

Garant

Machine tap for synchronised spindles HSS-E-PM IC / Form C, TiAlN, M: M12



Order data

Order number	135420 M12
GTIN	4045197508201
Item class	11H

Description

Version:

Sturdy version with right-hand helix and shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives**. The tap is guided by the synchronised spindle on the machine. Special **TiAlN-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

With **internal coolant supply** for maximum tool life.

Recommendation:

For **TOOLOX materials** we recommend **deviating from the DIN** data (see table) by drilling the tapping hole \varnothing **0.05 to 0.3mm** larger.

Note:

For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank \varnothing D_s: 12 mm

Shank square □: 9 mm

Tapping hole \varnothing : 10.2 mm

Technical description

Thread pitch	1.75 mm
Thread \varnothing	12 mm
Number of cutting edges Z	4

Number of clamping slots	4
Tapping hole Ø	10.2 mm
Standard	Manufacturer's standard
Shank Ø D _s	12 mm
Overall length L	110 mm
Shank square □	9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	30 mm
Thread type	M
Thread size	M12
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	DIN 1835 B to h6
Through-coolant	yes
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 750 N/mm ²	suitable	32 m/min	P

Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
TOOLOX 33	suitable	7 m/min	H
TOOLOX 44	suitable only under restricted conditions	3 m/min	H
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		