

**Garant**
**Machine tap HSS-E-PM, TiN, M: M12**

**Order data**

Order number	135378 M12
GTIN	4045197647986
Item class	11H

**Description**
**Version:**

For use with **emulsion** (fat content minimum 8%).

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**Recommendation:**

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

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2 6H

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank  $\varnothing$  D<sub>s</sub>: 12 mm

Shank square □: 9 mm

Tapping hole  $\varnothing$ : 10.2 mm

**Technical description**

Thread $\varnothing$	12 mm
Number of clamping slots	3
Thread pitch	1.75 mm
Number of cutting edges Z	3
Tapping hole $\varnothing$	10.2 mm
Standard	DIN 371
Shank $\varnothing$ D <sub>s</sub>	12 mm

Overall length L	110 mm
Shank square □	9 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Thread depth	36 mm
Thread type	M
Thread size	M12
Coating	TiN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	25°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 1100 N/mm <sup>2</sup>	suitable	9 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	7 m/min	P
TOOLOX 33	suitable	6 m/min	H
TOOLOX 44	suitable	3 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable	2 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	9 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	7 m/min	M
CuZn	suitable only under restricted conditions	7 m/min	N
Oil	suitable		
wet maximum	suitable		