



Machine taps HSS-E Form C, vaporised, M: M12



Order data

Order number	135855 M12
GTIN	4045197649584
Item class	12H

Description

Version:

Form C (2–3 turns lead chamfer).

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2 6H

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank $\varnothing D_s$: 9 mm

Shank square \square : 7 mm

Tapping hole \varnothing : 10.2 mm

Technical description

Thread pitch	1.75 mm
Number of clamping slots	3
Tapping hole \varnothing	10.2 mm
Number of cutting edges Z	3
Thread \varnothing	12 mm
Standard	DIN 376
Shank $\varnothing D_s$	9 mm
Overall length L	110 mm
Shank square \square	7 mm

Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	36 mm
Thread type	M
Thread size	M12
Coating	vaporised
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	11 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 750 N/mm ²	suitable	8 m/min	P
Steel < 900 N/mm ²	suitable	7 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm ²	suitable	4 m/min	M

CuZn	suitable only under restricted conditions	12 m/min	N
Uni	suitable		
Oil	suitable		