

Garant
Machine tap for synchronised spindles HSS-E-PM, DLC, M: M12

Order data

Order number	131125 M12
GTIN	4045197648518
Item class	11H

Description
Version:

Sturdy design with spiral point and shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives**. Guidance is provided by the synchronising spindle of the machine.

With the latest generation of special **DLC coating sp²** for optimum tool life.

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

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 Ø D_s: 12 mm

Shank square □: 9 mm

Tapping hole Ø: 10.2 mm

Technical description

Thread Ø	12 mm
Thread pitch	1.75 mm
Number of clamping slots	3
Tapping hole Ø	10.2 mm

Number of cutting edges Z	3
Standard	Manufacturer's standard
Shank $\varnothing D_s$	12 mm
Overall length L	110 mm
Shank square \square	9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	30 mm
Thread type	M
Thread size	M12
Coating	DLC
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	DIN 1835 B with h6
Through-coolant	no
Application for type of drilling	up to 2.5xD for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	yellow
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium	suitable	30 m/min	N
Aluminium (short chipping)	suitable	30 m/min	N
Alu > 10% Si	suitable	25 m/min	N

PMMA acrylic	suitable	25 m/min	N
AFRP aramid	suitable only under restricted conditions	5 m/min	N
PA 66 GF30	suitable only under restricted conditions	15 m/min	N
PTFE CF25	suitable	25 m/min	N
Cu	suitable	55 m/min	N
CuZn	suitable	35 m/min	N
GRP	suitable only under restricted conditions	6 m/min	N
CRP	suitable only under restricted conditions	4 m/min	N
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		