

**Garant**
**Machine tap HSS-E, TiCN, MF: 12X1**

**Order data**

Order number	136270 12X1
GTIN	4045197079367
Item class	11H

**Description**
**Version:**

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

**Recommendation:**

For **TOOLOX 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: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole  $\varnothing$ : 11 mm

**Technical description**

Number of cutting edges Z	4
Thread $\varnothing$	12 mm
Number of clamping slots	4
Thread pitch	1 mm
Tapping hole $\varnothing$	11 mm
Shank $\varnothing$ D <sub>s</sub>	9 mm
Overall length L	100 mm

Shank square <input type="checkbox"/>	7 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Standard	DIN 374
Thread depth	24 mm
Thread type	MF
Thread size	M12×1
Coating	TiCN
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 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 < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	19 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	19 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	9 m/min	P
TOOLOX 33	suitable	3 m/min	H
Oil	suitable		

wet maximum

suitable