

**Garant****Machine tap HSS-E-PM, vaporised, MF: 12X1,5****Order data**

Order number	137055 12X1,5
GTIN	4045197272409
Item class	11H

**Description****Version:**

Surface vaporised for reduced edge build-up.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 100 mm

Shank Ø D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole Ø: 10.5 mm

**Technical description**

Number of cutting edges Z	3
Thread pitch	1.5 mm
Number of clamping slots	3
Thread Ø	12 mm
Tapping hole Ø	10.5 mm
Shank Ø D <sub>s</sub>	9 mm
Overall length L	100 mm
Shank square □	7 mm
Tolerance class	ISO 2X 6HX

Tool material	HSS E PM
Standard	DIN 374
Thread depth	24 mm
Thread type	MF
Thread size	M12×1.5
Coating	vaporised
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	20 °
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	pink
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	18 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	9 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	3 m/min	P
Ti > 850 N/mm <sup>2</sup>	suitable	4 m/min	S
Oil	suitable		
wet maximum	suitable		