

Garant
Machine tap for synchronised spindles HSS-E-PM internal cooling, TiAlN, M: M12

Order data

Order number	132070 M12
GTIN	4045197507747
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**. The tap is controlled by the synchronising spindle of the machine.

Special **TiAlN coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

With internal coolant supply for maximum tool life.

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.

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 \varnothing D_s: 12 mm

Shank square □: 9 mm

Tapping hole \varnothing : 10.2 mm

Technical description

Number of clamping slots	4
Thread \varnothing	12 mm

Thread pitch	1.75 mm
Number of cutting edges Z	4
Tapping hole Ø	10.2 mm
Standard	Manufacturer's standard
Shank Ø D _s	12 mm
Overall length L	110 mm
Shank square □	9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	30 mm
Thread type	M
Thread size	M12
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	B
Shank	DIN 1835 B with h6
Through-coolant	yes
Application for type of drilling	up to 2.5×D for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	red
Type of product	Tap