

**Garant**
**Machine tap HSS-E-PM, TiCN, M: M12**

**Order data**

Order number	132055 M12
GTIN	4045197648730
Item class	11H

**Description**
**Version:**
**Sturdy version.**
**Recommendation:**

For **very hard steels, TOOLOX** and **HARDOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole  $\varnothing$  **0.05** to **0.3 mm** larger. For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Thread type: M

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 110 mm

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

Shank square □: 7 mm

 Tapping hole  $\varnothing$ : 10.2 mm

**Technical description**

Thread $\varnothing$	12 mm
Thread pitch	1.75 mm
Number of clamping slots	3
Tapping hole $\varnothing$	10.2 mm
Number of cutting edges Z	3
Standard	DIN 376

Shank $\varnothing D_s$	9 mm
Overall length L	110 mm
Shank square $\square$	7 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	18 mm
Thread type	M
Thread size	M12
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5xD for through holes
Application for type of drilling	up to 1.5xD 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	$V_c$	ISO code
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 55 HRC	suitable	2 m/min	H
TOOLOX 33	suitable	4 m/min	H
TOOLOX 44	suitable	3 m/min	H

HARDOX 500 < 1600 N/ mm <sup>2</sup>	suitable	2 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	15 m/min	N
Oil	suitable		