

Garant
Machine tap, uncoated, UNF: 1-12

Order data

Order number	138000 1-12
GTIN	4045197080400
Item class	11H

Description
Version:
Sturdy design, with 20° right-hand chip flutes. HSS
Application:
For UNF uniform fine threads ASME – B1.1.
Technical description

Thread Ø	25.4 mm
Number of clamping slots	4
Number of cutting edges Z	4
Threads per inch	12
Tapping hole Ø	23.25 mm
Tool material	HSS
Standard	DIN 374
Shank Ø D _s	20 mm
Overall length L	140 mm
Shank square □	16 mm
Thread depth	50.8 mm
Thread pitch	2.117 mm
Thread type	UNF

Thread size	1-12 UNF
Coating	uncoated
Flank angle	60 degrees
Tolerance class	2B
Taper lead form	C
Helix angle	20 degrees
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 conventional machining
Colour ring	without
Type of product	Tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P
Oil	suitable		
wet maximum	suitable only under restricted conditions		