

**Garant**
**Machine tap Form D, vaporised, M: M12**

**Order data**

Order number	132155 M12
GTIN	4045197446084
Item class	11H

**Description**
**Version:**

Particularly sturdy design.

**Taper lead form D with 15° left-hand spiral.**

**Callout:**

Oil groove

Guide thread

Lead-in

Spiral point

**Advantage:**

Special geometry enables **higher cutting speeds and long tool life in stainless steel.**

Thread type: M

Tool material: HSS E

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank  $\varnothing D_s$ : 9 mm

Shank square  $\square$ : 7 mm

Tapping hole  $\varnothing$ : 10.2 mm

**Technical description**

Number of clamping slots	3
Number of cutting edges Z	3
Thread $\varnothing$	12 mm

Thread pitch	1.75 mm
Tapping hole $\varnothing$	10.2 mm
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
Thread depth	36 mm
Thread type	M
Thread size	M12
Coating	vaporised
Flank angle	60°
Thread standard	DIN 13
Taper lead form	D
Helix angle	15°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	blue
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 <sup>2</sup>	suitable	15 m/min	P

Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	13 m/min	M
CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		