

**Garant****Machine tap Form B, vaporised, M: M12****Order data**

|              |               |
|--------------|---------------|
| Order number | 132150 M12    |
| GTIN         | 4045197071194 |
| Item class   | 11H           |

**Description****Version:**

Particularly sturdy design.

**Guide section with oil grooves**, but without chip flutes. **Lead chamfer form B, with strong spiral point**. Size M2.6 to the old DIN profile.

**Advantage:**

**Optimum self-guidance** and **no recutting** when reversed.

**Technical description**

|                            |            |
|----------------------------|------------|
| Number of cutting edges Z  | 3          |
| Number of clamping slots   | 3          |
| Tapping hole $\varnothing$ | 10.2 mm    |
| Thread pitch               | 1.75 mm    |
| Thread $\varnothing$       | 12 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      |

## Data sheet

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread type                      | M                                 |
| Thread size                      | M12                               |
| Coating                          | vaporised                         |
| Flank angle                      | 60 degrees                        |
| Thread standard                  | DIN 13                            |
| Taper lead form                  | B                                 |
| 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 <sub>c</sub> | 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                                  | 6 m/min        | M        |
| CuZn                          | suitable only under restricted conditions | 13 m/min       | N        |
| Oil                           | suitable                                  |                |          |
| wet maximum                   | suitable only under restricted conditions |                |          |