

Garant
Fluteless machine tap without oil grooves HSS-E-PM 6GX, TiN, M: M12

Order data

Order number	139135 M12
GTIN	4045197508836
Item class	11H

Description
Version:

DIN 2174 (\approx **DIN 371** \leq M10; \approx **DIN 376** \geq M12).

The **innovative polygon form** permits a wide application spectrum. The **multi-function layer structure** achieves **maximum service life** even in **high-tensile materials**.

Tolerance class: ISO 3X / 6GX = **Oversize 0.02 – 0.04 mm**.

Application:

For components which are **galvanised after threading** or which shrink slightly when hardened.

Tolerance class: ISO 3X 6GX

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank \varnothing D_s: 9 mm

Shank square □: 7 mm

Tapping hole \varnothing guide value: 11.2 mm

Technical description

Thread \varnothing	12 mm
Number of cutting edges Z	5
Number of clamping slots	5
Thread pitch	1.75 mm
Shank \varnothing D _s	9 mm
Shank square □	7 mm
Overall length L	110 mm

Tapping hole Ø guide value	11.2 mm
Tolerance class	ISO 3X 6GX
Thread depth	18 mm
Thread size	M12
Coating	TiN
Thread type	M
Flank angle	60°
Tool material	HSS E PM
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5×D for through holes
Application for type of drilling	up to 1.5×D for blind holes
Cutting direction	right-hand
Colour ring	green
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	42 m/min	N
Aluminium (short chipping)	suitable	42 m/min	N
Steel < 500 N/mm ²	suitable	37 m/min	P
Steel < 750 N/mm ²	suitable	32 m/min	P
Steel < 900 N/mm ²	suitable	27 m/min	P
Steel < 1100 N/mm ²	suitable	22 m/min	P

Steel < 1400 N/mm ²	suitable only under restricted conditions	17 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		