

Garant

GARANT Master Form Steel fluteless machine tap with oil grooves Left-hand thread HSS-E-PM Form C 6HX, TiAlN, M-LH: M12



Order data

Order number	139255 M12
GTIN	4062406383817
Item class	11I

Description

Version:

The latest generation of **high-performance fluteless taps**, specially developed for **use in steel materials**.

- **Optimised polygon geometry for a lower torque.**
- **Multi-layer HIPIMS coating for high wear resistance.**
- **HSS-E-PM substrate for exceptional process reliability.**

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

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 guide value: 11.2 mm

Technical description

Tapping hole \varnothing guide value	11.2 mm
Shank square \square	7 mm
Number of clamping slots	8
Number of cutting edges Z	8
Thread depth	36 mm
Thread pitch	1.75 mm

Overall length L	110 mm
Thread Ø	12 mm
Series	GARANT Master
Shank Ø D _s	9 mm
Tolerance class	ISO 2X 6HX
Thread size	M12 LH
Coating	TiAlN
Thread type	M-LH
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 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	without
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable	38 m/min	N
Steel < 500 N/mm ²	suitable	37 m/min	P
Steel < 750 N/mm ²	suitable	35 m/min	P
Steel < 900 N/mm ²	suitable	27 m/min	P
Steel < 1100 N/mm ²	suitable	18 m/min	P

Steel < 1400 N/mm ²	suitable	12 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	7 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		