

Garant
Machine tap HSS-E, TiCN, M: M12

Order data

Order number	132450 M12
GTIN	4045197071699
Item class	11H

Description
Version:

Strong spiral point. Guide section with oil grooves, but without chip flutes.

Particularly suitable for **difficult to machine steels up to 850 N/mm²**.

For use with **emulsion** (fat content minimum 8%).

Advantage:

Particularly strong, optimum self-guidance and no recutting when reversed.

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 Ø D_s: 9 mm

Shank square □: 7 mm

Tapping hole Ø: 10.2 mm

Technical description

Thread pitch	1.75 mm
Number of clamping slots	3
Thread Ø	12 mm
Tapping hole Ø	10.2 mm
Number of cutting edges Z	3
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	24 mm
Thread type	M
Thread size	M12
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	pink
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	16 m/min	N
Steel < 500 N/mm ²	suitable	20 m/min	P
Steel < 750 N/mm ²	suitable	19 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	19 m/min	P
INOX < 900 N/mm ²	suitable	8 m/min	M
INOX > 900 N/mm ²	suitable	6 m/min	M

Ti > 850 N/mm ²	suitable	4 m/min	S
Inconel	suitable	2 m/min	S
CuZn	suitable only under restricted conditions	16 m/min	N
Oil	suitable		
wet maximum	suitable		