

Garant**Machine tap for synchronised spindles HSS-E-PM Form E, TiAlN, M: M12****Order data**

Order number	132560 M12
GTIN	4045197585363
Item class	11H

Description**Version:**

Sturdy design with shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives**. The tap is controlled by the synchronising spindle of the machine. **Special TiAlN coating for optimum tool life.** For use with **emulsion** (fat content minimum 8 %).

Also outstandingly suitable for **bainite cast iron (ADI)**.

Note:

For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures maximum process reliability.

Technical description

Thread pitch	1.75 mm
Number of cutting edges Z	4
Thread Ø	12 mm
Number of clamping slots	4
Tapping hole Ø	10.2 mm
Standard	Manufacturer's standard
Shank Ø D _s	12 mm
Overall length L	110 mm
Shank square □	9 mm
Tolerance class	ISO 2X 6HX

Data sheet

Tool material	HSS E PM
Thread depth	30 mm
Thread type	M
Thread size	M12
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	E
Shank	DIN 1835 B with h6
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2.5×D for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	white
Type of product	Tap

User data

	Suitability	V _c	ISO code
GJS, ADI > 800N/mm ²	suitable	20 m/min	K
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		
Air	suitable only under restricted conditions		