

Garant
GARANT Master Tap machine tap HSS-E-PM Form B 6H+0.1, ALTiX, M: M12

Order data

Order number	132735 M12
GTIN	4062406719005
Item class	111

Description
Version:
Tolerance class: ISO2/6H + 0.1
Universal taps, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

Application:

For components which are galvanised or shrink slightly when hardened.

Recommendation:

 We recommend increasing the size of the tapping hole \varnothing by the tolerance allowance.

Thread type: M

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2 6H + 0.1

Thread pitch: 1.75 mm

Overall length L: 110 mm

 Shank \varnothing D_s: 9 mm

Shank square □: 7 mm

 Tapping hole \varnothing : 10.2 mm

Technical description

Number of cutting edges Z	3
Thread \varnothing	12 mm
Tapping hole \varnothing	10.2 mm
Tool material	HSS E PM

Thread pitch	1.75 mm
Number of clamping slots	3
Overall length L	110 mm
Shank $\varnothing D_s$	9 mm
Tolerance class	ISO 2 6H + 0.1
Thread type	M
Standard	DIN 376
Thread depth	36 mm
Shank square \square	7 mm
Thread size	M12
Coating	AlTiX
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 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N

Steel < 500 N/mm ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		