

**Garant**
**GARANT Master Tap Alu machine tap extra long, DLC, M: M12**

**Order data**

Order number	131115 M12
GTIN	4067263830054
Item class	11I

**Description**
**Version:**

**High-performance tap**, specially developed for **aluminium and non-ferrous alloys**. **Extra-long clamping slots** and neck length for usable **thread depth up to 4×D**.

- **HSS-E-PM tool material for high cutting edge stability.**
- **Ultra-smooth DLC coating for wear resistance and preventing galling.**
- **Extra-long flute geometry.**

With extra long shank.

Thread type: M

Tool material: HSS E PM

Standard: Works standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 200 mm

Shank Ø D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole Ø: 10.2 mm

**Technical description**

Overall length L	200 mm
Shank square □	7 mm
Tool material	HSS E PM
Standard	Works standard
Thread Ø	12 mm
Number of cutting edges Z	3

Thread size	M12
Thread depth	48 mm
Number of clamping slots	3
Thread type	M
Thread pitch	1.75 mm
Shank $\varnothing D_s$	9 mm
Tolerance class	ISO 2X 6HX
Tapping hole $\varnothing$	10.2 mm
Coating	DLC
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 4×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	yellow
Series	Master Tap
Type of product	Taps

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable	35 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N
Alu > 10% Si	suitable	20 m/min	N
PMMA acrylic	suitable only under restricted conditions	20 m/min	N

PA 66	suitable only under restricted conditions	18 m/min	N
PEEK	suitable	18 m/min	N
Cu	suitable	18 m/min	N
CuZn	suitable	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		