

Garant
GARANT Master Tap Alu machine tap, DLC, MF: 12X1

Order data

Order number	136230 12X1
GTIN	4067263830597
Item class	11I

Description
Version:

High-performance tap, specially developed for **aluminium and non-ferrous alloys**. **Dynamic helical pitch** of the clamping slots ensure **optimum chip evacuation** and **process reliability**.

- **HSS-E-PM tool material – for high cutting edge stability.**
- **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up.**
- **Dynamic helical pitch of the flutes**
- **Short lead chamfer form E**

Technical description

Tool material	HSS E PM
Number of clamping slots	3
Thread pitch	1 mm
Tolerance class	ISO 2X 6HX
Number of cutting edges Z	3
Shank $\varnothing D_s$	9 mm
Shank square \square	7 mm
Standard	Works standard
Thread depth	36 mm
Overall length L	115 mm
Tapping hole \varnothing	11 mm

Thread Ø	12 mm
Thread size	M12×1
Thread type	M
Coating	DLC
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	E
Helix angle	45 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Helix angle characteristic	unequal spacing
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		