

**Garant**
**GARANT Master Tap Alu machine tap for wire thread inserts, DLC, EG-M: EG-M12**

**Order data**

Order number	138205 EG-M12
GTIN	4067263830757
Item class	11I

**Description**
**Version:**

**High-performance tap**, specially developed for **aluminium and non-ferrous alloys**. **Dynamic helical pitch** of the flutes ensures **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.**

**Application:**

For production of EG mounting thread according to metric ISO thread **DIN 8140** for **STI wire thread inserts** (Screw Thread Insert).

**Note:**

Please be sure to observe the correct **tapping hole Ø (see table)**!

**Technical description**

Standard	Works standard
Tapping hole Ø	12.5 mm
Tolerance class	6HX mod.
Shank square □	9 mm
Number of clamping slots	3
Thread Ø	12 mm
Tool material	HSS E PM

Overall length L	120 mm
Number of cutting edges Z	3
Thread pitch	1.75 mm
Thread size	M12
Thread depth	36 mm
Shank $\varnothing D_s$	11 mm
Helix angle characteristic	unequal spacing
Coating	DLC
Thread type	EG-M
Flank angle	60 degrees
Taper lead form	E
Helix angle	45 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3xD for blind 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		