

Garant
Machine tap HSS-E-PM, TiN / vaporised, MF: 12X1,5

Order data

| | |
|--------------|---------------|
| Order number | 136290 12X1,5 |
| GTIN | 4045197883568 |
| Item class | 11H |

Description
Version:

With special TiN coating and vaporised cutting surfaces.

For controlled swarf evacuation and avoidance of clogging.

Especially suitable for problem materials.

For use with **emulsion** (fat content minimum 8%).

Recommendation:

For **TOOLOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05 to 0.3 mm** larger.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 100 mm

Shank \varnothing D_s: 9 mm

Shank square □: 7 mm

Tapping hole \varnothing : 10.5 mm

Technical description

| | |
|---------------------------|----------|
| Overall length L | 100 mm |
| Standard | DIN 374 |
| Thread pitch | 1.5 mm |
| Tool material | HSS E PM |
| Number of cutting edges Z | 4 |

| | |
|----------------------------------|-----------------------------------|
| Tapping hole Ø | 10.5 mm |
| Shank square □ | 7 mm |
| Number of clamping slots | 4 |
| Thread Ø | 12 mm |
| Shank Ø D _s | 9 mm |
| Tolerance class | ISO 2 6H |
| Thread depth | 36 mm |
| Thread type | MF |
| Thread size | M12×1.5 |
| Coating | TiN / vaporised |
| Flank angle | 60 ° |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 40 ° |
| 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 |
| Colour ring | red |
| Type of product | Tap |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm ² | suitable | 27 m/min | P |
| Steel < 750 N/mm ² | suitable | 23 m/min | P |
| Steel < 900 N/mm ² | suitable | 23 m/min | P |
| Steel < 1100 N/mm ² | suitable | 13 m/min | P |
| Steel < 1400 N/mm ² | suitable | 10 m/min | P |

| | | | |
|----------------------------|----------|----------|---|
| TOOLOX 33 | suitable | 12 m/min | H |
| Ti > 850 N/mm ² | suitable | 5 m/min | S |
| Oil | suitable | | |
| wet maximum | suitable | | |