

Garant
GARANT Master Tap machine tap HSS-E-PM extra long Form B 6HX, AlTiX, M: M12

Order data

| | |
|--------------|---------------|
| Order number | 131770 M12 |
| GTIN | 4045197901354 |
| Item class | 11I |

Description
Version:

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.**

Shank to DIN 376.

Advantage:

Designed for tapping threads where access is difficult.

Technical description

| Standard | Manufacturer's standard |
|---------------------------|-------------------------|
| Thread depth | 36 mm |
| Tolerance class | ISO 2X 6HX |
| Tapping hole Ø | 10.2 mm |
| Thread Ø | 12 mm |
| Number of clamping slots | 3 |
| Thread pitch | 1.75 mm |
| Number of cutting edges Z | 3 |
| Thread type | M |
| Shank square □ | 7 mm |

| | |
|----------------------------------|-----------------------------------|
| Thread size | M12 |
| Overall length L | 200 mm |
| Shank $\varnothing D_s$ | 9 mm |
| Tool material | HSS E PM |
| Coating | AlTiX |
| Flank angle | 60 degrees |
| 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 | 24 m/min | N |
| Aluminium (short chipping) | suitable | 28 m/min | N |
| Alu > 10% Si | suitable | 16 m/min | N |
| Steel < 500 N/mm ² | suitable | 24 m/min | P |
| Steel < 750 N/mm ² | suitable | 24 m/min | P |
| Steel < 900 N/mm ² | suitable | 20 m/min | P |
| Steel < 1100 N/mm ² | suitable | 10 m/min | P |
| Steel < 1400 N/mm ² | suitable | 6 m/min | P |
| INOX < 900 N/mm ² | suitable | 8 m/min | M |

| | | | |
|------------------------------|----------|----------|---|
| INOX > 900 N/mm ² | suitable | 6 m/min | M |
| GG(G) | suitable | 16 m/min | K |
| CuZn | suitable | 16 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |