

**Garant**
**GARANT Master Tap machine tap IC / Form B 6HX, AlTiX, M: M12**

**Order data**

Order number	132723 M12
GTIN	4045197900333
Item class	111

**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.**

**With internal coolant feed.**

Thread type: M

Tool material: HSS E PM

Standard: DIN 376

Tolerance class: ISO 2X 6HX

Thread pitch: 1.75 mm

Overall length L: 110 mm

Shank  $\varnothing D_s$ : 9 mm

Shank square  $\square$ : 7 mm

Tapping hole  $\varnothing$ : 10.2 mm

**Technical description**

Tool material	HSS E PM
Overall length L	110 mm
Thread pitch	1.75 mm
Tolerance class	ISO 2X 6HX
Shank $\varnothing D_s$	9 mm
Shank square $\square$	7 mm

Thread depth	36 mm
Number of clamping slots	3
Standard	DIN 376
Thread Ø	12 mm
Number of cutting edges Z	3
Tapping hole Ø	10.2 mm
Thread type	M
Thread size	M12
Coating	AlTiX
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	yes
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 <sub>c</sub>	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N
Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		