

**Garant**
**GARANT Master Tap machine tap Left-hand thread, AlTiX, MF-LH: 10X1,25**

**Order data**

Order number	137190 10X1,25
GTIN	4045197901408
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.**

Thread type: MF-LH

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 7 mm

Shank square □: 5.5 mm

Tapping hole  $\varnothing$ : 8.8 mm

**Technical description**

Thread pitch	1.25 mm
Standard	DIN 374
Number of cutting edges Z	3
Thread size	M10×1.25 LH
Thread type	MF-LH
Tool material	HSS E PM
Shank square □	5.5 mm

Tapping hole Ø	8.8 mm
Number of clamping slots	3
Thread Ø	10 mm
Shank Ø D <sub>s</sub>	7 mm
Tolerance class	ISO 2X 6HX
Overall length L	100 mm
Thread depth	25 mm
Coating	AlTiX
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 2.5×D for blind holes
Cutting direction	left-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		