

**Garant****GARANT Master Tap machine tap Form B, AlTiX, M: M12****Order data**

|              |               |
|--------------|---------------|
| Order number | 132721 M12    |
| GTIN         | 4045197900432 |
| 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.**

Corresponds to **ISO 2X/6HX**.

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 Ø D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole Ø: 10.2 mm

**Technical description**

|                 |            |
|-----------------|------------|
| Thread pitch    | 1.75 mm    |
| Tolerance class | ISO 2X 6HX |
| Thread Ø        | 12 mm      |
| Standard        | DIN 376    |
| Tool material   | HSS E PM   |
| Shank square □  | 7 mm       |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Tapping hole Ø                   | 10.2 mm                           |
| Shank Ø D <sub>s</sub>           | 9 mm                              |
| Number of clamping slots         | 3                                 |
| Number of cutting edges Z        | 3                                 |
| Overall length L                 | 110 mm                            |
| Thread depth                     | 36 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                  | 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 <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 |          |   |