

**Garant**
**Machine tap for synchronised spindles HSS-E-PM Form E, TiAlN, M: 12X1,25**

**Order data**

Order number	137183 12X1,25
GTIN	4045197705389
Item class	11H

**Description**
**Version:**

**Sturdy version with right-hand helix and shank to DIN 1835-B.** Special geometry for **general-purpose use** on machines with **synchronised spindle drive**. The tap is controlled by the synchronising spindle of the machine. Special **TiAlN-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

**Form E** (lead chamfer: 1.5 - 2 turns) for the deepest possible thread depths.

**Note:**

**For use on synchronised spindles, the GARANT quick-change tapping chuck No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.

Thread type: MF

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 100 mm

Shank  $\varnothing$  D<sub>s</sub>: 12 mm

Shank square □: 9 mm

Tapping hole  $\varnothing$ : 10.8 mm

**Technical description**

Thread pitch	1.25 mm
Thread $\varnothing$	12 mm
Number of cutting edges Z	4
Tapping hole $\varnothing$	10.8 mm
Number of clamping slots	4

Shank $\varnothing D_s$	12 mm
Overall length L	100 mm
Shank square $\square$	9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Standard	Manufacturer's standard
Thread depth	36 mm
Thread type	MF
Thread size	M12 $\times$ 1.25
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	E
Helix angle	40 degrees
Shank	DIN 1835 B with h6
Through-coolant	no
Application for type of drilling	up to 3 $\times$ D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	green
Type of product	Tap