

**Value pack machine tap Form B****Order data**

Order number	GG1645 M12
GTIN	4045197734921
Item class	GGN

Description**Version:****Spiral point with oil grooves.****Guide section with oil grooves, but without chip flutes.****Same as No. 132645. Tolerance class: ISO 2 6H****Technical description**

Thread Ø	12 mm
Tool material	HSS E
Tapping hole Ø	10.2 mm
Number of clamping slots	3
Shank square □	7 mm
Tolerance class	ISO 2 6H
Shank Ø D _s	9 mm
Thread pitch	1.75 mm
Number of cutting edges Z	3
Overall length L	110 mm
Standard	DIN 376

Data sheet

Thread depth	36 mm
Thread type	M
Thread size	M12
Contents	10
Coating	vaporised
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
Type of product	Tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	11 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 750 N/mm ²	suitable	8 m/min	P
Steel < 900 N/mm ²	suitable	7 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm ²	suitable	4 m/min	M
CuZn	suitable only under restricted conditions	12 m/min	N
Uni	suitable		

Oil

suitable

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/GG1645-M12>