



## Fluteless machine tap with oil grooves HSS-E Form C 6GX, TiAlN, M: M6



### Order data

Order number	139192 M6
GTIN	4045197446862
Item class	12H

### Description

#### Version:

**DIN 2174** ( $\approx$  DIN 371  $\leq$  M10;  $\approx$  DIN 376  $\geq$  M12). With oil grooves; optimum lubrication effect even in deeper threads.

**Tolerance class:** ISO 3X / 6GX = **Oversize 0.02 – 0.04 mm.**

#### Application:

For components which are **galvanised after threading** or which shrink slightly when hardened.

Tolerance class: ISO 3X 6GX

Thread pitch: 1 mm

Overall length L: 80 mm

Shank  $\varnothing D_s$ : 6 mm

Shank square  $\square$ : 4.9 mm

Tapping hole  $\varnothing$  guide value: 5.55 mm

### Technical description

Thread $\varnothing$	6 mm
Thread pitch	1 mm
Number of cutting edges Z	5
Number of clamping slots	5
Shank $\varnothing D_s$	6 mm
Shank square $\square$	4.9 mm
Overall length L	80 mm
Tapping hole $\varnothing$ guide value	5.55 mm

Tolerance class	ISO 3X 6GX
Thread depth	18 mm
Thread size	M6
Coating	TiAlN
Thread type	M
Flank angle	60 °
Tool material	HSS E
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	green
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	23 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	11 m/min	M
CuZn	suitable only under restricted conditions	12 m/min	N
Uni	suitable		

Oil	suitable
wet maximum	suitable