



Fluteless machine tap with oil grooves HSS-E Form C 6GX, TiAlN, M: M10



Order data

Order number	139192 M10
GTIN	4045197446886
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: 1.5 mm

Overall length L: 100 mm

Shank $\varnothing D_s$: 10 mm

Shank square \square : 8 mm

Tapping hole \varnothing guide value: 9.35 mm

Technical description

Thread \varnothing	10 mm
Number of clamping slots	3
Thread pitch	1.5 mm
Number of cutting edges Z	3
Shank $\varnothing D_s$	10 mm
Shank square \square	8 mm
Overall length L	100 mm
Tapping hole \varnothing guide value	9.35 mm

Tolerance class	ISO 3X 6GX
Thread depth	30 mm
Thread size	M10
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 _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	23 m/min	N
Steel < 500 N/mm ²	suitable	23 m/min	P
Steel < 750 N/mm ²	suitable	22 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
INOX < 900 N/mm ²	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