



Fluteless machine tap with oil grooves HSS-E Form C 6GX, TiAlN, M: M4



Order data

Order number	139192 M4
GTIN	4045197446848
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: 0.7 mm

Overall length L: 63 mm

Shank \varnothing D_s: 4.5 mm

Shank square \square : 3.4 mm

Tapping hole \varnothing guide value: 3.7 mm

Technical description

Thread pitch	0.7 mm
Number of cutting edges Z	5
Number of clamping slots	5
Thread \varnothing	4 mm
Shank \varnothing D _s	4.5 mm
Shank square \square	3.4 mm
Overall length L	63 mm
Tapping hole \varnothing guide value	3.7 mm

Tolerance class	ISO 3X 6GX
Thread depth	12 mm
Thread size	M4
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