

**Machine tap HSS-E Form B, uncoated, MF: 14X1,25****Order data**

|              |                |
|--------------|----------------|
| Order number | 132840 14X1,25 |
| GTIN         | 4045197532527  |
| Item class   | 12H            |

**Description**

**Version:**  
**With spiral point.**

**Technical description**

|                           |          |
|---------------------------|----------|
| Thread Ø                  | 14 mm    |
| Tapping hole Ø            | 12.8 mm  |
| Number of cutting edges Z | 4        |
| Number of clamping slots  | 4        |
| Thread pitch              | 1.25 mm  |
| Shank Ø D <sub>s</sub>    | 11 mm    |
| Overall length L          | 100 mm   |
| Shank square □            | 9 mm     |
| Tolerance class           | ISO 2 6H |
| Tool material             | HSS E    |
| Standard                  | DIN 374  |
| Thread depth              | 42 mm    |
| Thread type               | MF       |
| Thread size               | M14×1.25 |
| Coating                   | uncoated |

## Data sheet

|                                  |                                        |
|----------------------------------|----------------------------------------|
| 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 conventional machining |
| Colour ring                      | without                                |
| Type of product                  | Tap                                    |

## User data

|                               | Suitability                               | V <sub>c</sub> | ISO code |
|-------------------------------|-------------------------------------------|----------------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 13 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 15 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 15 m/min       | P        |
| Oil                           | suitable                                  |                |          |
| wet maximum                   | suitable only under restricted conditions |                |          |