



Fluteless machine tap with oil grooves HSS-E, TiAlN, MF: 12X1,5



Order data

Order number	139372 12X1,5
GTIN	4045197447043
Item class	12H

Description

Version:

Satisfies DIN 374.

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 100 mm

Shank $\varnothing D_s$: 9 mm

Shank square \square : 7 mm

Tapping hole \varnothing guide value: 11.35 mm

Technical description

Number of cutting edges Z	3
Number of clamping slots	3
Thread \varnothing	12 mm
Shank $\varnothing D_s$	9 mm
Shank square \square	7 mm
Overall length L	100 mm
Tapping hole \varnothing guide value	11.35 mm
Thread depth	36 mm
Thread pitch	1.5 mm
Tolerance class	ISO 2X 6HX
Thread size	M12x1.5

Coating	TiAlN
Thread type	MF
Flank angle	60°
Tool material	HSS E
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		

