



Fluteless machine tap with oil grooves HSS-E, TiAlN, MF: 18X1,5



Order data

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|--------------|---------------|
| Order number | 139372 18X1,5 |
| GTIN | 4045197447067 |
| Item class | 12H |

Description

Version:

Satisfies DIN 374.

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 110 mm

Shank $\varnothing D_s$: 14 mm

Shank square \square : 11 mm

Tapping hole \varnothing guide value: 17.35 mm

Technical description

| | |
|--|------------|
| Number of clamping slots | 3 |
| Number of cutting edges Z | 3 |
| Thread \varnothing | 18 mm |
| Shank $\varnothing D_s$ | 14 mm |
| Shank square \square | 11 mm |
| Overall length L | 110 mm |
| Tapping hole \varnothing guide value | 17.35 mm |
| Thread depth | 54 mm |
| Thread pitch | 1.5 mm |
| Tolerance class | ISO 2X 6HX |
| Thread size | M18x1.5 |

| | |
|----------------------------------|-----------------------------|
| 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 | | |

