



## Fluteless machine tap with oil grooves HSS-E, TiAlN, MF: 20X1,5



### Order data

Order number	139372 20X1,5
GTIN	4045197447074
Item class	12H

### Description

#### Version:

#### Satisfies DIN 374.

Tolerance class: ISO 2X 6HX

Thread pitch: 1.5 mm

Overall length L: 125 mm

Shank  $\varnothing D_s$ : 16 mm

Shank square  $\square$ : 12 mm

Tapping hole  $\varnothing$  guide value: 19.35 mm

### Technical description

Number of cutting edges Z	7
Thread $\varnothing$	20 mm
Number of clamping slots	7
Shank $\varnothing D_s$	16 mm
Shank square $\square$	12 mm
Overall length L	125 mm
Tapping hole $\varnothing$ guide value	19.35 mm
Thread depth	60 mm
Thread pitch	1.5 mm
Tolerance class	ISO 2X 6HX
Thread size	M20x1.5

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 <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	23 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	23 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
INOX < 900 N/mm <sup>2</sup>	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		

