



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



Order data

Order number	139372 12X1
GTIN	4045197447036
Item class	12H

Description

Version:

Satisfies DIN 374.

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 100 mm

Shank $\varnothing D_s$: 9 mm

Shank square \square : 7 mm

Tapping hole \varnothing guide value: 11.55 mm

Technical description

Thread \varnothing	12 mm
Number of cutting edges Z	3
Number of clamping slots	3
Shank $\varnothing D_s$	9 mm
Shank square \square	7 mm
Overall length L	100 mm
Tapping hole \varnothing guide value	11.55 mm
Thread depth	36 mm
Thread pitch	1 mm
Tolerance class	ISO 2X 6HX
Thread size	M12x1

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		

