

Machine tap, vaporised, M: M4



Order data

Order number	135150 M4
GTIN	4045197076113
Item class	11H

Description

Version:

With conically offset guide thread (3 - 4) full threads, then tapered towards the rear). Particularly for recessed blind hole threads where the swarf generated remains in the tap flutes.

Advantage:

The tapered guide section allows the tap to be reversed with greatly reduced risk of chips jamming and causing damage to the tap.

Thread type: M Tool material: HSS E Standard: DIN 371 Tolerance class: ISO 2 6H

Thread pitch: 0.7 mm

Overall length L: 63 mm

Shank Ø D_s: 4.5 mm

Shank square \Pi: 3.4 mm

Tapping hole Ø: 3.3 mm

Technical description

Thread Ø	4 mm
Thread pitch	0.7 mm
Number of cutting edges Z	3
Tapping hole Ø	3.3 mm
Number of clamping slots	3
Standard	DIN 371

Shank Ø D, 4.5 mm Overall length L 63 mm Shank square □ 3.4 mm Tolerance class ISO 2 6H Tool material HSS E Thread depth 12 mm Thread type M Thread size M4 Coating vaporised Flank angle 60 ° Thread standard DIN 13 Taper lead form C Helix angle 40 ° Shank Plain shank with h9 Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction right-hand Type of threading tool Machine tap for conventional machining Colour ring without				
Shank square □ 3.4 mm Tolerance class ISO 2 6H Tool material HSS E Thread depth 12 mm Thread type M Thread size M4 Coating vaporised Flank angle 60 ° Thread standard DIN 13 Taper lead form C Helix angle 40 ° Shank Plain shank with h9 Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction Type of threading tool Machine tap for conventional machining	Shank Ø D _s	4.5 mm		
Tolerance class Tool material Tool material HSS E Thread depth 12 mm Thread type M Thread size M4 Coating Vaporised Flank angle Flank angle Thread standard DIN 13 Taper lead form C Helix angle Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction Type of threading tool ISO 2 6H Iso S M Iso Yaporised Vaporised Vaporised Vaporised Plain shank with h9 Ino Application for type of drilling Up to 3×D for blind holes Cutting direction Type of threading tool Machine tap for conventional machining	Overall length L	63 mm		
Tool material HSS E Thread depth 12 mm Thread type M Thread size M4 Coating vaporised Flank angle 60 ° Thread standard DIN 13 Taper lead form C Helix angle 40 ° Shank Plain shank with h9 Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction S Type of threading tool R Thread standard Type of drilling Machine tap for conventional machining	Shank square □	3.4 mm		
Thread depth Thread type M Thread size M4 Coating vaporised Flank angle Flank angle Thread standard Thread form C Helix angle Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction Type of threading tool Thread size M4 AM AM A B B A B A A B A A A A A	Tolerance class	ISO 2 6H		
Thread type M Thread size M4 Coating Vaporised Flank angle Flank angle Thread standard DIN 13 Taper lead form C Helix angle Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction Type of threading tool M Machine tap for conventional machining	Tool material	HSS E		
Thread size Coating Vaporised Flank angle 60 ° Thread standard DIN 13 Taper lead form C Helix angle Shank Plain shank with h9 Through-coolant no Application for type of drilling Cutting direction Type of threading tool Machine tap for conventional machining	Thread depth	12 mm		
Coating vaporised Flank angle 60 ° Thread standard DIN 13 Taper lead form C Helix angle 40 ° Shank Plain shank with h9 Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction right-hand Type of threading tool Machine tap for conventional machining	Thread type	М		
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Thread standard Taper lead form C Helix angle Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction Type of threading tool DIN 13 C d Machine tap for conventional machining	Coating	vaporised		
Taper lead form C Helix angle 40° Shank Plain shank with h9 Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction Type of threading tool Machine tap for conventional machining	Flank angle	60 °		
Helix angle Shank Plain shank with h9 Through-coolant Application for type of drilling Cutting direction Type of threading tool Application for type of drilling Machine tap for conventional machining	Thread standard	DIN 13		
Shank Plain shank with h9 Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction right-hand Type of threading tool Machine tap for conventional machining	Taper lead form	С		
Through-coolant no Application for type of drilling up to 3×D for blind holes Cutting direction right-hand Type of threading tool Machine tap for conventional machining	Helix angle	40 °		
Application for type of drilling up to 3×D for blind holes Cutting direction right-hand Type of threading tool Machine tap for conventional machining	Shank	Plain shank with h9		
Cutting direction right-hand Type of threading tool Machine tap for conventional machining	Through-coolant	no		
Type of threading tool Machine tap for conventional machining	Application for type of drilling	up to 3×D for blind holes		
conventional machining	Cutting direction	right-hand		
Colour ring without	Type of threading tool			
	Colour ring	without		
Type of product Tap	Type of product	Тар		

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	15 m/min	Р
Steel < 750 N/mm ²	suitable	15 m/min	Р
Steel < 900 N/mm ²	suitable	15 m/min	Р

GG(G)	suitable only under restricted conditions	9 m/min	K
CuZn	suitable only under restricted conditions	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		