

**Machine tap, uncoated, UNC: 6-32****Order data**

|              |               |
|--------------|---------------|
| Order number | 137862 6-32   |
| GTIN         | 4045197594884 |
| Item class   | 12H           |

**Description****Version:****Sturdy design, with right-hand chip flutes. HSS-E****Application:****For UNC uniform coarse threads ASME – B1.1.****Technical description**

|                           |          |
|---------------------------|----------|
| Thread pitch              | 0.794 mm |
| Number of clamping slots  | 3        |
| Threads per inch          | 32       |
| Number of cutting edges Z | 3        |
| Thread Ø                  | 3.51 mm  |
| Tapping hole Ø            | 2.85 mm  |
| Standard                  | DIN 371  |
| Tool material             | HSS E    |
| Shank Ø D <sub>s</sub>    | 4 mm     |
| Overall length L          | 56 mm    |
| Shank square □            | 3 mm     |
| Thread depth              | 7.02 mm  |
| Thread type               | UNC      |
| Thread size               | 6-32 UNC |

## Data sheet

|                                  |                                        |
|----------------------------------|----------------------------------------|
| Coating                          | uncoated                               |
| Flank angle                      | 60 degrees                             |
| Tolerance class                  | 2B                                     |
| Taper lead form                  | C                                      |
| Helix angle                      | 15 degrees                             |
| Shank                            | Plain shank with h9                    |
| Through-coolant                  | no                                     |
| Application for type of drilling | up to 2×D for blind holes              |
| Cutting direction                | right-hand                             |
| Type of threading tool           | Machine tap for conventional machining |
| Colour ring                      | without                                |
| Type of product                  | Tap                                    |

## User data

|                               | Suitability                               | V <sub>c</sub> | ISO code |
|-------------------------------|-------------------------------------------|----------------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 13 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 15 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 15 m/min       | P        |
| Oil                           | suitable                                  |                |          |
| wet maximum                   | suitable only under restricted conditions |                |          |