



Fluteless machine tap without oil grooves HSS-E 6HX, TiAlN, M: M8



Order data

| | |
|--------------|---------------|
| Order number | 139132 M8 |
| GTIN | 4045197446589 |
| Item class | 12H |

Description

Version:

Size M1–M1.4 – **tolerance class:** ISO 1X / 4HX

DIN 2174 (\approx **DIN 371** \leq M10; \approx **DIN 376** \geq M12).

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank $\varnothing D_s$: 8 mm

Shank square \square : 6.2 mm

Tapping hole \varnothing guide value: 7.45 mm

Technical description

| | |
|--|------------|
| Thread pitch | 1.25 mm |
| Number of clamping slots | 5 |
| Number of cutting edges Z | 5 |
| Thread \varnothing | 8 mm |
| Shank $\varnothing D_s$ | 8 mm |
| Shank square \square | 6.2 mm |
| Overall length L | 90 mm |
| Tapping hole \varnothing guide value | 7.45 mm |
| Tolerance class | ISO 2X 6HX |
| Thread depth | 12 mm |

| | |
|----------------------------------|-------------------------------|
| Thread size | M8 |
| Coating | TiAlN |
| Thread type | M |
| Flank angle | 60 ° |
| Tool material | HSS E |
| Standard | DIN 2174 |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 1.5×D for through holes |
| Application for type of drilling | up to 1.5×D for blind 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 | | |

