



## Fluteless machine tap without oil grooves HSS-E 6HX, TiAlN, M: M2



### Order data

Order number	139132 M2
GTIN	4045197446497
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: 0.4 mm

Overall length L: 45 mm

Shank  $\varnothing D_s$ : 2.8 mm

Shank square  $\square$ : 2.1 mm

Tapping hole  $\varnothing$  guide value: 1.85 mm

### Technical description

Number of clamping slots	3
Thread pitch	0.4 mm
Thread $\varnothing$	2 mm
Number of cutting edges Z	3
Shank $\varnothing D_s$	2.8 mm
Shank square $\square$	2.1 mm
Overall length L	45 mm
Tapping hole $\varnothing$ guide value	1.85 mm
Tolerance class	ISO 2X 6HX
Thread depth	3 mm

Thread size	M2
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 <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		

