



## Fluteless machine tap with oil grooves HSS-E Form C 6HX, TiAlN, M: M3



### Order data

Order number	139182 M3
GTIN	4045197446732
Item class	12H

### Description

#### Version:

**Tolerance class:** ISO 2X/6HX.

**DIN 2174** ( $\approx$  DIN 371  $\leq$  M10;  $\approx$  DIN 376  $\geq$  M12). **With oil grooves; optimum lubrication effect even in deeper threads.**

Tolerance class: ISO 2X 6HX

Thread pitch: 0.5 mm

Overall length L: 56 mm

Shank  $\varnothing$  D<sub>s</sub>: 3.5 mm

Shank square □: 2.7 mm

Tapping hole  $\varnothing$  guide value: 2.8 mm

### Technical description

Number of clamping slots	2
Thread $\varnothing$	3 mm
Number of cutting edges Z	2
Thread pitch	0.5 mm
Shank $\varnothing$ D <sub>s</sub>	3.5 mm
Shank square □	2.7 mm
Overall length L	56 mm
Tapping hole $\varnothing$ guide value	2.8 mm
Tolerance class	ISO 2X 6HX
Thread depth	9 mm

Thread size	M3
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 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 <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		

