



Fluteless machine tap with oil grooves HSS-E Form C 6HX, TiAlN, M: M6



Order data

Order number	139182 M6
GTIN	4045197446770
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: 1 mm

Overall length L: 80 mm

Shank $\varnothing D_s$: 6 mm

Shank square \square : 4.9 mm

Tapping hole \varnothing guide value: 5.55 mm

Technical description

Number of clamping slots	5
Thread pitch	1 mm
Number of cutting edges Z	5
Thread \varnothing	6 mm
Shank $\varnothing D_s$	6 mm
Shank square \square	4.9 mm
Overall length L	80 mm
Tapping hole \varnothing guide value	5.55 mm
Tolerance class	ISO 2X 6HX
Thread depth	18 mm

Thread size	M6
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 _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		

