



Fluteless machine tap with oil grooves HSS-E Form C 6HX, TiAlN, M: M12



Order data

Order number	139182 M12
GTIN	4045197446800
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: 1.75 mm

Overall length L: 110 mm

Shank \varnothing D_s: 9 mm

Shank square \square : 7 mm

Tapping hole \varnothing guide value: 11.2 mm

Technical description

Thread \varnothing	12 mm
Thread pitch	1.75 mm
Number of clamping slots	3
Number of cutting edges Z	3
Shank \varnothing D _s	9 mm
Shank square \square	7 mm
Overall length L	110 mm
Tapping hole \varnothing guide value	11.2 mm
Tolerance class	ISO 2X 6HX

Thread depth	36 mm
Thread size	M12
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