



Machine tap HSS-E, vaporised, M: M4



Order data

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|--------------|---------------|
| Order number | 132645 M4 |
| GTIN | 4045197648877 |
| Item class | 12H |

Description

Version:

Spiral point with oil grooves.

Guide section with oil grooves, but without chip flutes. Tolerance class: ISO 2 6H

Thread type: M

Tool material: HSS E

Standard: DIN 371

Tolerance class: ISO 2 6H

Thread pitch: 0.7 mm

Overall length L: 63 mm

Shank $\varnothing D_s$: 4.5 mm

Shank square \square : 3.4 mm

Tapping hole \varnothing : 3.3 mm

Technical description

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|----------------------------|---------|
| Number of cutting edges Z | 2 |
| Tapping hole \varnothing | 3.3 mm |
| Number of clamping slots | 2 |
| Thread \varnothing | 4 mm |
| Thread pitch | 0.7 mm |
| Standard | DIN 371 |
| Shank $\varnothing D_s$ | 4.5 mm |
| Overall length L | 63 mm |
| Shank square \square | 3.4 mm |

| | |
|----------------------------------|-----------------------------------|
| Tolerance class | ISO 2 6H |
| Tool material | HSS E |
| Thread depth | 12 mm |
| Thread type | M |
| Thread size | M4 |
| Coating | vaporised |
| Flank angle | 60° |
| Thread standard | DIN 13 |
| Taper lead form | B |
| Shank | Plain shank with h9 |
| Through-coolant | no |
| Application for type of drilling | up to 3×D for through holes |
| Cutting direction | right-hand |
| Type of threading tool | Machine tap for dynamic machining |
| Colour ring | green |
| Type of product | Tap |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 11 m/min | N |
| Steel < 500 N/mm ² | suitable only under restricted conditions | 12 m/min | P |
| Steel < 750 N/mm ² | suitable | 8 m/min | P |
| Steel < 900 N/mm ² | suitable | 7 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 4 m/min | P |
| INOX < 900 N/mm ² | suitable | 4 m/min | M |
| CuZn | suitable only under restricted conditions | 12 m/min | N |

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|-----|----------|
| Uni | suitable |
| Oil | suitable |