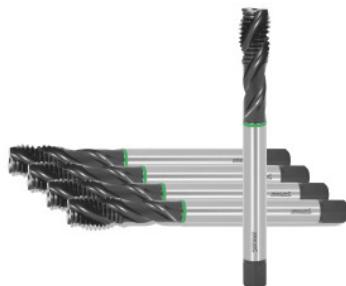




Value pack machine tap HSS-E Form C



Order data

Order number	GG1856 M4
GTIN	4067263135357
Item class	GGN

Description

Version:

Form C (2–3 turns lead chamfer).

Same as No. 135855.

Technical description

Tapping hole Ø	3.3 mm
Thread size	M4
Standard	DIN 371
Thread depth	12 mm
Overall length L	63 mm
Tool material	HSS E
Tolerance class	ISO 2 6H
Shank square □	3.4 mm
Number of clamping slots	2
Shank Ø D _s	4.5 mm

Thread type	M
Thread Ø	4 mm
Number of cutting edges Z	2
Thread pitch	0.7 mm
Coating	vaporised
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3xD for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Taps

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

Uni	suitable
Oil	suitable

Accessories

Machine tapHSS-E Form C M M4

135855 M4