

**Machine tap HSS-E Form C, vaporised, M: M4****Order data**

Order number	135855 M4
GTIN	4045197649539
Item class	12H

Description**Version:****Form C** (2–3 turns lead chamfer).

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 Ø D_s: 4.5 mm

Shank square □: 3.4 mm

Tapping hole Ø: 3.3 mm

Technical description

Thread Ø	4 mm
Number of cutting edges Z	2
Thread pitch	0.7 mm
Number of clamping slots	2
Tapping hole Ø	3.3 mm
Standard	DIN 371
Shank Ø D _s	4.5 mm
Overall length L	63 mm
Shank 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	C
Helix angle	40 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind 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
Uni	suitable		
Oil	suitable		