



HOLEX Pro Tap machine tap HSS-E, TiN, UNF: 1/4-28



Order data

Order number	133425 1/4-28
GTIN	4062406374310
Item class	12I

Description

Version:

HOLEX Pro Tap general-purpose tap. Sturdy design suitable for a wide spectrum of materials.
Improved HSS-E tool material with low-friction TiN coating.

Application:

For UNF unified fine threads ASME – B1.1.

Thread type: UNF

Tool material: HSS E

Standard: DIN 371

Threads per inch: 28

Thread Ø: 6.35 mm

Overall length L: 80 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.5 mm

Technical description

Tapping hole Ø	5.5 mm
Threads per inch	28
Tool material	HSS E
Number of cutting edges Z	3
Thread Ø	6.35 mm
Number of clamping slots	3
Standard	DIN 371

Thread pitch	0.907 mm
Shank $\varnothing D_s$	7 mm
Overall length L	80 mm
Shank square \square	5.5 mm
Thread type	UNF
Thread size	1/4-28 UNF
Thread depth	19.05 mm
Coating	TiN
Flank angle	60 °
Tolerance class	2B
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
Type of product	Tap

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	24 m/min	N
Aluminium (short chipping)	suitable	25 m/min	N
Alu > 10% Si	suitable	10 m/min	N
Steel < 500 N/mm ²	suitable	24 m/min	P
Steel < 750 N/mm ²	suitable	20 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	8 m/min	P

INOX < 900 N/mm ²	suitable	8 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		