



## HOLEX Pro Tap machine tap HSS-E, TiN, MF: 24X1,5



### Order data

|              |               |
|--------------|---------------|
| Order number | 137170 24X1,5 |
| GTIN         | 4062406374693 |
| 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.**

Thread type: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 140 mm

Shank  $\varnothing D_s$ : 18 mm

Shank square  $\square$ : 14.5 mm

Tapping hole  $\varnothing$ : 22.5 mm

### Technical description

|                            |          |
|----------------------------|----------|
| Thread size                | M24×1.5  |
| Number of clamping slots   | 4        |
| Tolerance class            | ISO 2 6H |
| Standard                   | DIN 374  |
| Thread pitch               | 1.5 mm   |
| Tapping hole $\varnothing$ | 22.5 mm  |
| Shank $\varnothing D_s$    | 18 mm    |
| Thread $\varnothing$       | 24 mm    |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread type                      | MF                                |
| Shank square $\square$           | 14.5 mm                           |
| Number of cutting edges Z        | 4                                 |
| Tool material                    | HSS E                             |
| Thread depth                     | 60 mm                             |
| Overall length L                 | 140 mm                            |
| Coating                          | TiN                               |
| 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 2.5×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 |
|-------------------------------|-------------|----------|----------|
| 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 <sup>2</sup> | suitable    | 24 m/min | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable    | 20 m/min | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable    | 15 m/min | P        |

|                                |   |          |   |
|--------------------------------|---|----------|---|
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 8 m/min  | P |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 8 m/min  | M |
| CuZn                           | suitable only under restricted conditions | 15 m/min | N |
| Uni                            | suitable                                  |          |   |
| Oil                            | suitable                                  |          |   |
| wet maximum                    | suitable                                  |          |   |