



HOLEX Pro Tap machine tap HSS-E, TiN, UNC: 1/4-20



Order data

| | |
|--------------|---------------|
| Order number | 137910 1/4-20 |
| GTIN | 4062406374839 |
| 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 UNC uniform coarse threads ASME – B1.1.

Thread type: UNC

Tool material: HSS E

Standard: DIN 371

Threads per inch: 20

Thread Ø: 6.35 mm

Overall length L: 80 mm

Shank Ø D_s: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.1 mm

Technical description

| | |
|------------------------|------------|
| Shank Ø D _s | 7 mm |
| Thread size | 1/4-20 UNC |
| Overall length L | 80 mm |
| Thread Ø | 6.35 mm |
| Thread pitch | 1.27 mm |
| Tapping hole Ø | 5.1 mm |
| Standard | DIN 371 |

| | |
|----------------------------------|-----------------------------------|
| Tool material | HSS E |
| Thread type | UNC |
| Number of clamping slots | 2 |
| Number of cutting edges Z | 2 |
| Threads per inch | 20 |
| Shank square \square | 5.5 mm |
| Thread depth | 15.9 mm |
| Coating | TiN |
| Flank angle | 60° |
| Tolerance class | 2B |
| 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 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 | | |