



HOLEX Pro Tap machine tap HSS-E 6H, TiN, MF: 22X1,5



Order data

Order number	137170 22X1,5
GTIN	4062406374686
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.

Technical description

Shank $\varnothing D_s$	18 mm
Tapping hole \varnothing	20.5 mm
Shank square \square	14.5 mm
Tolerance class	ISO 2 6H
Thread depth	55 mm
Thread size	M22×1.5
Thread pitch	1.5 mm
Thread \varnothing	22 mm
Number of cutting edges Z	4
Thread type	MF
Number of clamping slots	4
Tool material	HSS E
Overall length L	125 mm
Standard	DIN 374

Coating	TiN
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 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Pro Tap
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