



HOLEX Clever Tap machine tap HSS-E, uncoated, NPT: 1/8-27



Order data

Order number	138095 1/8-27
GTIN	4067263161479
Item class	12H

Description

Version:

HOLEX Clever Tap: Sturdy tap for conventional standard applications. High-quality HSS-E tool material and geometry for steels. Surface: Bronze-coloured tempered thread profile.

Application:

Tapered pipe threads (NPT) to ANSI B1.20.1, for threads with sealants. See the table for the specified minimum size of the tapping hole.

Recommendation:

Tapping hole \varnothing A: Pre-drill a plain hole, do not use a reamer. Tapping hole \varnothing B: Pre-drill a plain hole then ream it using a 1:16 taper reamer (see No. 162650). The taper bore \varnothing can then be checked laterally by reference to the Dmax check dimension (see table). Variant B for drilling the tapping hole offers the best process reliability for the tapping operation.

Technical description

Thread size	1/8-27 NPT
Number of clamping slots	4
Shank square \square	5.5 mm
Number of cutting edges Z	4
Threads per inch	27
Overall length L	90 mm
Shank \varnothing D _s	7 mm
Tapping hole \varnothing A	8.5 mm

Thread depth	19.73 mm
Tapping hole Ø B	8.25 mm
Thread pitch	0.941 mm
Thread gauge Ø D _{max} + 0.05	8.74 mm
Thread Ø	10.242 mm
Tapping hole minimum depth	12 mm
Coating	uncoated
Thread type	NPT
Flank angle	60 degrees
Tool material	HSS E
Standard	Works standard
Thread standard	ANSI B 1.20.1
Taper lead form	C
Taper ratio	1:16
Helix angle	15 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	Blind hole
Application for type of drilling	Through hole
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	without
Series	CleverTap
Type of product	Taps

User data

	Suitability	V _c	ISO code
Aluminium	suitable only under restricted conditions	13 m/min	N

Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm ²	suitable	12 m/min	P
Steel < 750 N/mm ²	suitable	12 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	6 m/min	P
Oil	suitable		
wet maximum	suitable		