



HOLEX Clever Tap machine tap HSS-E, uncoated, NPT: 1-11,5



Order data

Order number	138095 1-11,5
GTIN	4067263162537
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 pitch	2.209 mm
Shank square \square	20 mm
Thread depth	64.18 mm
Shank \varnothing D _s	25 mm
Threads per inch	11.5
Overall length L	160 mm
Tapping hole \varnothing A	29 mm
Tapping hole minimum depth	27.4 mm

Tapping hole \varnothing B	28.6 mm
Thread \varnothing	33.228 mm
Number of cutting edges Z	6
Thread size	1-11.5 NPT
Thread gauge \varnothing D _{max} + 0.05	29.69 mm
Number of clamping slots	6
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		