



## HOLEX Clever Tap machine tap, uncoated, UNF: 1/4-28



### Order data

Order number	133404 1/4-28
GTIN	4067263161912
Item class	12H

### Description

#### Version:

#### With spiral point.

#### 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:

**For UNF uniform fine threads ASME – B1.1.**

Thread type: UNF

Tool material: HSS E

Standard: DIN 371

Threads per inch: 28

Thread Ø: 6.35 mm

Overall length L: 80 mm

Shank Ø D<sub>s</sub>: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.5 mm

### Technical description

Thread size	1/4-28 UNF
Standard	DIN 371
Thread Ø	6.35 mm
Tool material	HSS E
Number of cutting edges Z	3
Threads per inch	28

Tapping hole Ø	5.5 mm
Thread pitch	0.907 mm
Thread type	UNF
Shank square □	5.5 mm
Shank Ø D <sub>s</sub>	7 mm
Thread depth	19.05 mm
Number of clamping slots	3
Overall length L	80 mm
Coating	uncoated
Flank angle	60°
Tolerance class	2B
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for conventional machining
Colour ring	without
Type of product	Taps

## User data

	Suitability	V <sub>c</sub>	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 <sup>2</sup>	suitable	12 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	6 m/min	P
Oil	suitable		
wet maximum	suitable		