



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



Order data

Order number	138004 1/4-28
GTIN	4067263162407
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. **HSS-E**

Application:

For UNF uniform fine threads ASME – B1.1.

Technical description

Thread depth	15.9 mm
Number of clamping slots	3
Threads per inch	28
Tool material	HSS E
Thread Ø	6.35 mm
Standard	DIN 371
Shank Ø D _s	7 mm
Shank square □	5.5 mm
Thread type	UNF
Number of cutting edges Z	3
Thread size	1/4-28 UNF
Tapping hole Ø	5.5 mm

Thread pitch	0.907 mm
Overall length L	80 mm
Series	CleverTap
Coating	uncoated
Flank angle	60 degrees
Tolerance class	2B
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 conventional machining
Colour ring	without
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		

