



HOLEX Clever Tap machine tap, uncoated, MF: 22X1,5



Order data

Order number	136255 22X1,5
GTIN	4067263162278
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.

Thread type: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 125 mm

Shank $\varnothing D_s$: 18 mm

Shank square \square : 14.5 mm

Tapping hole \varnothing : 20.5 mm

Technical description

Overall length L	125 mm
Thread depth	55 mm
Thread type	MF
Standard	DIN 374
Tool material	HSS E
Thread \varnothing	22 mm
Shank $\varnothing D_s$	18 mm

Shank square <input type="checkbox"/>	14.5 mm
Thread size	M22×1.5
Thread pitch	1.5 mm
Number of clamping slots	4
Tapping hole Ø	20.5 mm
Number of cutting edges Z	4
Tolerance class	ISO 2 6H
Coating	uncoated
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 °
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	15 m/min	P
Steel < 750 N/mm ²	suitable	15 m/min	P

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