



## HOLEX Clever Tap machine tap, uncoated, MF: 25X1,5



### Order data

Order number	136255 25X1,5
GTIN	4067263162292
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: 140 mm

Shank  $\varnothing D_s$ : 18 mm

Shank square  $\square$ : 14.5 mm

Tapping hole  $\varnothing$ : 23.5 mm

### Technical description

Number of cutting edges Z	4
Thread size	M25×1.5
Shank square $\square$	14.5 mm
Thread type	MF
Shank $\varnothing D_s$	18 mm
Standard	DIN 374
Thread $\varnothing$	25 mm

Overall length L	140 mm
Tapping hole Ø	23.5 mm
Number of clamping slots	4
Thread depth	62.5 mm
Tolerance class	ISO 2 6H
Thread pitch	1.5 mm
Tool material	HSS E
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 <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	15 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		