



## HOLEX Clever Tap machine tap, uncoated, UNC: 1/4-20



### Order data

Order number	137868 1/4-20
GTIN	4067263162339
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 **UNC uniform coarse threads** ASME – B1.1.

### Technical description

Thread type	UNC
Overall length L	80 mm
Number of clamping slots	3
Thread size	1/4-20 UNC
Thread depth	15.9 mm
Shank square □	5.5 mm
Thread Ø	6.35 mm
Number of cutting edges Z	3
Tapping hole Ø	5.1 mm
Tool material	HSS E
Shank Ø D <sub>s</sub>	7 mm
Standard	DIN 371

Thread pitch	1.27 mm
Threads per inch	20
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 <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	12 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	6 m/min	P
Oil	suitable		
wet maximum	suitable		

