



HOLEX Pro Form fluteless machine tap without oil grooves 6HX, TiN, M: M1



Order data

Order number	139130 M1
GTIN	4069515003193
Item class	12I

Description

Version:

DIN 2174 ($\approx$ **DIN 371** $\leq$ M10; $\approx$ **DIN 376** $\geq$ M12).

Size M1–M1.4 – **tolerance class:** ISO 1X / 4HX.

HOLEX Pro Form: High-performance fluteless tap for use in a **wide range of materials**.

- **HSS-E-PM tool material for high wear resistance.**
- **The latest-generation optimised HIPIMS TiN coating.**

Technical description

Tapping hole Ø guide value	0.9 mm
Number of clamping slots	1
Number of cutting edges Z	1
Thread size	M1
Overall length L	40 mm
Thread Ø	1 mm
Thread pitch	0.25 mm
Series	Pro Form
Shank Ø D _s	2.5 mm
Thread depth	1.5 mm
Shank square □	2.1 mm
Tolerance class	ISO 1X 4HX

Data sheet

Coating	TiN
Thread type	M
Flank angle	60 degrees
Tool material	HSS E PM
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5×D for blind holes
Application for type of drilling	up to 1.5×D for through holes
Cutting direction	right-hand
Colour ring	green
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	20 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	20 m/min	N
Steel < 500 N/mm ²	suitable	27 m/min	P
Steel < 750 N/mm ²	suitable	25 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
INOX < 900 N/mm ²	suitable	8 m/min	M
CuZn	suitable only under restricted conditions	20 m/min	N
Uni	suitable		
Oil	suitable		

wet maximum

suitable