



HOLEX Pro Form fluteless machine tap with oil grooves HSS-E-PM, TiN, G: G1/8



Order data

Order number	139475 G1/8
GTIN	4069515003735
Item class	12I

Description

Version:

DIN 2189 (≈ DIN 5156). **With oil grooves; optimum lubrication effect even in deeper threads.**

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.**

Application:

For **Whitworth parallel pipe threads** DIN-ISO 228/1 (threads that do not form a seal within the connection).

Technical description

Shank Ø D _s	7 mm
Thread depth	29.19 mm
Threads per inch	28
Thread Ø	9.73 mm
Shank square □	5.5 mm
Thread size	G1/8
Number of clamping slots	6
Thread pitch	0.907 mm
Tapping hole Ø guide value	9.25 mm

Data sheet

Overall length L	90 mm
Number of cutting edges Z	6
Coating	TiN
Thread type	G
Flank angle	55 degrees
Tool material	HSS E PM
Standard	DIN 2189
Tolerance class	ISO 228 X
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Colour ring	green
Series	Pro Form
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		