



HOLEX Pro Form fluteless machine tap with oil grooves 6GX, TiN, M: M12



Order data

Order number	139195 M12
GTIN	4069515003643
Item class	12I

Description

Version:

DIN 2174 ($\approx$ DIN 371 $\leq$ M10; $\approx$ DIN 376 $\geq$ M12). With oil grooves; optimum lubrication effect even in deeper threads.

Tolerance class: ISO 3X/6GX = **Oversize 0.02– 0.04 mm.**

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

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

Application:

For components which are **galvanised after threading** or which shrink slightly when hardened.

Technical description

Thread pitch	1.75 mm
Shank square □	7 mm
Number of cutting edges Z	5
Series	Pro Form
Overall length L	110 mm
Shank Ø D _s	9 mm
Thread Ø	12 mm
Thread depth	36 mm
Tolerance class	ISO 3X 6GX
Number of clamping slots	5

Data sheet

Thread size	M12
Tapping hole Ø guide value	11.2 mm
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 3×D for through holes
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Colour ring	yellow
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