



HOLEX Pro Form fluteless machine tap with oil grooves 6HX, TiN, M: M6



Order data

Order number	139180 M6
GTIN	4069515003520
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 2X/6HX.

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.**

Technical description

Shank square ☐	4.9 mm
Overall length L	80 mm
Number of clamping slots	5
Shank $\varnothing D_s$	6 mm
Thread size	M6
Thread pitch	1 mm
Tolerance class	ISO 2X 6HX
Number of cutting edges Z	5
Series	Pro Form
Tapping hole $\varnothing$ guide value	5.55 mm
Thread $\varnothing$	6 mm
Thread depth	18 mm

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 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