

**HOLEX Pro Form fluteless machine tap with oil grooves HSS-E-PM, TiN, MF: 8X1****Order data**

Order number	139370 8X1
GTIN	4069515003667
Item class	12I

Description**Version:**

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.**

Satisfies DIN 374.

Technical description

Thread size	M8×1
Series	Pro Form
Overall length L	90 mm
Thread pitch	1 mm
Tolerance class	ISO 2X 6HX
Number of clamping slots	5
Shank square □	4.9 mm
Tapping hole Ø guide value	7.55 mm
Thread Ø	8 mm
Thread depth	24 mm
Shank Ø D _s	6 mm
Number of cutting edges Z	5

Data sheet

Coating	TiN
Thread type	MF
Flank angle	60 degrees
Tool material	HSS E PM
Standard	DIN 374
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×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
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		
wet minimum	suitable		

