



## HOLEX Pro Form fluteless machine tap without oil grooves 6GX, TiN, M: M6



### Order data

|              |               |
|--------------|---------------|
| Order number | 139143 M6     |
| GTIN         | 4069515003414 |
| Item class   | 12I           |

### Description

#### Version:

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

**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 tool material 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

|                            |            |
|----------------------------|------------|
| Series                     | Pro Form   |
| Thread Ø                   | 6 mm       |
| Shank Ø D <sub>s</sub>     | 6 mm       |
| Thread size                | M6         |
| Shank square □             | 4.9 mm     |
| Overall length L           | 80 mm      |
| Tolerance class            | ISO 3X 6GX |
| Tapping hole Ø guide value | 5.55 mm    |
| Thread depth               | 9 mm       |
| Number of clamping slots   | 5          |
| Number of cutting edges Z  | 5          |

## Data sheet

|                                  |                               |
|----------------------------------|-------------------------------|
| Thread pitch                     | 1 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 1.5×D for through holes |
| Application for type of drilling | up to 1.5×D for blind holes   |
| Cutting direction                | right-hand                    |
| Colour ring                      | green                         |
| Type of product                  | Fluteless tap                 |

## User data

|                                | Suitability                               | V <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 27 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 25 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 25 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 10 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 8 m/min        | M        |
| CuZn                           | suitable only under restricted conditions | 20 m/min       | N        |
| Uni                            | suitable                                  |                |          |

Data sheet

|             |          |
|-------------|----------|
| Oil         | suitable |
| wet maximum | suitable |