



HOLEX Pro Form fluteless machine tap with oil grooves HSS-E-PM, TiN, G: G1/4



Order data

Order number	139475 G1/4
GTIN	4069515003742
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

Tapping hole Ø guide value	12.55 mm
Overall length L	100 mm
Thread pitch	1.337 mm
Number of cutting edges Z	6
Thread size	G1/4
Shank Ø D _s	11 mm
Thread Ø	13.16 mm
Thread depth	39.48 mm
Number of clamping slots	6

Data sheet

Shank square ☐	9 mm
Threads per inch	19
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

Data sheet

CuZn	suitable only under restricted conditions	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		