



## HOLEX Pro Form fluteless machine tap with oil grooves 6GX, TiN, M: M4



### Order data

|              |               |
|--------------|---------------|
| Order number | 139195 M4     |
| GTIN         | 4069515003599 |
| 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

|                            |            |
|----------------------------|------------|
| Number of cutting edges Z  | 4          |
| Overall length L           | 63 mm      |
| Thread pitch               | 0.7 mm     |
| Thread Ø                   | 4 mm       |
| Number of clamping slots   | 4          |
| Series                     | Pro Form   |
| Tapping hole Ø guide value | 3.7 mm     |
| Shank Ø D <sub>s</sub>     | 4.5 mm     |
| Shank square □             | 3.4 mm     |
| Tolerance class            | ISO 3X 6GX |

## Data sheet

|                                  |                             |
|----------------------------------|-----------------------------|
| Thread size                      | M4                          |
| Thread depth                     | 12 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

|                                | <b>Suitability</b>                        | <b>V<sub>c</sub></b> | <b>ISO code</b> |
|--------------------------------|-------------------------------------------|----------------------|-----------------|
| 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               |

Data sheet

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