



## HOLEX Pro Form fluteless machine tap with oil grooves 6HX, TiN, M: M5



### Order data

|              |               |
|--------------|---------------|
| Order number | 139180 M5     |
| GTIN         | 4069515003513 |
| 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 $\varnothing D_s$                | 6 mm       |
| Thread $\varnothing$                   | 5 mm       |
| Tolerance class                        | ISO 2X 6HX |
| Overall length L                       | 70 mm      |
| Thread depth                           | 15 mm      |
| Thread pitch                           | 0.8 mm     |
| Number of clamping slots               | 4          |
| Thread size                            | M5         |
| Shank square $\square$                 | 4.9 mm     |
| Number of cutting edges Z              | 4          |
| Series                                 | Pro Form   |
| Tapping hole $\varnothing$ guide value | 4.65 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 <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                                  |                |          |
| Oil                            | suitable                                  |                |          |

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