

## HOLEX Clever Tap machine tap HSS-E, uncoated, NPT: 1/4-18



### Order data

Order number	138095 1/4-18
GTIN	4067263162490
Item class	12H

### Description

**Version:**

HOLEX Clever Tap: Sturdy tap for conventional standard applications. High-quality HSS-E tool material and geometry for steels. Surface: Bronze-coloured tempered thread profile.

**Application:**

Tapered pipe threads (NPT) to ANSI B1.20.1, for threads with sealants. See the table for the specified minimum size of the tapping hole.

**Recommendation:**

Tapping hole  $\varnothing$  A: Pre-drill a plain hole, do not use a reamer. Tapping hole  $\varnothing$  B: Pre-drill a plain hole then ream it using a 1:16 taper reamer (see No. 162650). The taper bore  $\varnothing$  can then be checked laterally by reference to the  $D_{max}$  check dimension (see table). Variant B for drilling the tapping hole offers the best process reliability for the tapping operation.

### Technical description

Tapping hole minimum depth	17.5 mm
Tapping hole $\varnothing$ A	11.1 mm
Thread pitch	1.411 mm
Thread size	1/4-18 NPT
Thread $\varnothing$	6.35 mm
Number of cutting edges Z	3
Thread gauge $\varnothing D_{max} + 0.05$	11.36 mm
Tapping hole $\varnothing$ B	10.75 mm
Threads per inch	18

Number of clamping slots	3
Shank square □	9 mm
Shank $\varnothing D_s$	11 mm
Thread depth	19.05 mm
Overall length L	100 mm
Coating	uncoated
Thread type	NPT
Flank angle	60 degrees
Tool material	HSS E
Standard	Works standard
Thread standard	ANSI B 1.20.1
Taper lead form	C
Taper ratio	1:16
Helix angle	15 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	Blind hole
Application for type of drilling	Through hole
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	without
Series	CleverTap
Type of product	Taps

## User data

	Suitability	$V_c$	ISO code
Aluminium	suitable only under restricted conditions	13 m/min	N

Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	6 m/min	P
Oil	suitable		
wet maximum	suitable		