



## HOLEX Pro Tap machine tap HSS-E, TiN, UNF: 1/4-28



### Order data

Order number	138050 1/4-28
GTIN	4062406374907
Item class	12I

### Description

#### Version:

**HOLEX Pro Tap general-purpose tap.** Sturdy design suitable for a wide spectrum of materials.  
**Improved HSS-E tool material with low-friction TiN coating.**

#### Application:

**For UNF uniform fine threads ASME – B1.1.**

Thread type: UNF

Tool material: HSS E

Standard: DIN 371

Threads per inch: 28

Thread Ø: 6.35 mm

Overall length L: 80 mm

Shank Ø D<sub>s</sub>: 7 mm

Shank square □: 5.5 mm

Tapping hole Ø: 5.5 mm

### Technical description

Thread depth	15.9 mm
Number of cutting edges Z	2
Standard	DIN 371
Shank Ø D <sub>s</sub>	7 mm
Thread size	1/4-28 UNF
Threads per inch	28
Tool material	HSS E

Thread type	UNF
Number of clamping slots	2
Tapping hole Ø	5.5 mm
Shank square □	5.5 mm
Overall length L	80 mm
Thread Ø	6.35 mm
Thread pitch	0.907 mm
Coating	TiN
Flank angle	60 °
Tolerance class	2B
Taper lead form	C
Helix angle	40 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	24 m/min	N
Aluminium (short chipping)	suitable	25 m/min	N
Alu > 10% Si	suitable	10 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P

Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	8 m/min	M
CuZn	suitable only under restricted conditions	15 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		