



## HOLEX Pro Tap machine tap HSS-E, TiN, MF: 22X1,5



### Order data

Order number	132925 22X1,5
GTIN	4062406374099
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.**

Thread type: MF

Tool material: HSS E

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1.5 mm

Overall length L: 125 mm

Shank  $\varnothing$  D<sub>s</sub>: 18 mm

Shank square  $\square$ : 14.5 mm

Tapping hole  $\varnothing$ : 20.5 mm

### Technical description

Number of cutting edges Z	4
Shank square $\square$	14.5 mm
Thread pitch	1.5 mm
Thread size	M22×1.5
Standard	DIN 374
Tapping hole $\varnothing$	20.5 mm
Shank $\varnothing$ D <sub>s</sub>	18 mm
Overall length L	125 mm

Tool material	HSS E
Thread type	MF
Tolerance class	ISO 2 6H
Number of clamping slots	4
Thread depth	66 mm
Thread Ø	22 mm
Coating	TiN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through 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		