

**HOLEX Pro Tap machine tap HSS-E, TiN, MF: 12X1,25****Order data**

|              |                |
|--------------|----------------|
| Order number | 137170 12X1,25 |
| GTIN         | 4062406374624  |
| 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: 1.25 mm

Overall length L: 100 mm

Shank Ø D<sub>s</sub>: 9 mm

Shank square □: 7 mm

Tapping hole Ø: 10.8 mm

**Technical description**

|                           |          |
|---------------------------|----------|
| Thread Ø                  | 12 mm    |
| Thread type               | MF       |
| Tolerance class           | ISO 2 6H |
| Overall length L          | 100 mm   |
| Shank square □            | 7 mm     |
| Thread size               | M12×1.25 |
| Standard                  | DIN 374  |
| Number of cutting edges Z | 3        |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread depth                     | 30 mm                             |
| Shank Ø D <sub>s</sub>           | 9 mm                              |
| Thread pitch                     | 1.25 mm                           |
| Number of clamping slots         | 3                                 |
| Tapping hole Ø                   | 10.8 mm                           |
| Tool material                    | HSS E                             |
| Coating                          | TiN                               |
| Flank angle                      | 60 °                              |
| Thread standard                  | DIN 13                            |
| 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                                  |          |   |