

**Garant****GARANT Master Tap INOX machine tap HSS-E-PM IC / Form C 6HX, TiAlN, M: M8****Order data**

Order number	135734 M8
GTIN	4062406081492
Item class	11I

**Description****Version:**

High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials**.

**The 45° helix angle** of the flutes facilitates chip formation especially in ductile austenitic CrNi steels.

- **HSS-E-PM tool material for a high degree of wear resistance**
- **The latest generation of TiAlN multi-layer coating**
- **Parameterised flute geometry for optimum chip formation and torsional rigidity**

With internal coolant supply

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank  $\varnothing D_s$ : 8 mm

Shank square  $\square$ : 6.2 mm

Tapping hole  $\varnothing$ : 6.8 mm

**Technical description**

Thread pitch	1.25 mm
Tapping hole $\varnothing$	6.8 mm
Shank square $\square$	6.2 mm

Thread type	M
Number of clamping slots	3
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	20 mm
Number of cutting edges Z	3
Thread Ø	8 mm
Shank Ø D <sub>s</sub>	8 mm
Standard	DIN 371
Overall length L	90 mm
Thread size	M8
Coating	TiAlN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	45 °
Shank	Plain shank with h9
Through-coolant	yes
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	blue
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N

Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	11 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		