

Garant
Machine tap, TiCN, MF: 8X1

Order data

Order number	132861 8X1
GTIN	4045197745699
Item class	11H

Description
Version:
Sturdy version.
Recommendation:

For **very hard steels, TOOLOX** and **HARDOX materials** we recommend **deviating from the DIN data** (see table) by **drilling the core hole \varnothing 0.05 to 0.3 mm** larger. For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 90 mm

 Shank \varnothing D_s: 8 mm

 Shank square \square : 6.2 mm

 Tapping hole \varnothing : 7 mm

Technical description

Number of cutting edges Z	5
Tapping hole \varnothing	7 mm
Shank square \square	6.2 mm
Thread \varnothing	8 mm
Number of clamping slots	5
Shank \varnothing D _s	8 mm

Thread pitch	1 mm
Tool material	HSS E PM
Tolerance class	ISO 2X 6HX
Overall length L	90 mm
Standard	DIN 371
Thread depth	12 mm
Thread type	MF
Thread size	M8×1
Coating	TiCN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
Steel < 55 HRC	suitable	2 m/min	H
TOOLOX 33	suitable	4 m/min	H
TOOLOX 44	suitable	3 m/min	H
HARDOX 500 < 1600 N/mm ²	suitable	2 m/min	H

Graphite	suitable only under restricted conditions	15 m/min	N
Oil	suitable		