

**Garant**
**GARANT Master Tap machine tap extra long HSS-E-PM 6HX, AlTiX, MF: 8X1**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 137162 8X1    |
| GTIN         | 4062406207946 |
| Item class   | 111           |

**Description**
**Version:**

**GARANT Master Tap Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for maximum wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

With extra long shank.

**Advantage:**

Designed for tapping threads where access is difficult.

**Technical description**

|                            |                         |
|----------------------------|-------------------------|
| Thread pitch               | 1 mm                    |
| Tapping hole $\varnothing$ | 7 mm                    |
| Tool material              | HSS E PM                |
| Standard                   | Manufacturer's standard |
| Thread size                | M8x1                    |
| Shank square $\square$     | 4.9 mm                  |
| Number of cutting edges Z  | 3                       |
| Thread $\varnothing$       | 8 mm                    |
| Shank $\varnothing D_s$    | 6 mm                    |
| Overall length L           | 180 mm                  |
| Number of clamping slots   | 3                       |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread type                      | MF                                |
| Thread depth                     | 20 mm                             |
| Tolerance class                  | ISO 2X 6HX                        |
| Coating                          | AlTiX                             |
| Flank angle                      | 60 degrees                        |
| Thread standard                  | DIN 13                            |
| Taper lead form                  | C                                 |
| Helix angle                      | 40 degrees                        |
| 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                             |
| Series                           | Master Tap                        |
| Type of product                  | Tap                               |

## User data

|                                | Suitability | V <sub>c</sub> | ISO code |
|--------------------------------|-------------|----------------|----------|
| Alu plastics                   | suitable    | 24 m/min       | N        |
| Aluminium (short chipping)     | suitable    | 28 m/min       | N        |
| Alu > 10% Si                   | suitable    | 16 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable    | 24 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 24 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 20 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 10 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 6 m/min        | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 8 m/min        | M        |

|                              |          |          |   |
|------------------------------|----------|----------|---|
| INOX > 900 N/mm <sup>2</sup> | suitable | 6 m/min  | M |
| GG(G)                        | suitable | 16 m/min | K |
| CuZn                         | suitable | 16 m/min | N |
| Uni                          | suitable |          |   |
| Oil                          | suitable |          |   |
| wet maximum                  | suitable |          |   |