

## Garant

### GARANT Master Tap INOX machine tap extra long HSS-E-PM Form B 6HX, TiAlN, M: M8



#### Order data

Order number	132195 M8
GTIN	4062406209421
Item class	111

#### Description

##### Version:

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

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

**With extra long shank.** Shank to DIN371.

##### Advantage:

Designed for tapping threads where access is difficult.

#### Technical description

Tapping hole Ø	6.8 mm
Number of cutting edges Z	3
Thread depth	24 mm
Shank square □	6.2 mm
Overall length L	180 mm
Number of clamping slots	3
Tool material	HSS E PM
Thread size	M8
Thread type	M
Standard	Manufacturer's standard

Thread Ø	8 mm
Tolerance class	ISO 2X 6HX
Thread pitch	1.25 mm
Shank Ø D <sub>s</sub>	8 mm
Coating	TiAlN
Flank angle	60 degrees
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	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	20 m/min	N
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	16 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	16 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	7 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	6 m/min	M
Oil	suitable		
wet maximum	suitable		

