

Garant
GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6HX, TiAlN, MF: 8X0,75

Order data

Order number	136350 8X0,75
GTIN	4062406237295
Item class	111

Description
Version:

High-performance tap, specially developed for use in **steels with high tensile strength** and for **difficult-to-machine materials**. Sturdy design with **optimised guide thread to avoid chips jamming**.

- **HSS-E-PM tool material – for very high cutting edge stability.**
- **Optimised honed cutting edges.**
- **TiAlN coating – for maximum wear protection.**

Recommendation:

For **TOOLOX materials** we recommend deviating from the **DIN data** (see table) **by selecting a larger tapping hole \varnothing** .

Note:

For **TOOLOX materials**: do not exceed the maximum thread depth of $2 \times D$!

Technical description

Tolerance class	ISO 2X 6HX
Number of cutting edges Z	3
Tool material	HSS E PM
Overall length L	80 mm
Thread \varnothing	8 mm
Shank $\varnothing D_s$	6 mm
Thread depth	20 mm
Number of clamping slots	3

Tapping hole \varnothing	7.2 mm
Thread pitch	0.75 mm
Thread type	MF
Shank square \square	4.9 mm
Thread size	M8x0.75
Standard	DIN 374
Coating	TiAlN
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 2xD for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	red
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	15 m/min	P
Steel < 1400 N/mm ²	suitable		
Steel < 50 HRC	Suitable only under restricted conditions		

TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
INOX > 900 N/mm ²	suitable		
Ti > 850 N/mm ²	Suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		