Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6GX, TiAlN, M: M8

Order data

Order number	135374 M8
GTIN	4062406237035
Item class	11l

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.**
Tolerance class: ISO 3X/6GX.
Application:
For components which are galvanised or shrink slightly when hardened.
Recommendation:
For **TOOLOX and HARDOX materials we recommend deviating from the DIN data** (see table) by **selecting a larger tapping hole ∅.**
Note:
For **TOOLOX and HARDOX materials:** do not exceed the maximum thread depth 2×D!

Technical description

Number of cutting edges Z	3
Thread type	M
Standard	DIN 371
Thread depth	20 mm
Shank ∅ D_s	8 mm
Tool material	HSS E PM

Tapping hole ⌀	6.8 mm
Shank square ☐	6.2 mm
Tolerance class	ISO 3X 6GX
Overall length L	90 mm
Thread pitch	1.25 mm
Thread ⌀	8 mm
Number of clamping slots	3
Thread size	M8
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 2×D 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/mm²	suitable only under restricted conditions	30 m/min	P
Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	15 m/min	P
Steel < 1400 N/mm²	suitable	12 m/min	P

Steel < 50 HRC	suitable only under restricted conditions		
TOOLOX 33	suitable	15 m/min	H
TOOLOX 44	suitable		
INOX > 900 N/mm²	suitable		
Ti > 850 N/mm²	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		