

Garant

GARANT Master Tap SteelHT machine tap HSS-E-PM Form C 6HX, TiAlN, MF: 8X1



Order data

Order number	136350 8X1
GTIN	4062406237301
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** and **HARDOX** materials we recommend deviating from the DIN data (see table) **by selecting a larger tapping hole diameter.**

Note:

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

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 90 mm

Shank $\varnothing D_s$: 6 mm

Shank square \square : 4.9 mm

Tapping hole \varnothing : 7 mm

Technical description

Thread depth	20 mm
--------------	-------

Overall length L	90 mm
Shank square □	4.9 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread type	MF
Number of clamping slots	3
Number of cutting edges Z	3
Thread size	M8×1
Standard	DIN 374
Tapping hole Ø	7 mm
Thread pitch	1 mm
Shank Ø D _s	6 mm
Thread Ø	8 mm
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
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
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		
HARDOX 500 < 1600 N/mm ²	Suitable only under restricted conditions		
INOX > 900 N/mm ²	suitable		
Ti > 850 N/mm ²	Suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		