

**Garant**
**Synchronised fluteless machine tap with oil grooves Solid carbide IC, TiAlN, M: M8**

**Order data**

Order number	139244 M8
GTIN	4045197273505
Item class	11H

**Description**
**Version:**

**Special polygon geometry and shank to DIN 6535-HA** for use on machines with **synchronised spindle drives. With oil grooves; optimal lubrication effect even in deeper threads.**

**Special solid carbide tool material** for high cutting speeds and long tool life. **TiAlN and anti-friction coating** ensure low wear and low tendency to edge build-up.

**With axial internal coolant supply;** advantageous / sufficient for **blind hole** machining.

**Note:**

**For use on synchronised spindles,** the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures very high process reliability.

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank  $\varnothing D_s$ : 8 mm

Shank square  $\square$ : 6.2 mm

Tapping hole  $\varnothing$  guide value: 7.45 mm

**Technical description**

Thread $\varnothing$	8 mm
Number of clamping slots	5
Number of cutting edges Z	5
Thread pitch	1.25 mm
Shank $\varnothing D_s$	8 mm

Shank square <input type="checkbox"/>	6.2 mm
Overall length L	90 mm
Tapping hole Ø guide value	7.45 mm
Tolerance class	ISO 2X 6HX
Thread depth	24 mm
Thread size	M8
Coating	TiAlN
Thread type	M
Flank angle	60 °
Tool material	Solid carbide
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	DIN 6535 HA with h6
Through-coolant	yes
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Shank tolerance	h6
Colour ring	without
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	53 m/min	N
Aluminium (short chipping)	suitable	53 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N

Steel < 500 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	47 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	43 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	36 m/min	P
Oil	suitable		
wet maximum	suitable		