

**Garant**
**Machine tap HSS-E, vaporised, M: M8**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 132640 M8     |
| GTIN         | 4045197072344 |
| Item class   | 11H           |

**Description**
**Version:**

**Guide section with oil grooves**, but without chip flutes.

Size M1.7, M2.3, and M2.6 with old DIN profile.

**With spiral point. Tolerance class: ISO 2 6H**

**Technical description**

|                            |          |
|----------------------------|----------|
| Thread pitch               | 1.25 mm  |
| Thread $\varnothing$       | 8 mm     |
| Number of clamping slots   | 3        |
| Number of cutting edges Z  | 3        |
| Tapping hole $\varnothing$ | 6.8 mm   |
| Standard                   | DIN 371  |
| Shank $\varnothing D_s$    | 8 mm     |
| Overall length L           | 90 mm    |
| Shank square $\square$     | 6.2 mm   |
| Tolerance class            | ISO 2 6H |
| Tool material              | HSS E    |
| Thread depth               | 24 mm    |
| Thread type                | M        |
| Thread size                | M8       |

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Coating                          | vaporised                         |
| 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                      | green                             |
| Type of product                  | Tap                               |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 13 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 15 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 15 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 15 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 6 m/min        | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 6 m/min        | M        |
| CuZn                           | suitable only under restricted conditions | 13 m/min       | N        |
| Uni                            | suitable                                  |                |          |
| Oil                            | suitable                                  |                |          |
| wet maximum                    | suitable only under restricted conditions |                |          |