

Garant
Machine tap, TiCN, MF: 8X1

Order data

Order number	132860 8X1
GTIN	4045197073839
Item class	11H

Description
Recommendation:

For **TOOLOX materials** we recommend **deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05 to 0.3 mm** larger.

Thread type: MF

Tool material: HSS E

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

Tapping hole \varnothing	7 mm
Thread pitch	1 mm
Number of clamping slots	3
Number of cutting edges Z	3
Thread \varnothing	8 mm
Shank \varnothing D _s	6 mm
Overall length L	90 mm
Shank square \square	4.9 mm
Tolerance class	ISO 2X 6HX

Tool material	HSS E
Standard	DIN 374
Thread depth	16 mm
Thread type	MF
Thread size	M8×1
Coating	TiCN
Flank angle	60°
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	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	20 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	19 m/min	P
Steel < 900 N/mm ²	suitable	19 m/min	P
Steel < 1100 N/mm ²	suitable	9 m/min	P
TOOLOX 33	suitable	4 m/min	H
Oil	suitable		
wet maximum	suitable		

