

Garant
Solid carbide machine tap, TiAlN, MF: 8X1

Order data

Order number	132862 8X1
GTIN	4045197073945
Item class	11H

Description
Version:

Particularly sturdy version. For the highest performance demands.

Recommendation:

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

For use only with a length compensation chuck – even on machines with synchronised spindle drives.

Thread type: MF

Tool material: Solid carbide

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 90 mm

Shank \varnothing D_s: 8 mm

Shank square □: 6.2 mm

Tapping hole \varnothing : 7 mm

Technical description

Number of cutting edges Z	5
Thread pitch	1 mm
Thread \varnothing	8 mm
Number of clamping slots	5
Tapping hole \varnothing	7 mm
Shank \varnothing D _s	8 mm

Overall length L	90 mm
Shank square □	6.2 mm
Tolerance class	ISO 2X 6HX
Tool material	Solid carbide
Standard	DIN 371
Thread depth	16 mm
Thread type	MF
Thread size	M8×1
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	D
Shank	Parallel shank to h6
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
Application for type of drilling	up to 2×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 < 55 HRC	suitable	3 m/min	H
Steel < 60 HRC	suitable	2 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	1 m/min	H
Steel < 67 HRC	suitable only under restricted conditions	1 m/min	H

TOOLOX 33	suitable	5 m/min	H
TOOLOX 44	suitable	4 m/min	H
HARDOX 500 < 1600 N/ mm ²	suitable	3 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	18 m/min	N
Oil	suitable		