

**Garant****Machine tap, nitrided, Tr: TR8X1,5****Order data**

Order number	133490 TR8X1,5
GTIN	4045197533005
Item class	11H

**Description****Version:**

**Profile correct for NC**, with divided envelope cut.

**Lead chamfer:**  $\approx 20$  turns. **With 25° left-hand flutes**, right-hand cutting.

**Advantage:**

**Suitable for reversing.**

**Note:**

**For use on synchronised spindles.**

The lead must be machine driven.

**Technical description**

Tapping hole $\varnothing$	6.6 mm
Number of cutting edges Z	3
Thread pitch	1.5 mm
Number of clamping slots	3
Shank $\varnothing D_s$	6 mm
Overall length L	90 mm
Shank square $\square$	4.9 mm
Thread depth	9.9 mm
Thread size	8
Coating	nitrided
Thread type	TR

Flank angle	30 degrees
Tool material	HSS E
Standard	Manufacturer's standard
Tolerance class	DIN 103 7H
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5xD 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	7 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	5 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	3 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	3 m/min	M
GG(G)	suitable	7 m/min	K
CuZn	suitable	7 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		