

**Garant**
**Machine taps extra long HSS-E-PM Form C, vaporised, M: M8**

**Order data**

Order number	134670 M8
GTIN	4045197301673
Item class	11H

**Description**
**Version:**
**With extra long shank.**
**All sizes: Shank to DIN 376 (= shank Ø relieved).**
**Form C** (2–3 turns lead chamfer).

**Advantage:**

Designed for tapping threads where access is difficult.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2 6H

Thread pitch: 1.25 mm

Overall length L: 140 mm

 Shank Ø D<sub>s</sub>: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø: 6.8 mm

**Technical description**

Number of cutting edges Z	3
Thread pitch	1.25 mm
Tapping hole Ø	6.8 mm
Thread Ø	8 mm
Number of clamping slots	3
Standard	Manufacturer's standard
Shank Ø D <sub>s</sub>	6 mm

Overall length L	140 mm
Shank square □	4.9 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Thread depth	24 mm
Thread type	M
Thread size	M8
Coating	vaporised
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind 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	15 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	9 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	8 m/min	M

CuZn	suitable only under restricted conditions	16 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable only under restricted conditions		