

**Garant****Machine tap HSS-E-PM, uncoated, M: M8****Order data**

Order number	134620 M8
GTIN	4045197075635
Item class	11H

**Description****Version:**

**HSS-E-PM steel for high wear resistance** and **strong right-hand chip flutes**, for optimum chip evacuation.

**Technical description**

Number of cutting edges Z	3
Thread Ø	8 mm
Tapping hole Ø	6.8 mm
Number of clamping slots	3
Thread pitch	1.25 mm
Standard	DIN 371
Shank Ø D <sub>s</sub>	8 mm
Overall length L	90 mm
Shank square □	6.2 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Thread depth	24 mm
Thread type	M
Thread size	M8

Coating	uncoated
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
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 conventional machining
Colour ring	without
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
Oil	suitable		
wet maximum	suitable only under restricted conditions		