

Garant
Machine tap, TiCN, M: M8

Order data

Order number	135320 M8
GTIN	4045197076496
Item class	11H

Description
Version:

With strong right-hand chip flutes, for optimum swarf evacuation.

For use with **emulsion** (fat content minimum 8%).

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: M

Tool material: HSS E

Standard: DIN 371

Tolerance class: ISO 2 6H

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank \varnothing D_s: 8 mm

Shank square □: 6.2 mm

Tapping hole \varnothing : 6.8 mm

Technical description

Thread pitch	1.25 mm
Number of cutting edges Z	3
Thread \varnothing	8 mm
Tapping hole \varnothing	6.8 mm
Number of clamping slots	3
Standard	DIN 371
Shank \varnothing D _s	8 mm

Overall length L	90 mm
Shank square □	6.2 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	16 mm
Thread type	M
Thread size	M8
Coating	TiCN
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 2xD for blind 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	3 m/min	H
Oil	suitable		

wet maximum

suitable