

**Garant**
**Machine tap HSS-E-PM Form B, uncoated, M: M8**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 131280 M8     |
| GTIN         | 4045197069436 |
| Item class   | 11H           |

**Description**
**Version:**
**With spiral point.**
**Advantage:**

Greater wear resistance.

Thread type: M

Tool material: HSS E PM

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  $\square$ : 6.2 mm

 Tapping hole  $\varnothing$ : 6.8 mm

**Technical description**

|                            |         |
|----------------------------|---------|
| Number of cutting edges Z  | 3       |
| Number of clamping slots   | 3       |
| Tapping hole $\varnothing$ | 6.8 mm  |
| Thread pitch               | 1.25 mm |
| Thread $\varnothing$       | 8 mm    |
| Standard                   | DIN 371 |
| Shank $\varnothing D_s$    | 8 mm    |
| Overall length L           | 90 mm   |

|                                       |  |
|---------------------------------------|--|
| Shank square <input type="checkbox"/> | 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°                                    |
| Thread standard                       | DIN 13                                 |
| Taper lead form                       | B                                      |
| Shank                                 | Plain shank with h9                    |
| Through-coolant                       | no                                     |
| Application for type of drilling      | up to 3×D for through 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

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restricted conditions