

**Garant****Machine tap, uncoated, UNC: 1-8****Order data**

Order number	137860 1-8
GTIN	4045197080288
Item class	11H

**Description****Version:****Sturdy design, with 20° right-hand chip flutes. HSS****Application:****For UNC uniform coarse threads ASME – B1.1.****Technical description**

Number of clamping slots	4
Threads per inch	8
Thread Ø	25.4 mm
Number of cutting edges Z	4
Tapping hole Ø	22.25 mm
Thread pitch	3.175 mm
Standard	DIN 376
Tool material	HSS
Shank Ø D <sub>s</sub>	20 mm
Overall length L	160 mm
Shank square □	16 mm
Thread depth	50.8 mm
Thread type	UNC

Thread size	1-8 UNC
Coating	uncoated
Flank angle	60 degrees
Tolerance class	2B
Taper lead form	C
Helix angle	20 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2×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	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	15 m/min	P
Oil	suitable		
wet maximum	suitable only under restricted conditions		