

**Garant**
**Machine tap with interrupted thread, uncoated, M: M8**

**Order data**

Order number	131900 M8
GTIN	4045197070586
Item class	11H

**Description**
**Version:**
**Spiral point.**

With interrupted thread, this **reduces torque** and **improves distribution of the lubricant**.

**Advantage:**

**Particularly suitable for thin-walled components.** Low frictional resistance, thus no material deformation is caused.

**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<sub>s</sub>: 8 mm

Shank square □: 6.2 mm

Tapping hole  $\varnothing$ : 6.8 mm

**Technical description**

Thread $\varnothing$	8 mm
Thread pitch	1.25 mm
Number of clamping slots	3
Tapping hole $\varnothing$	6.8 mm

Number of cutting edges Z	3
Standard	DIN 371
Shank $\varnothing D_s$	8 mm
Overall length L	90 mm
Shank square $\square$	6.2 mm
Tolerance class	ISO 2 6H
Tool material	HSS E
Thread depth	16 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 2×D for through 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
Aluminium (short chipping)	suitable only under restricted conditions	13 m/min	N
Alu > 10% Si	suitable	13 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	P

Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	6 m/min	P
TOOLOX 33	suitable	3 m/min	H
CuZn	suitable	13 m/min	N
Oil	suitable		
wet maximum	suitable only under restricted conditions		