

**Garant**
**Machine tap, uncoated, M: M8**

**Order data**

Order number	131950 M8
GTIN	4045197070920
Item class	11H

**Description**
**Version:**
**Sturdy version.**
**Recommendation:**

For **TOOLOX** and **HARDOX 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 2X 6HX

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 cutting edges Z	4
Number of clamping slots	4
Tapping hole $\varnothing$	6.8 mm
Standard	DIN 371
Shank $\varnothing$ D <sub>s</sub>	8 mm

Overall length L	90 mm
Shank square □	6.2 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E
Thread depth	12 mm
Thread type	M
Thread size	M8
Coating	uncoated
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 1.5×D for through holes
Application for type of drilling	up to 1.5×D 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 <sub>c</sub>	ISO code
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
Steel < 1400 N/mm <sup>2</sup>	suitable	3 m/min	P
TOOLOX 33	suitable	4 m/min	H

TOOLOX 44	suitable only under restricted conditions	3 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable only under restricted conditions	3 m/min	H
Oil	suitable		
wet maximum	suitable only under restricted conditions		