

**Garant**
**Solid carbide machine tap, TiAlN, M: M8**

**Order data**

Order number	132080 M8
GTIN	4045197071071
Item class	11H

**Description**
**Version:**

Particularly **sturdy version**. For the highest performance demands.

**Application:**

For use only with a length compensation chuck – even on machines with synchronised spindle drives.

**Recommendation:**

For **very hard steels, 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: solid carbide

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**

Tapping hole $\varnothing$	6.8 mm
Thread pitch	1.25 mm
Number of clamping slots	5
Number of cutting edges Z	5
Thread $\varnothing$	8 mm

Standard	DIN 371
Shank $\varnothing D_s$	8 mm
Overall length L	90 mm
Shank square $\square$	6.2 mm
Tolerance class	ISO 2X 6HX
Tool material	solid carbide
Thread depth	16 mm
Thread type	M
Thread size	M8
Coating	TiAlN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	D
Shank	Parallel shank to h6
Through-coolant	no
Application for type of drilling	up to 2×D for blind holes
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
Steel < 55 HRC	suitable	3 m/min	H
Steel < 60 HRC	suitable	2 m/min	H
Steel < 65 HRC	suitable only under restricted conditions	1 m/min	H

Steel < 67 HRC	suitable only under restricted conditions	1 m/min	H
TOOLOX 33	suitable	5 m/min	H
TOOLOX 44	suitable	4 m/min	H
HARDOX 500 < 1600 N/mm <sup>2</sup>	suitable	3 m/min	H
Graphite, GRP, CRP	suitable only under restricted conditions	18 m/min	N
Oil	suitable		