

Garant
Through hole machine tap with interrupted thread HSS-E-PM, uncoated, M: M8

Order data

Order number	132400 M8
GTIN	4045197071446
Item class	11H

Description
Version:

Sturdy design with 15° left-hand spiral. With interrupted thread, this **reduces torque** and **improves distribution of the lubricant.**

Particularly suitable for **titanium alloys** and **pure titanium.**

Advantage:

Ideally suited for use on resilient materials and thin-walled components. Low frictional resistance, thus no material deformation is caused.

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank Ø D_s: 8 mm

Shank square □: 6.2 mm

Tapping hole Ø: 6.8 mm

Technical description

Thread pitch	1.25 mm
Tapping hole Ø	6.8 mm
Number of clamping slots	3
Number of cutting edges Z	3
Thread Ø	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	HSS E PM
Thread depth	16 mm
Thread type	M
Thread size	M8
Coating	uncoated
Flank angle	60°
Thread standard	DIN 13
Taper lead form	D
Helix angle	15°
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	pink
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	15 m/min	N
Alu > 10% Si	suitable only under restricted conditions	15 m/min	N
Steel < 900 N/mm ²	suitable only under restricted conditions	18 m/min	P

Steel < 1100 N/mm ²	suitable	9 m/min	P
Steel < 1400 N/mm ²	suitable	3 m/min	P
Ti > 850 N/mm ²	suitable	4 m/min	S
Oil	suitable		
wet maximum	suitable		