

## Garant

### GARANT Master Form Steel fluteless machine tap with oil grooves HSS-E-PM IC, TiAlN, MF: 8X1



#### Order data

Order number	139290 8X1
GTIN	4062406383947
Item class	111

#### Description

##### Version:

##### GARANT Master Form Steel:

The latest generation of **high-performance fluteless taps** are specially developed for **use in steels**.

- **Optimised polygon geometry for a reduced torque.**
- **Multi-layer HIPIMS coating for high wear resistance.**
- **HSS-E-PM substrate for top process reliability.**

<strong>DIN 2174</strong> (≈ <strong>DIN 371</strong> ≤ M10; <strong>DIN 376</strong> ≥ M12).

With internal coolant feed laterally from the grooves. Permits the longest possible tool life when machining through holes and blind holes.

Tolerance class: ISO 2X 6HX

Thread pitch: 1 mm

Overall length L: 90 mm

Shank Ø D<sub>s</sub>: 8 mm

Shank square □: 6.2 mm

Tapping hole Ø guide value: 7.55 mm

#### Technical description

Tolerance class	ISO 2X 6HX
Thread size	M8×1
Thread Ø	8 mm
Shank Ø D <sub>s</sub>	8 mm

Series	GARANT Master
Tapping hole $\varnothing$ guide value	7.55 mm
Thread depth	24 mm
Number of cutting edges Z	5
Shank square $\square$	6.2 mm
Overall length L	90 mm
Number of clamping slots	5
Thread pitch	1 mm
Coating	TiAlN
Thread type	MF
Flank angle	60 °
Tool material	HSS E PM
Standard	DIN 2174
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	yes
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	without
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	42 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	38 m/min	P

Steel < 900 N/mm <sup>2</sup>	suitable	29 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	15 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	M
CuZn	suitable only under restricted conditions	25 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		