

**Garant**
**Fluteless machine tap with oil grooves extra long HSS-E-PM Form C 6HX, TiAlN, M: M8**

**Order data**

Order number	139208 M8
GTIN	4062406383718
Item class	111

**Description**
**Version:**

The latest generation of **high-performance fluteless taps**, specially developed for **use in steel materials**.

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

**Tolerance class: ISO 2X/6HX.**

With extra long shank.

**Advantage:**

Ideal for thread forming where access is difficult.

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 180 mm

Shank  $\varnothing$  D<sub>s</sub>: 8 mm

Shank square □: 6.2 mm

Tapping hole  $\varnothing$  guide value: 7.45 mm

**Technical description**

Tapping hole $\varnothing$ guide value	7.45 mm
Thread pitch	1.25 mm
Thread depth	24 mm
Overall length L	180 mm
Number of cutting edges Z	5

Series	GARANT Master
Shank square □	6.2 mm
Thread Ø	8 mm
Shank Ø D <sub>s</sub>	8 mm
Tolerance class	ISO 2X 6HX
Thread size	M8
Number of clamping slots	5
Coating	TiAlN
Thread type	M
Flank angle	60°
Tool material	HSS E PM
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
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	34 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	33 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	24 m/min	P

Steel < 1100 N/mm <sup>2</sup>	suitable	16 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	10 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
CuZn	suitable	20 m/min	N
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		