

Garant
Machine tap for synchronised spindles HSS-E-PM Form C, TiAlN, M: M8

Order data

Order number	132555 M8
GTIN	4045197585288
Item class	11H

Description
Version:

Sturdy design with shank to DIN 1835-B. Special geometry for use on machines with **synchronised spindle drives**. The tap is controlled by the synchronising spindle of the machine. **Special TiAlN coating for optimum tool life.** For use with **emulsion** (fat content minimum 8 %).

Also outstandingly suitable for **bainite cast iron (ADI)**.

Note:

For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures maximum process reliability.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank $\varnothing D_s$: 8 mm

Shank square \square : 6.2 mm

Tapping hole \varnothing : 6.8 mm

Technical description

Thread pitch	1.25 mm
Number of clamping slots	4
Thread \varnothing	8 mm
Number of cutting edges Z	4

Tapping hole \varnothing	6.8 mm
Standard	Manufacturer's standard
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	20 mm
Thread type	M
Thread size	M8
Coating	TiAlN
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Shank	DIN 1835 B with h6
Through-coolant	no
Application for type of drilling	up to 2xD for blind holes
Application for type of drilling	up to 2.5xD for through holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	white
Type of product	Tap

User data

	Suitability	V_c	ISO code
GJS, ADI > 800N/mm ²	suitable	20 m/min	K
wet maximum	suitable		

wet minimum	suitable only under restricted conditions
Air	suitable only under restricted conditions