

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

**Order data**

Order number	139175 M8
GTIN	4045197509017
Item class	11H

**Description**
**Version:**

**DIN 2174** ( $\approx$  DIN 371  $\leq$  M10;  $\approx$  DIN 376  $\geq$  M12). **With oil grooves; optimum lubrication effect even in deeper threads.**

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

The **innovative polygon form** permits a wide application spectrum. The **multi-function layer structure** achieves **maximum service life** even in **high-tensile materials**.

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  $\varnothing$  guide value: 7.45 mm

**Technical description**

Number of cutting edges Z	5
Thread pitch	1.25 mm
Number of clamping slots	5
Thread $\varnothing$	8 mm
Shank $\varnothing D_s$	8 mm
Shank square $\square$	6.2 mm
Overall length L	90 mm
Tapping hole $\varnothing$ guide value	7.45 mm

Tolerance class	ISO 2X 6HX
Thread depth	24 mm
Thread size	M8
Coating	TiN
Thread type	M
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	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	blue
Type of product	Fluteless tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	17 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	7 m/min	M
CuZn	suitable only under restricted conditions	22 m/min	N
Oil	suitable		

wet maximum

suitable