

**Garant**
**GARANT Master Tap machine tap HSS-E-PM Form C 6H+0.1, AlTiX, M: M8**

**Order data**

Order number	136164 M8
GTIN	4062406718916
Item class	11I

**Description**
**Version:**

**Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

**Tolerance class: ISO 2/6H+0.1**

**Application:**

For components which are galvanised or shrink slightly when hardened.

**Recommendation:**

We recommend increasing the size of the tapping hole  $\varnothing$  by the tolerance allowance.

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2 6H + 0.1

Thread pitch: 1.25 mm

Overall length L: 90 mm

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

Shank square □: 6.2 mm

Tapping hole  $\varnothing$ : 6.8 mm

**Technical description**

Overall length L	90 mm
Thread depth	20 mm
Tolerance class	ISO 2 6H + 0.1
Thread pitch	1.25 mm

Shank $\varnothing D_s$	8 mm
Thread size	M8
Tool material	HSS E PM
Thread $\varnothing$	8 mm
Number of clamping slots	3
Standard	DIN 371
Number of cutting edges Z	3
Thread type	M
Tapping hole $\varnothing$	6.8 mm
Shank square $\square$	6.2 mm
Coating	AlTiX
Flank angle	60°
Thread standard	DIN 13
Taper lead form	C
Helix angle	40°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	30 m/min	N
Aluminium (short chipping)	suitable	35 m/min	N

Alu > 10% Si	suitable	20 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	10 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M
GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		