

Garant

GARANT Master Tap machine tap HSS-E-PM extra long Form B 6HX DIN 376, AlTiX, M: M8



Order data

Order number	132738 M8
GTIN	4062406719043
Item class	111

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.**

All sizes with shank to DIN 376 (= **shank Ø tapered**). Therefore suitable for greater operating depths.

Advantage:

Designed for tapping threads where access is difficult.

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: 180 mm

Shank Ø D_s: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø: 6.8 mm

Technical description

Thread size	M8
Standard	Manufacturer's standard
Thread depth	24 mm
Thread pitch	1.25 mm

Number of clamping slots	3
Tool material	HSS E PM
Tapping hole \varnothing	6.8 mm
Overall length L	180 mm
Shank $\varnothing D_s$	6 mm
Thread \varnothing	8 mm
Thread type	M
Number of cutting edges Z	3
Shank square \square	4.9 mm
Tolerance class	ISO 2X 6HX
Coating	AlTiX
Flank angle	60°
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through 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	24 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N
Alu > 10% Si	suitable	16 m/min	N

Steel < 500 N/mm ²	suitable	24 m/min	P
Steel < 750 N/mm ²	suitable	24 m/min	P
Steel < 900 N/mm ²	suitable	20 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable	8 m/min	M
INOX > 900 N/mm ²	suitable	6 m/min	M
GG(G)	suitable	16 m/min	K
CuZn	suitable	16 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		