

**Garant**
**GARANT Master Tap Alu machine tap, DLC, MF: 8X1**

**Order data**

Order number	136230 8X1
GTIN	4067263830573
Item class	11I

**Description**
**Version:**

**High-performance tap**, specially developed for **aluminium and non-ferrous alloys**. **Dynamic helical pitch** of the clamping slots ensure **optimum chip evacuation** and **process reliability**.

- **HSS-E-PM tool material – for high cutting edge stability.**
- **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up.**
- **Dynamic helical pitch of the flutes**
- **Short lead chamfer form E**

**Technical description**

Thread type	M
Tool material	HSS E PM
Overall length L	90 mm
Thread Ø	8 mm
Thread depth	24 mm
Thread size	M8×1
Thread pitch	1 mm
Standard	Works standard
Number of clamping slots	3
Shank Ø D <sub>s</sub>	6 mm
Shank square □	4.9 mm
Number of cutting edges Z	3

Tolerance class	ISO 2X 6HX
Tapping hole Ø	7 mm
Coating	DLC
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	E
Helix angle	45 degrees
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Helix angle characteristic	unequal spacing
Colour ring	yellow
Series	Master Tap
Type of product	Taps

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium	suitable	35 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N
Alu > 10% Si	suitable	20 m/min	N
PMMA acrylic	suitable only under restricted conditions	20 m/min	N
PA 66	suitable only under restricted conditions	18 m/min	N
PEEK	suitable	18 m/min	N
Cu	suitable	18 m/min	N
CuZn	suitable	25 m/min	N

Oil	suitable
wet maximum	suitable
wet minimum	suitable