

Garant
GARANT Master Tap machine tap HSS-E-PM 6GX, AlTiX, MF: 8X1

Order data

Order number	137161 8X1
GTIN	4067263106982
Item class	111

Description
Version:

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

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

Tolerance class: ISO 3X/6GX. For components which are **galvanised** or shrink slightly when hardened.

Technical description

Standard	DIN 374
Shank $\varnothing D_s$	6 mm
Thread pitch	1 mm
Number of cutting edges Z	3
Tapping hole \varnothing	7 mm
Shank square \square	4.9 mm
Overall length L	90 mm
Tool material	HSS E PM
Tolerance class	ISO 3X 6GX
Thread size	M8x1
Number of clamping slots	3

Thread depth	20 mm
Thread Ø	8 mm
Thread type	MF
Coating	AlTiX
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
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 ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	121 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M

INOX > 900 N/mm ²	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		