

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

Order number	132906 8X1
GTIN	4067263108467
Item class	11I

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 ISO3X/6GX. For components which are **galvanised** or shrink slightly when hardened.

Technical description

Thread type	MF
Shank square <input type="checkbox"/>	4.9 mm
Overall length L	90 mm
Number of clamping slots	3
Thread size	M8×1
Tolerance class	ISO 3X 6GX
Tool material	HSS E PM
Tapping hole Ø	7 mm
Thread Ø	8 mm
Thread pitch	1 mm
Thread depth	24 mm

Shank $\varnothing D_s$	6 mm
Standard	DIN 374
Number of cutting edges Z	3
Coating	AlTiX
Flank angle	60 degrees
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	Taps

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	12 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		