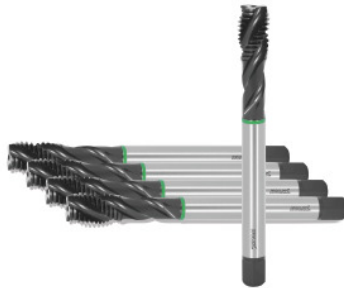


**Machine tap HSS-E Form C, vaporised, M: M8****Order data**

Order number	GG1856 M8
GTIN	4067263135388
Item class	GGN

**Description****Version:****Form C** (2–3 turns lead chamfer).**Same as No. 135855.****Technical description**

Thread size	M8
Standard	DIN 371
Thread depth	24 mm
Shank $\varnothing D_s$	8 mm
Thread pitch	1.25 mm
Thread $\varnothing$	8 mm
Overall length L	90 mm
Tolerance class	ISO 2 6H
Number of clamping slots	3
Tool material	HSS E

Number of cutting edges Z	3
Shank square □	6.2 mm
Thread type	M
Tapping hole Ø	6.8 mm
Coating	vaporised
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 3×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Type of product	Taps

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	11 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	4 m/min	M
CuZn	suitable only under restricted conditions	12 m/min	N

Uni	suitable
Oil	suitable

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## Accessories

Machine tapHSS-E Form C M M8	135855 M8
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