


**GARANT Vap Tap machine tap HSS-E Form C DIN 376, vaporised, M: M8**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 135810 M8     |
| GTIN         | 4069515002424 |
| Item class   | 13V           |

**Description**
**Version:**

**GARANT Vap Tap general-purpose tap.** Can be used **reliably** in a **wide range of materials**.

Optimised **neck and flute length** for **improved chip evacuation** when working on **deep** threads. High-performance **HSS-E tool material** with higher **vanadium content** for improved **wear resistance**. **Surface vaporised** for reduced edge build-up.

Shank **to DIN 376** (shank Ø relieved); thus suitable for greater operating depths.

**Form C** (2–3 turns lead chamfer).

**Technical description**

|                           |          |
|---------------------------|----------|
| Shank Ø D <sub>s</sub>    | 6 mm     |
| Tapping hole Ø            | 6.8 mm   |
| Tolerance class           | ISO 2 6H |
| Thread depth              | 24 mm    |
| Thread type               | M        |
| Overall length L          | 90 mm    |
| Number of cutting edges Z | 3        |
| Shank square □            | 4.9 mm   |
| Number of clamping slots  | 3        |
| Standard                  | DIN 376  |
| Thread Ø                  | 8 mm     |
| Thread pitch              | 1.25 mm  |

## Data sheet

|                                  |                                   |
|----------------------------------|-----------------------------------|
| Thread size                      | M8                                |
| Tool material                    | HSS E                             |
| 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                             |
| Series                           | Vap Tap                           |
| Type of product                  | Taps                              |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|-------------------------------------------|----------------|----------|
| Alu plastics                   | suitable                                  | 18 m/min       | N        |
| Aluminium (short chipping)     | suitable                                  | 13 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 18 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 15 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 15 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 6 m/min        | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 6 m/min        | M        |
| CuZn                           | suitable only under restricted conditions | 15 m/min       | N        |
| Uni                            | suitable                                  |                |          |

Data sheet

|             |          |
|-------------|----------|
| Oil         | suitable |
| wet maximum | suitable |