

**Garant****GARANT Vap Tap machine tap HSS-E Form E, vaporised, M: M8****Order data**

Order number	135815 M8
GTIN	4069515002479
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.

**Form E** (1.5–2 turns lead chamfer).

**Technical description**

Standard	DIN 371
Thread Ø	8 mm
Number of cutting edges Z	3
Thread pitch	1.25 mm
Tool material	HSS E
Overall length L	90 mm
Shank square □	6.2 mm
Thread size	M8
Shank Ø D <sub>s</sub>	8 mm
Thread type	M
Tapping hole Ø	6.8 mm
Thread depth	24 mm

## Data sheet

Tolerance class	ISO 2 6H
Number of clamping slots	3
Coating	vaporised
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	E
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