

Garant
Machine tap HSS-E-PM, TiN / vaporised, MF: 8X1

Order data

Order number	136290 8X1
GTIN	4045197883537
Item class	11H

Description
Version:

With special TiN coating and vaporised cutting surfaces.

For controlled swarf evacuation and avoidance of clogging.

Especially suitable for problem materials.

For use with **emulsion** (fat content minimum 8%).

Recommendation:

For **TOOLOX materials we recommend deviating from the DIN data** (see table) by drilling the tapping hole \varnothing **0.05 to 0.3 mm** larger.

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2 6H

Thread pitch: 1 mm

Overall length L: 90 mm

Shank \varnothing D_s: 6 mm

Shank square □: 4.9 mm

Tapping hole \varnothing : 7 mm

Technical description

Overall length L	90 mm
Standard	DIN 374
Thread \varnothing	8 mm
Tapping hole \varnothing	7 mm
Tolerance class	ISO 2 6H

Number of cutting edges Z	3
Tool material	HSS E PM
Thread pitch	1 mm
Shank square □	4.9 mm
Number of clamping slots	3
Shank Ø D _s	6 mm
Thread depth	24 mm
Thread type	MF
Thread size	M8×1
Coating	TiN / vaporised
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 °
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	red
Type of product	Tap

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	27 m/min	P
Steel < 750 N/mm ²	suitable	23 m/min	P
Steel < 900 N/mm ²	suitable	23 m/min	P
Steel < 1100 N/mm ²	suitable	13 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P

TOOLOX 33	suitable	12 m/min	H
Ti > 850 N/mm ²	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		