

**Garant**
**Machine taps extra long HSS-E-PM, TiAlN, M: M8**

**Order data**

Order number	134655 M8
GTIN	4045197705167
Item class	11H

**Description**
**Version:**
**With extra long shank.**

Special **TiAlN coating**, highly suitable for **aluminium alloys**.

**All sizes: Shank to DIN 376 (= shank Ø relieved)**, outstandingly suitable for use up to great depths.

**Advantage:**

Designed **for tapping threads where access is difficult**.

**Application:**

Suitable for materials with tensile strength **up to maximum 450N/mm<sup>2</sup>**.

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2 6H

Thread pitch: 1.25 mm

Overall length L: 140 mm

Shank Ø D<sub>s</sub>: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø: 6.8 mm

**Technical description**

Thread Ø	8 mm
Number of cutting edges Z	3
Number of clamping slots	3
Thread pitch	1.25 mm
Tapping hole Ø	6.8 mm

Standard	Manufacturer's standard
Shank $\varnothing D_s$	6 mm
Overall length L	140 mm
Shank square $\square$	4.9 mm
Tolerance class	ISO 2 6H
Tool material	HSS E PM
Thread depth	24 mm
Thread type	M
Thread size	M8
Coating	TiAlN
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	yellow
Type of product	Tap

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	28 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N
Alu > 10% Si	suitable	23 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	27 m/min	P

CuZn	suitable only under restricted conditions	28 m/min	N
Oil	suitable		
wet maximum	suitable		