

Garant
GARANT Master Tap machine tap HSS-E-PM Form E 6HX, AlTiX, M: M8

Order data

Order number	136152 M8
GTIN	4045197900241
Item class	111

Description
Version:

Universal taps, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

Form E (1.5-2 turns lead chamfer)

Thread type: M

Tool material: HSS E PM

Standard: DIN 371

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank $\varnothing D_s$: 8 mm

Shank square \square : 6.2 mm

Tapping hole \varnothing : 6.8 mm

Technical description

Standard	DIN 371
Number of cutting edges Z	3
Thread \varnothing	8 mm
Shank square \square	6.2 mm
Tool material	HSS E PM
Number of clamping slots	3

Tapping hole Ø	6.8 mm
Shank Ø D _s	8 mm
Tolerance class	ISO 2X 6HX
Thread pitch	1.25 mm
Overall length L	90 mm
Thread depth	20 mm
Thread type	M
Thread size	M8
Coating	AlTiX
Flank angle	60°
Thread standard	DIN 13
Taper lead form	E
Helix angle	40°
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	22 m/min	N
Aluminium (short chipping)	suitable	25 m/min	N
Alu > 10% Si	suitable	15 m/min	N
Steel < 500 N/mm ²	suitable	22 m/min	P

Steel < 750 N/mm ²	suitable	22 m/min	P
Steel < 900 N/mm ²	suitable	18 m/min	P
Steel < 1100 N/mm ²	suitable	8 m/min	P
Steel < 1400 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable	7 m/min	M
INOX > 900 N/mm ²	suitable	6 m/min	M
GG(G)	suitable	15 m/min	K
CuZn	suitable	15 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		