



Value pack machine tap Form C



Order data

| | |
|--------------|---------------|
| Order number | GG1855 M8 |
| GTIN | 4045197735119 |
| Item class | GGN |

Description

Version:

Form C (2–3 turns lead chamfer).

Same as No. 135855.

Technical description

| | |
|------------------------|----------|
| Standard | DIN 371 |
| Tool material | HSS E |
| Shank Ø D _s | 8 mm |
| Tolerance class | ISO 2 6H |
| Overall length L | 90 mm |
| Tapping hole Ø | 6.8 mm |
| Shank square □ | 6.2 mm |
| Thread pitch | 1.25 mm |
| Thread type | M |
| Thread size | M8 |
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Data sheet

| | |
|----------------------------------|-----------------------------------|
| Coating | vaporised |
| Flank angle | 60 degrees |
| Thread standard | DIN 13 |
| Taper lead form | C |
| Helix angle | 40 degrees |
| Shank | Plain shank with h9 |
| 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 |
| Type of product | Tap |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 11 m/min | N |
| Steel < 500 N/mm ² | suitable only under restricted conditions | 12 m/min | P |
| Steel < 750 N/mm ² | suitable | 8 m/min | P |
| Steel < 900 N/mm ² | suitable | 7 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 4 m/min | P |
| INOX < 900 N/mm ² | suitable | 4 m/min | M |
| CuZn | suitable only under restricted conditions | 12 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/GG1855-M8>