



## 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 <sub>s</sub>	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
Contents	10

## 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 3xD for blind holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Type of product	Tap

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Aluminium (short chipping)	suitable only under restricted conditions	11 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	7 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	4 m/min	P
INOX < 900 N/mm <sup>2</sup>	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>