

Garant**GARANT Master Form Steel fluteless machine tap with oil grooves extra long HSS-E-PM Form C 6HX, TiAlN, M: M8****Order data**

Order number	139208 M8
GTIN	4062406383718
Item class	11I

Description**Version:****Tolerance class: ISO 2X/6HX.**

The latest generation of **high-performance fluteless taps**, specially developed for **use in steel materials**.

- **Optimised polygon geometry for a lower torque.**
- **Multi-layer HIPIMS coating for high wear resistance.**
- **HSS-E-PM substrate for exceptional process reliability.**

With extra long shank.

Advantage:

Ideal for thread forming where access is difficult.

Technical description

Tapping hole Ø guide value	7.45 mm
Thread pitch	1.25 mm
Thread depth	24 mm
Overall length L	180 mm
Number of cutting edges Z	5
Series	GARANT Master
Shank square □	6.2 mm
Thread Ø	8 mm
Shank Ø D _s	8 mm

Data sheet

Tolerance class	ISO 2X 6HX
Thread size	M8
Number of clamping slots	5
Coating	TiAlN
Thread type	M
Flank angle	60 degrees
Tool material	HSS E PM
Standard	Manufacturer's standard
Thread standard	DIN 13
Taper lead form	C
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for blind holes
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Colour ring	without
Type of product	Fluteless tap

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable	34 m/min	N
Steel < 500 N/mm ²	suitable	33 m/min	P
Steel < 750 N/mm ²	suitable	32 m/min	P
Steel < 900 N/mm ²	suitable	24 m/min	P
Steel < 1100 N/mm ²	suitable	16 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P
INOX < 900 N/mm ²	suitable	10 m/min	M
CuZn	suitable	20 m/min	N

Oil	suitable
wet maximum	suitable
wet minimum	suitable