

Garant
GARANT Master Tap Alu machine tap extra long, DLC, M: M8

Order data

Order number	134265 M8
GTIN	4067263830481
Item class	11I

Description
Version:

With extra long shank.

High-performance tap, specially developed for **aluminium and non-ferrous alloys**. **Dynamic helical pitch** of the clamping slots ensure **optimum chip evacuation** and **process reliability**.

- **HSS-E-PM tool material – for high cutting edge stability.**
- **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up.**
- **Dynamic helical pitch of the flutes.**
- **Short lead chamfer form E.**

Technical description

Thread Ø	8 mm
Shank square □	6.2 mm
Shank Ø D _s	8 mm
Standard	Works standard
Thread type	M
Thread pitch	1.25 mm
Thread depth	24 mm
Tool material	HSS E PM
Tapping hole Ø	6.8 mm
Overall length L	180 mm
Number of clamping slots	3

Number of cutting edges Z	3
Tolerance class	ISO 2X 6HX
Coating	DLC
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	E
Helix angle	45 degrees
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
Helix angle characteristic	unequal spacing
Colour ring	yellow
Series	Master Tap
Type of product	Taps

User data

	Suitability	V _c	ISO code
Aluminium	suitable	35 m/min	N
Aluminium (short chipping)	suitable	32 m/min	N
Alu > 10% Si	suitable	20 m/min	N
PMMA acrylic	suitable only under restricted conditions	20 m/min	N
PA 66	suitable only under restricted conditions	18 m/min	N
PEEK	suitable	18 m/min	N
Cu	suitable	18 m/min	N
CuZn	suitable	25 m/min	N

Oil	suitable
wet maximum	suitable
wet minimum	suitable