

Garant
Synchronised fluteless machine tap with oil grooves HSS-E-PM Form E, TiN, M: M8

Order data

| | |
|--------------|---------------|
| Order number | 139215 M8 |
| GTIN | 4045197509437 |
| Item class | 11H |

Description
Version:

Special polygon geometry and shank to DIN 1835-B for machines with **synchronised spindle drive. With oil grooves; optimal lubrication effect even in deeper threads.**

The **innovative polygon form** permits a wide application spectrum. The **multi-function layered coating** achieves **maximum service life** even in **high-tensile materials** in **fixed** applications.

Form E (lead-in: 1.5 – 2 turns) **for deep threads with short run-out.**

Note:

For use on synchronised spindles, the **GARANT** quick-change tapping chuck **No. 338100 – 338121 with minimum length adjustment (MLA)** ensures the highest process reliability.

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 guide value: 7.45 mm

Technical description

| | |
|---------------------------|---------|
| Number of cutting edges Z | 5 |
| Thread pitch | 1.25 mm |
| Thread \varnothing | 8 mm |
| Number of clamping slots | 5 |
| Shank $\varnothing D_s$ | 8 mm |

| | |
|----------------------------------|-------------------------------|
| Shank square □ | 6.2 mm |
| Overall length L | 90 mm |
| Tapping hole Ø guide value | 7.45 mm |
| Tolerance class | ISO 2X 6HX |
| Thread depth | 20 mm |
| Thread size | M8 |
| Coating | TiN |
| Thread type | M |
| Flank angle | 60 ° |
| Tool material | HSS E PM |
| Standard | Manufacturer's standard |
| Thread standard | DIN 13 |
| Taper lead form | E |
| Shank | DIN 1835 B with h6 |
| Through-coolant | no |
| Application for type of drilling | up to 2×D for blind holes |
| Application for type of drilling | up to 2.5×D for through holes |
| Cutting direction | right-hand |
| Shank tolerance | h6 |
| Colour ring | green |
| Type of product | Fluteless tap |

User data

| | Suitability | V _c | ISO code |
|----------------------------|---|----------------|----------|
| Alu plastics | suitable | 45 m/min | N |
| Aluminium (short chipping) | suitable | 45 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 40 m/min | N |

| | | | |
|--------------------------------|---|----------|---|
| Steel < 500 N/mm ² | suitable | 45 m/min | P |
| Steel < 750 N/mm ² | suitable | 37 m/min | P |
| Steel < 900 N/mm ² | suitable | 35 m/min | P |
| Steel < 1100 N/mm ² | suitable | 32 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 22 m/min | P |
| INOX < 900 N/mm ² | suitable | 10 m/min | M |
| CuZn | suitable only under restricted conditions | 35 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |