

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

**Order data**

Order number	131115 M8
GTIN	4067263830030
Item class	111

**Description**
**Version:**

**High-performance tap**, specially developed for **aluminium and non-ferrous alloys**. **Extra-long clamping slots** and neck length for usable **thread depth up to 4xD**.

- **HSS-E-PM tool material for high cutting edge stability.**
- **Ultra-smooth DLC coating for wear resistance and avoidance of edge build-up.**
- **Extra-long flute geometry.**

With extra long shank.

**Technical description**

Thread Ø	8 mm
Thread type	M
Tool material	HSS E PM
Number of clamping slots	3
Thread pitch	1.25 mm
Number of cutting edges Z	3
Thread depth	28 mm
Tapping hole Ø	6.8 mm
Thread size	M8
Shank Ø D <sub>s</sub>	8 mm
Tolerance class	ISO 2X 6HX
Shank square □	6.2 mm

Standard	Works standard
Overall length L	180 mm
Coating	DLC
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 4×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	yellow
Series	Master Tap
Type of product	Taps

## User data

	Suitability	V <sub>c</sub>	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