

Garant**GARANT Master Tap INOX machine tap HSS-E-PM, TiAlN, MF: 8X0,75****Order data**

Order number	137053 8X0,75
GTIN	4062406081706
Item class	11I

Description**Version:****GARANT Master Tap INOX:**

High-performance tap, specially developed for **good process reliability in stainless and acid-resistant steels** and **duplex materials**.

The 45° helix angle of the flutes facilitates chip formation especially in ductile austenitic CrNi steels.

- **HSS-E-PM tool material for a high degree of wear resistance**
- **The latest generation of TiAlN multi-layer coating**
- **Parameterised flute geometry for optimum chip formation and torsional rigidity**

Thread type: MF

Tool material: HSS E PM

Standard: DIN 374

Tolerance class: ISO 2X 6HX

Thread pitch: 0.75 mm

Overall length L: 80 mm

Shank Ø D_s: 6 mm

Shank square □: 4.9 mm

Tapping hole Ø: 7.2 mm

Technical description

Tapping hole Ø	7.2 mm
Thread depth	20 mm
Number of cutting edges Z	3
Thread Ø	8 mm

Tolerance class	ISO 2X 6HX
Overall length L	80 mm
Number of clamping slots	3
Thread type	MF
Tool material	HSS E PM
Shank square $\square$	4.9 mm
Thread pitch	0.75 mm
Standard	DIN 374
Shank $\varnothing D_s$	6 mm
Thread size	M8x0.75
Coating	TiAlN
Flank angle	60 °
Thread standard	DIN 13
Taper lead form	C
Helix angle	45 °
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3xD for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	blue
Series	Master Tap
Type of product	Tap

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	28 m/min	N

Steel < 750 N/mm ²	suitable only under restricted conditions	23 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	23 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
INOX < 900 N/mm ²	suitable	11 m/min	M
INOX > 900 N/mm ²	suitable	9 m/min	M
Oil	suitable		
wet maximum	suitable		