

**Garant**
**Machine tap for synchronised spindles HSS-E-PM IC / Form C, TiAlN, M: M8**

**Order data**

Order number	135420 M8
GTIN	4045197507983
Item class	11H

**Description**
**Version:**

**Sturdy version with right-hand helix and shank to DIN 1835-B.** Special geometry for use on machines with **synchronised spindle drives**. The tap is guided by the synchronised spindle on the machine. Special **TiAlN-S coating** for optimum tool life. For use with **emulsion** (fat content minimum 8%).

With **internal coolant supply** for maximum tool life.

**Recommendation:**

For **TOOLOX materials** we recommend **deviating from the DIN** data (see table) by drilling the tapping hole  $\varnothing$  **0.05 to 0.3mm** larger.

**Note:**

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

Thread type: M

Tool material: HSS E PM

Standard: Manufacturer's standard

Tolerance class: ISO 2X 6HX

Thread pitch: 1.25 mm

Overall length L: 90 mm

Shank  $\varnothing$  D<sub>s</sub>: 8 mm

Shank square □: 6.2 mm

Tapping hole  $\varnothing$ : 6.8 mm

**Technical description**

Thread pitch	1.25 mm
Number of cutting edges Z	3
Tapping hole $\varnothing$	6.8 mm

Thread Ø	8 mm
Number of clamping slots	3
Standard	Manufacturer's standard
Shank Ø D <sub>s</sub>	8 mm
Overall length L	90 mm
Shank square □	6.2 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Thread depth	20 mm
Thread type	M
Thread size	M8
Coating	TiAlN
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	C
Helix angle	40 degrees
Shank	DIN 1835 B to h6
Through-coolant	yes
Application for type of drilling	up to 2.5×D for blind holes
Cutting direction	right-hand
Shank tolerance	h6
Type of threading tool	Machine tap for synchronous machining
Colour ring	red
Type of product	Tap