



# **800**X



High performance machine taps

The **800X** tap is developed version of a well-known over years on the market the 800 tap. Its construction is completely modified and makes possible machining of stainless steels. Innovative production technologies guaranties increased tool life and machining efficiency.

All of this features make the **800X** tap the best choice for short and medium production series and offers favorable ratio of price and quality.

## DESIGN



- Multilayer TN coating
- Cutting edges special microgeometry
- Increased clearance angle
- Tapered end of working part
- Special design of divergent spiral flutes R40
- Highest quality HSSE steel
- h6 shank tolerance



## USER BENEFITS

- Up to 2x increased tool life and machining efficiency
- Stable machining and correct thread dimensions
- Better chip control
- Stable mounting
- Wide range of machined materials
- Favorable price/quality ratio

## CASE STUDY

During tests **MASTERSYNC** toolholder has been used.

**Tap: 800X M6 6H DIN-371 R40 HSSE TN**

	Steel C45(1.0503)	Stainless steel 0H18N9 (1.4301)	Aluminium PA6 (3.1325)
Workpiece material	Steel C45(1.0503)	Stainless steel 0H18N9 (1.4301)	Aluminium PA6 (3.1325)
Type of hole	blind hole	blind hole	blind hole
Depth	2xD 12mm	2xD 12mm	2xD 12mm
Cutting speed	Vc=10m/min	Vc=10m/min	Vc=25m/min
Number of holes	2700 <span style="border: 1px solid black; padding: 2px;">P</span>	1000 <span style="border: 1px solid black; padding: 2px;">M</span>	7000+ <span style="border: 1px solid black; padding: 2px;">N</span>

ISO metric thread DIN-13										<b>800X</b>						
										C-R40-TN	B-TN					
Material groups										P M K N S H	P M K N S H					
Hole type																
Type of material										HSSE	HSSE					
Coating										TN	TN					
Chamfer										C / 2-3P	B / 4-5P					
M	P	$l_1$	$l_2$	$l_2$	$l_3$	$d_2$	a		INDEX	DIN-371						
$d_1$				R40				$d_1$		C2-513X01	C2-113X01					
Tolerance										ISO2 (6H)	ISO2 (6H)					
M3	0,50	56	10	5	18	3,5	2,7	2,50	0030	●	●					
M4	0,70	63	12	7	21	4,5	3,4	3,30	0040	●	●					
M5	0,80	70	14	8	25	6,0	4,9	4,20	0050	●	●					
M6	1,00	80	18	10	30	6,0	4,9	5,00	0060	●	●					
M8	1,25	90	20	13	35	8,0	6,2	6,80	0080	●	●					
M10	1,50	100	20	15	39	10,0	8,0	8,50	0100	●	●					
MF	P	$l_1$	$l_2$	$l_2$	$l_3$	$d_2$	a		INDEX	DIN-371						
$d_1$				R40				$d_1$		C2-513X01	C2-113X01					
Tolerance										ISO2 (6H)	ISO2 (6H)					
M8x1	1,00	90	20	10		6,0	4,9	7,00	0083	●	●					
M10x1	1,00	90	20	13		7,0	5,5	9,00	0103	●	●					
M10x1,25	1,25	100	20	15		7,0	5,5	8,80	0104	●	●					
M	P	$l_1$	$l_2$	$l_2$	$l_3$	$d_2$	a		INDEX	DIN-376						
$d_1$				R40				$d_1$		D2-513X01	D2-113X01					
Tolerance										ISO2 (6H)	ISO2 (6H)					
M12	1,75	110	24	18		9,0	7,0	10,20	0120	●	●					
M14	2,00	110	25	20		11,0	9,0	12,00	0140	●	●					
M16	2,00	110	32	20		12,0	9,0	14,00	0160	●	●					
M18	2,50	125	32	25		14,0	11,0	15,50	0180	●	●					
M20	2,50	140	32	25		16,0	12,0	17,50	0200	●	●					
M22	2,50	140	32	25		18,0	14,5	19,50	0220	●	●					
M24	3,00	160	38	30		18,0	14,5	21,00	0240	●	●					
M27	3,00	160	38	30		20,0	16,0	24,00	0270	●	●					
M30	3,50	180	40	35		22,0	18,0	26,50	0300	●	●					
M33	3,50	180	45	35		25,0	20,0	29,50	0330	●	●					
M36	4,00	200	50	40		28,0	22,0	32,00	0360	●	●					
MF	P	$l_1$	$l_2$	$l_2$	$l_3$	$d_2$	a		INDEX	DIN-374						
$d_1$				R40				$d_1$		D2-513X01	D2-113X01					
Tolerance										ISO2 (6H)	ISO2 (6H)					
M12x1,5	1,50	100	20	5		9,0	7,0	10,50	0125	●	●					
M14x1,5	1,50	100	20	7		11,0	9,0	12,50	0145	●	●					
M16x1,5	1,50	100	20	8		12,0	9,0	14,50	0165	●	●					

Example of order

D2-511X01-0083  
800X M8x1 6H DIN-374 C R40 HSSE TN

● Available from stock



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