

Thread former with internal cooling radial HSSE-PM TiAlN MF ISO 2X (6HX) 0° 374 similar to C

For universal use up to 1300 N/mm²

ATORN®



Application

For producing fine, deep-set metric threads in through holes and blind holes on CNC or conventional machines in **steel, stainless steel and non-ferrous metals up to a strength of 1300 N/mm²**.

Advantage

- Innovative mould geometry ensures very high dimensional accuracy and process reliability.
- High-quality, torsion-resistant HSSE PM cutting material and surface finish for very high service life requirements.
- Cutting edge finish for very high service life requirements.

Application	Steel (N/mm ²)			Stainless steel		Alu		Brass		Bronze		Plas-tics	Graphite G(C)FK	GG(G) GjMW	Titan-alloy	Nickel-alloy	Super-alloy	Hard mat.	
	<700	<1000	<1300	marten.	austen.	short	long	short	long	short	long							<55 HRC	<65 HRC
	45	30	20	18	12	40	50	35	45	27	32								

Art. No.	13399 105
Surface	TiCN
Lead angle shape	C
Thread type	Metric fine thread
Thread type x nominal diameter	MF10
Pitch	1 mm
Cutting material	HSSE-PM
Core hole diameter	9.55 mm
Length	90 mm
Hole type	Clearance/blind hole ≤ 3xD
Shaft diameter	10 mm
Shank square	8 mm
Coolant supply	Internal radial
Tolerance of screw taps	ISO 2X (6HX)
Application type/machine type	CNC, Conventional
Cutting speed (steel 1000) suitability	1
Cutting speed (steel 1300) suitability	1
Overall stainless steel suitability	1
fitness not iron total	2
Cutting speed (cast) suitability	3
fitness Titan/Nickel/Super total	3
Cutting speed (hard 65) suitability	3
DIN	Similar to 374

EAN-Code

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