

Screw tap, HSSE M ISO 2 (6H) 15° (right) 376 C

for universal use up to 1000 N/mm²

ATORN[®]



Application

For producing metric threads on CNC machines or conventional machines in **blind holes** in the steel, (stainless steel), non-ferrous metals and (cast iron) material groups up to a strength of 1000 N/mm².

Version

- structural dimensions in accordance with: DIN 371 = reinforced shank (up to M10), DIN 376 = over-long shank (from M12)

Advantage

- good service life and process reliability thanks to innovative cutting geometry and universal use for the greatest flexibility in applications
- optimised geometry for lathes as stationary tool

Application	Steel (N/mm ²)			Stainless steel		Alu		Brass		Bronze		Plastics	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
	16	11		9		18	18	15	18	15	15	13		16					

Art. No.	13281 180
Type	P MAX 1000
Thread type	Metric thread
Thread type x nominal diameter	M18
Pitch	2.5 mm
Hole type	Blind hole ≤ 2.5xD
Cutting material	HSSE
Surface	Uncoated
Lead angle shape	C
Tolerance of screw taps	ISO 2 (6H)
Twist angle	15° (right)
Shaft diameter	14 mm
Application type/machine type	CNC, Conventional
Core hole diameter	15.5 mm
Coolant supply	External
Length	125 mm
Shank square	11 mm
Cutting speed (steel 1000) suitability	1
Cutting speed (steel 1300) suitability	3
Overall stainless steel suitability	3
fitness not iron total	1
fitness Titan/Nickel/Super total	3
Cutting speed (cast) suitability	2
Cutting speed (hard 55) suitability	3
Cutting speed (hard 65) suitability	3
DIN	376

EAN-Code

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