Screw tap, HSSE M ISO 2 (6H) 0° 371 B for universal use up to 1000 N/mm2



Application

For producing metric threads on CNC machines or conventional machines in **through 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)

good service life and process reliability thanks to innovative cutting geometry and universal use for the greatest flexibility in applications

Application	Steel (N/mm²)			Stainless steel		Alu		Brass				Plas-		GG(G)	Titan-			Hard mat.	
	<700	<1000	<1300	marten.	austen.	short	long	short	long	short	long	tics	G(C)FK	GjMW	alloy	alloy	alloy	<55 HRC	<65 HRC
	17	12		10		19	19	17	19	17	17	15		18					

Thread type	Art. No.	13113 014
Thread type x nominal diameter M1.4 Pitch 0.3 mm Clearance hole ≤ 3xD Cutting material HSSE Surface Vaporised Lead angle shape B Folerance of screw taps Folerance of screw taps Folerance of screw taps CNC, Conventional Core hole diameter Coolant supply Length Shank square Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability Fitness not iron total Fitness Titan/Nickel/Super total Cutting speed (hard 55) suitability Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Туре	P MAX 1000
Pitch 0.3 mm Clearance hole ≤ 3xD Cutting material HSSE Surface Vaporised Lead angle shape B Folerance of screw taps ISO 2 (6H) Twist angle 0° Shaft diameter 2.5 mm Application type/machine type CNC, Conventional Core hole diameter 1.1 mm Coolant supply External Length 40 mm Shank square 2.1 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 2 Cutting speed (hard 55) suitability 3	Thread type	Metric thread
Cutting material Cutting material Burface Lead angle shape B Tolerance of screw taps Iso 2 (6H) Twist angle Shaft diameter Application type/machine type Core hole diameter Coolant supply Length Shank square Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability Difference Total Infiness Titan/Nickel/Super total Cutting speed (hard 55) suitability 3	Thread type x nominal diameter	M1.4
Cutting material Surface Lead angle shape B Tolerance of screw taps ISO 2 (6H) Twist angle Shaft diameter Application type/machine type Core hole diameter Coolant supply Length Shank square Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability Times and iron total fitness Titan/Nickel/Super total Cutting speed (hard 55) suitability Cutting speed (hard 55) suitability Cutting speed (hard 55) suitability 3	Pitch	0.3 mm
Surface Vaporised Lead angle shape Tolerance of screw taps Tolerance of screw taps Twist angle Shaft diameter Shaft diameter Application type/machine type CNC, Conventional Core hole diameter Coolant supply External Length 40 mm Shank square Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3 Overall stainless steel suitability 3 Fitness not iron total fitness Titan/Nickel/Super total Cutting speed (hard 55) suitability 3	Hole type	Clearance hole ≤ 3xD
Lead angle shape Tolerance of screw taps Tolerance of screw taps Twist angle Shaft diameter Application type/machine type Core hole diameter Coolant supply Length Shank square Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability Titles not iron total Sitness Titan/Nickel/Super total Cutting speed (hard 55) suitability Cutting speed (hard 55) suitability Cutting speed (hard 55) suitability 3	Cutting material	HSSE
Tolerance of screw taps Tolerance of screw taps Twist angle Shaft diameter Application type/machine type CNC, Conventional Core hole diameter 1.1 mm Coolant supply External Length 40 mm Shank square 2.1 mm Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3 Overall stainless steel suitability fitness not iron total fitness Titan/Nickel/Super total Cutting speed (hard 55) suitability 3	Surface	Vaporised
Twist angle 0° Shaft diameter 2.5 mm Application type/machine type CNC, Conventional Core hole diameter 1.1 mm Coolant supply External Length 40 mm Shank square 2.1 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 55) suitability 3 Cutting speed (hard 55) suitability 3	Lead angle shape	В
Shaft diameter Application type/machine type CNC, Conventional Core hole diameter 1.1 mm Coolant supply External Length Shank square Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability Overall stainless steel suitability 3 Overall stainless steel suitability 3 Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Tolerance of screw taps	ISO 2 (6H)
Application type/machine type CNC, Conventional Core hole diameter 1.1 mm Coolant supply External Length 40 mm Shank square Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3 Overall stainless steel suitability 3 fitness not iron total fitness Titan/Nickel/Super total Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3 Cutting speed (hard 65) suitability 3	Twist angle	0°
Core hole diameter Coolant supply External Length 40 mm Shank square Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3 Overall stainless steel suitability 3 fitness not iron total fitness Titan/Nickel/Super total Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3	Shaft diameter	2.5 mm
Coolant supply Length 40 mm Shank square 2.1 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 Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Application type/machine type	CNC, Conventional
Length 40 mm Shank square 2.1 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 55) suitability 3 Cutting speed (hard 65) suitability 3	Core hole diameter	1.1 mm
Shank square Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability 3 Overall stainless steel suitability 3 fitness not iron total fitness Titan/Nickel/Super total Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Coolant supply	External
Cutting speed (steel 1000) suitability Cutting speed (steel 1300) suitability 3 Overall stainless steel suitability 3 fitness not iron total 1 fitness Titan/Nickel/Super total Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Length	40 mm
Cutting speed (steel 1300) suitability Overall stainless steel suitability 3 fitness not iron total 1 fitness Titan/Nickel/Super total Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Shank square	2.1 mm
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	Cutting speed (steel 1000) suitability	1
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	Cutting speed (steel 1300) suitability	3
Fitness Titan/Nickel/Super total 3 Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	Overall stainless steel suitability	3
Cutting speed (cast) suitability 2 Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	fitness not iron total	1
Cutting speed (hard 55) suitability 3 Cutting speed (hard 65) suitability 3	fitness Titan/Nickel/Super total	3
Cutting speed (hard 65) suitability 3	Cutting speed (cast) suitability	2
3-1	Cutting speed (hard 55) suitability	3
071	Cutting speed (hard 65) suitability	3
JIN 3/1	DIN	371

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