

## Screw tap, HSSE-PM Ultra HL (short cut E) M ISO 2X (6HX) 50° (right) 371

E

For universal use up to 1200 N/mm<sup>2</sup>

**ATORN**<sup>®</sup>



### Application

For manufacturing metric threads in **blind holes** on CNC or conventional machines in the steel, stainless steel, non-ferrous metal and cast iron material groups up to -1200 N/mm<sup>2</sup>

### Advantage

- Universal application for maximum flexibility
- Innovative cutting geometry ensures high process reliability even under difficult machining conditions
- Short cut shape E to cut slightly above base

| Application | Steel (N/mm <sup>2</sup> ) |       |       | 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 |
|             | 22                         | 16    | 12    | 12              | 12      | 14    | 30   | 17    | 24   | 12     | 20   | 30        | 16              | 18         | 7           | 6            | 6           |           |         |

|                                               |                    |
|-----------------------------------------------|--------------------|
| <b>Art. no.</b>                               | <b>13217 920</b>   |
| <b>Type</b>                                   | UNI MAX 45HL Speed |
| <b>Thread type</b>                            | Metric thread      |
| <b>Thread type x nominal diameter</b>         | M12                |
| <b>Pitch</b>                                  | 1.75 mm            |
| <b>Hole type</b>                              | Blind hole ≤ 3xD   |
| <b>Cutting material</b>                       | HSSE-PM            |
| <b>Surface</b>                                | ULTRA HL           |
| <b>Lead angle shape</b>                       | E                  |
| <b>Tolerance of screw taps</b>                | ISO 2X (6HX)       |
| <b>Twist angle</b>                            | 50° (right)        |
| <b>Shaft diameter</b>                         | 9 mm               |
| <b>Application type/machine type</b>          | CNC, Conventional  |
| <b>Core hole diameter</b>                     | 10.2 mm            |
| <b>Coolant supply</b>                         | External           |
| <b>Length</b>                                 | 110 mm             |
| <b>Shank square</b>                           | 7 mm               |
| <b>Cutting speed (steel 1000) suitability</b> | 1                  |
| <b>Cutting speed (steel 1300) suitability</b> | 1                  |
| <b>Overall stainless steel suitability</b>    | 1                  |
| <b>fitness not iron total</b>                 | 2                  |
| <b>fitness Titan/Nickel/Super total</b>       | 1                  |
| <b>Cutting speed (cast) suitability</b>       | 1                  |
| <b>Cutting speed (hard 55) suitability</b>    | 3                  |
| <b>Cutting speed (hard 65) suitability</b>    | 3                  |
| <b>DIN</b>                                    | 376                |

### EAN-Code

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