

## Screw tap, HSSE Ultra HL cut E M ISO 2X (6HX) 45° (right) 371 E

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

**ATORN®**



### Application

For producing metric threads on CNC machines or conventional machines in **blind holes** in steel, stainless steel, non-ferrous metals, cast iron and special alloys up to 1200 N/mm<sup>2</sup>.

### Advantage

- Ideal for long service life requirements and materials that are difficult to machine, such as stainless steel
- Innovative cutting geometry and ULTRA HL coating guarantee high process reliability even under difficult machining conditions
- Short cut ensures high thread depth with low material thickness

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
	18	12	8	11	10	19	19	17	19	17	18	13		18	7	6	6		

<b>Art. No.</b>	<b>13091 180</b>
<b>Type</b>	UNI MAX 45HL Control
<b>Thread type</b>	Metric thread
<b>Thread type x nominal diameter</b>	M18
<b>Pitch</b>	2.5 mm
<b>Hole type</b>	Blind hole ≤ 2.5xD
<b>Cutting material</b>	HSSE
<b>Surface</b>	ULTRA HL
<b>Lead angle shape</b>	E
<b>Tolerance of screw taps</b>	ISO 2X (6HX)
<b>Twist angle</b>	45° (right)
<b>Shaft diameter</b>	14 mm
<b>Application type/machine type</b>	CNC, Conventional
<b>Core hole diameter</b>	15.5 mm
<b>Coolant supply</b>	External
<b>Length</b>	125 mm
<b>Shank square</b>	11 mm
<b>Cutting speed (steel 1000) suitability</b>	1
<b>Cutting speed (steel 1300) suitability</b>	2
<b>Overall stainless steel suitability</b>	1
<b>fitness not iron total</b>	1
<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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