

## Screw tap, HSSE M ISO 2 (6H) 15° (left) 371 D

For universal conventional use up to 1000 N/mm<sup>2</sup>

**ATORN**<sup>®</sup>



### Application

For producing metric threads on 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/mm<sup>2</sup>.

### Version

- Dimensions pursuant to: DIN 371 = reinforced shank (up to M10), DIN 376 = transition-fit shank (from M12)

### Advantage

- Long service life and high level of process reliability thanks to innovative cutting geometry and universal application for maximum flexibility in use
- Reliable chip removal through a 15° left-hand spiral in long-chipping materials

Application	Steel (N/mm <sup>2</sup> )			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					

<b>Art. No.</b>	<b>13100 080</b>
<b>Type</b>	P MAX 1000 Control
<b>Thread type</b>	Metric thread
<b>Thread type x nominal diameter</b>	M8
<b>Pitch</b>	1.25 mm
<b>Hole type</b>	Clearance hole ≤ 3xD
<b>Cutting material</b>	HSSE
<b>Surface</b>	Uncoated
<b>Lead angle shape</b>	D
<b>Tolerance of screw taps</b>	ISO 2 (6H)
<b>Twist angle</b>	15° (left)
<b>Shaft diameter</b>	8 mm
<b>Application type/machine type</b>	Conventional
<b>Core hole diameter</b>	6.8 mm
<b>Coolant supply</b>	External
<b>Length</b>	90 mm
<b>Shank square</b>	6.2 mm
<b>Cutting speed (steel 1000) suitability</b>	1
<b>Cutting speed (steel 1300) suitability</b>	3
<b>Overall stainless steel suitability</b>	3
<b>fitness not iron total</b>	1
<b>fitness Titan/Nickel/Super total</b>	3
<b>Cutting speed (cast) suitability</b>	2
<b>Cutting speed (hard 55) suitability</b>	3
<b>Cutting speed (hard 65) suitability</b>	3
<b>DIN</b>	371

### EAN-Code

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