

Screw tap, HSSE M ISO 2 (6H) 0° 376 B

for universal use up to 1000 N/mm²

ATORN[®]

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

- with over-long shank

Advantage

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

| 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 | | | | | |

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|---|----------------------|
| Art. No. | 13117 220 |
| Type | P MAX 1000 |
| Thread type | Metric thread |
| Thread type x nominal diameter | M22 |
| Pitch | 2.5 mm |
| Hole type | Clearance hole ≤ 3xD |
| Cutting material | HSSE |
| Surface | Vaporised |
| Lead angle shape | B |
| Tolerance of screw taps | ISO 2 (6H) |
| Twist angle | 0° |
| Shaft diameter | 18 mm |
| Application type/machine type | CNC, Conventional |
| Core hole diameter | 19.5 mm |
| Coolant supply | External |
| Length | 140 mm |
| Shank square | 14.5 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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