

Screw tap, HSSE-PM Ultra HL with internal cooling M ISO 2X (6HX) 45° (right) 371 C

for universal use up to 1000 N/mm²

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/mm².

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
- h6 shank for clamping in shrink-fit chucks
- HSSE PM cutting material and internal cooling for longer service life

Application	Steel (N/mm ²)			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		

Art. no.	13081 200
Type	UNI MAX 45HL Control
Thread type	Metric thread
Thread type x nominal diameter	M20
Pitch	2.5 mm
Hole type	Blind hole ≤ 2.5xD
Cutting material	HSSE-PM
Surface	ULTRA HL
Lead angle shape	C
Tolerance of screw taps	ISO 2X (6HX)
Twist angle	45° (right)
Shaft diameter	16 mm
Application type/machine type	CNC, Conventional
Core hole diameter	17.5 mm
Coolant supply	Internal
Length	140 mm
Shank square	12 mm
Cutting speed (steel 1000) suitability	1
Cutting speed (steel 1300) suitability	2
Overall stainless steel suitability	1
fitness not iron total	1
fitness Titan/Nickel/Super total	1
Cutting speed (cast) suitability	1
Cutting speed (hard 55) suitability	3
Cutting speed (hard 65) suitability	3
DIN	376

EAN-Code

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