

## Thread former with internal cooling radial HSSE-PM TiAlN MF ISO 2X (6HX) 0° 374 similar to C

For universal use up to 1300 N/mm<sup>2</sup>

**ATORN**<sup>®</sup>

### Application

For producing fine, deep-set metric threads in through holes and blind holes on CNC or conventional machines in **steel, stainless steel and non-ferrous metals up to a strength of 1300 N/mm<sup>2</sup>**.



### Advantage

- Innovative mould geometry ensures very high dimensional accuracy and process reliability.
- High-quality, torsion-resistant HSSE PM cutting material and surface finish for very high service life requirements.
- Cutting edge finish for very high service life requirements.

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
	45	30	20	18	12	40	50	35	45	27	32								

<b>Art. No.</b>	<b>13399 100</b>
<b>Surface</b>	TiCN
<b>Lead angle shape</b>	C
<b>Thread type</b>	Metric fine thread
<b>Thread type x nominal diameter</b>	MF8
<b>Pitch</b>	1 mm
<b>Cutting material</b>	HSSE-PM
<b>Core hole diameter</b>	7.55 mm
<b>Length</b>	90 mm
<b>Hole type</b>	Clearance/blind hole ≤ 3xD
<b>Shaft diameter</b>	8 mm
<b>Shank square</b>	6.2 mm
<b>Coolant supply</b>	Internal radial
<b>Tolerance of screw taps</b>	ISO 2X (6HX)
<b>Application type/machine type</b>	CNC, Conventional
<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>Cutting speed (cast) suitability</b>	3
<b>fitness Titan/Nickel/Super total</b>	3
<b>Cutting speed (hard 65) suitability</b>	3
<b>DIN</b>	Similar to 374

### EAN-Code

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