

## Thread former HSSE TiCN MF ISO 2X (6HX) 0° 374 C

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

**ATORN**<sup>®</sup>



### Application

For manufacturing metric threads in through and blind holes on CNC or conventional machines in the **steel, stainless steel and non-ferrous metals up to a strength of 1500 N/mm<sup>2</sup>**.

### Advantage

- Innovative shape geometry optimised for machining high-strength materials
- High-quality, torsion-resistant HSSE cutting material and surface finish ensure a long service life

| 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 |
|             | 28                         | 12    | 10    |                 |         | 30    | 40   | 30    | 40   | 25     | 35   | 30       |                 |            |             |              |             |           |         |

|   |                            |
|---|----------------------------|
| <b>Art. No.</b>                               | <b>13396 362</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>         | MF14                       |
| <b>Pitch</b>                                  | 1.25 mm                    |
| <b>Cutting material</b>                       | HSSE                       |
| <b>Core hole diameter</b>                     | 13.4 mm                    |
| <b>Length</b>                                 | 100 mm                     |
| <b>Hole type</b>                              | Clearance/blind hole ≤ 3xD |
| <b>Shaft diameter</b>                         | 11 mm                      |
| <b>Shank square</b>                           | 9 mm                       |
| <b>Coolant supply</b>                         | External                   |
| <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>    | 3                          |
| <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>                                    | 374                        |

### EAN-Code

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