

## Screw tap, oversize HSSE M ISO 3 (6G) 0° 371 B

For use in high-strength steel up to 1300 N/mm<sup>2</sup>

**ATORN**<sup>®</sup>



### Application

For manufacturing oversized metric threads to ISO 3 (for subsequent surface treatment or thread shrinking as part of a hardening process) in through holes on CNC and conventional machines in the steel material group up to a strength of 1300 N/mm<sup>2</sup>.

### Version

- With reinforced shank

### Advantage

- Long service life and high level of process reliability thanks to innovative cutting geometry and coating for use in high-strength steel

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
	16	12	9																

<b>Art. No.</b>	<b>13077 060</b>
<b>Type</b>	P MAX 1300
<b>Thread type</b>	Metric thread
<b>Thread type x nominal diameter</b>	M6
<b>Pitch</b>	1 mm
<b>Hole type</b>	Clearance hole ≤ 3xD
<b>Cutting material</b>	HSSE
<b>Surface</b>	Vaporised
<b>Lead angle shape</b>	B
<b>Tolerance of screw taps</b>	ISO 3 (6G)
<b>Twist angle</b>	0°
<b>Shaft diameter</b>	6 mm
<b>Application type/machine type</b>	CNC, Conventional
<b>Core hole diameter</b>	5 mm
<b>Coolant supply</b>	External
<b>Length</b>	80 mm
<b>Shank square</b>	4.9 mm
<b>Cutting speed (steel 1000) suitability</b>	2
<b>Cutting speed (steel 1300) suitability</b>	1
<b>Overall stainless steel suitability</b>	3
<b>fitness not iron total</b>	3
<b>fitness Titan/Nickel/Super total</b>	3
<b>Cutting speed (cast) suitability</b>	3
<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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