

for universal use up to 1200 N/mm<sup>2</sup>

### Application

For producing metric threads on CNC machines or conventional machines in **blind holes** in the steel, stainless steel, non-ferrous metals and cast material groups up to a strength of 1200 N/mm<sup>2</sup>



### Advantage

- Universal use for maximum flexibility
- Innovative cutting geometry ensures high process reliability even under difficult machining conditions

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
	22	16	12	12	12	14	30	17	24	12	20	30	16	18	7	6	6		

<b>Art. no.</b>	<b>13204 760</b>
<b>Thread type</b>	Metric thread
<b>Thread type x nominal diameter</b>	M6
<b>Pitch</b>	1 mm
<b>Cutting material</b>	HSSE-PM
<b>Surface</b>	ULTRA HL
<b>Lead angle shape</b>	C
<b>Tolerance of screw taps</b>	ISO 2X (6HX)
<b>Twist angle</b>	50°
<b>Shaft diameter</b>	4.5 mm
<b>Coolant supply</b>	External
<b>Length</b>	80 mm
<b>Shank square</b>	6 mm
<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>fitness Titan/Nickel/Super total</b>	1
<b>Cutting speed (cast) suitability</b>	1
<b>Cutting speed (hard 55) suitability</b>	3
<b>Cutting speed (hard 65) suitability</b>	3
<b>DIN</b>	376

### EAN-Code

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