# Screw tap, HSSE M ISO 2 (6H) 0° 371 B for universal use up to 1000 N/mm2



# Application

For producing metric threads on CNC machines or conventional machines in **through holes** in the steel, (stainless steel), non-ferrous metals and (cast iron) material groups up to a strength of 1000 N/mm².

### Version

structural dimensions in accordance with: DIN 371 = reinforced shank (up to M10), DIN 376 = over-long shank (from M12)

good service life and process reliability thanks to innovative cutting geometry and universal use for the greatest flexibility in applications

Α	pplication	on Steel (N/mm²)		Stainless steel		Alu		Brass		Bronze		Plas-	Graphite	GG(G)		Nickel-		Hard mat.		
		<700	<1000	<1300	marten.	austen.	short	long	short	long	short	long	tics	G(C)FK	GjMW	alloy	alloy	alloy	<55 HRC	<65 HRC
		17	12		10		19	19	17	19	17	17	15		18					

Type P MAX 1000 Thread type Metric thread Thread type x nominal diameter M1 Pitch 0.25 mm Hole type Clearance hole ≤ 3xD Cutting material HSSE Surface Vaporised Lead angle shape B Tolerance of screw taps ISO 2 (6H) Twist angle 0° Shaft diameter 2.5 mm Application type/machine type CNC, Conventional Core hole diameter 0.75 mm Coolant supply External Length 40 mm Shank square 2.1 mm Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3						
Thread type x nominal diameter  M1  Pitch  0.25 mm  Clearance hole ≤ 3xD  Cutting material  HSSE  Surface  Vaporised  Lead angle shape  B  Tolerance of screw taps  ISO 2 (6H)  Twist angle  O°  Shaft diameter  Application type/machine type  Core hole diameter  Coolant supply  Length  Shank square  Cutting speed (steel 1000) suitability  Cutting speed (steel 1300) suitability  Metric thread  M1  Netric thread  M1  Netric thread  M1  Netric thread  Stap  Clearance hole ≤ 3xD  Core hole ≤ 3	Art. No.	13113 010				
Thread type x nominal diameter  Pitch  0.25 mm  Clearance hole ≤ 3xD  Cutting material  HSSE  Surface  Vaporised  Lead angle shape  B  Tolerance of screw taps  Tolerance of screw taps  Twist angle  Shaft diameter  2.5 mm  Application type/machine type  CNC, Conventional  Core hole diameter  Coolant supply  External  Length  40 mm  Shank square  Cutting speed (steel 1000) suitability  1  Cutting speed (steel 1300) suitability  3	Туре	P MAX 1000				
Pitch         0.25 mm           Hole type         Clearance hole ≤ 3xD           Cutting material         HSSE           Surface         Vaporised           Lead angle shape         B           Tolerance of screw taps         ISO 2 (6H)           Twist angle         0°           Shaft diameter         2.5 mm           Application type/machine type         CNC, Conventional           Core hole diameter         0.75 mm           Coolant supply         External           Length         40 mm           Shank square         2.1 mm           Cutting speed (steel 1000) suitability         1           Cutting speed (steel 1300) suitability         3	Thread type	Metric thread				
Hole type  Clearance hole ≤ 3xD  Cutting material  HSSE  Surface  Vaporised  Lead angle shape  B  Tolerance of screw taps  Tolerance of screw taps  Twist angle  Shaft diameter  Application type/machine type  CNC, Conventional  Core hole diameter  Coolant supply  External  Length  40 mm  Shank square  Cutting speed (steel 1000) suitability  Cutting speed (steel 1300) suitability  3	Thread type x nominal diameter	M1				
Cutting material HSSE  Surface Vaporised  Lead angle shape B  Tolerance of screw taps ISO 2 (6H)  Twist angle 0°  Shaft diameter 2.5 mm  Application type/machine type CNC, Conventional  Core hole diameter 0.75 mm  Coolant supply External  Length 40 mm  Shank square 2.1 mm  Cutting speed (steel 1000) suitability 1  Cutting speed (steel 1300) suitability 3	Pitch	0.25 mm				
Surface         Vaporised           Lead angle shape         B           Tolerance of screw taps         ISO 2 (6H)           Twist angle         0°           Shaft diameter         2.5 mm           Application type/machine type         CNC, Conventional           Core hole diameter         0.75 mm           Coolant supply         External           Length         40 mm           Shank square         2.1 mm           Cutting speed (steel 1000) suitability         1           Cutting speed (steel 1300) suitability         3	Hole type	Clearance hole ≤ 3xD				
Lead angle shape Tolerance of screw taps ISO 2 (6H) Twist angle O° Shaft diameter 2.5 mm Application type/machine type CNC, Conventional Core hole diameter 0.75 mm Coolant supply External Length 40 mm Shank square 2.1 mm Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3	Cutting material	HSSE				
Tolerance of screw taps  Tolerance of screw taps  Twist angle  Shaft diameter  Application type/machine type  CNC, Conventional  Core hole diameter  0.75 mm  Coolant supply  External  Length  40 mm  Shank square  2.1 mm  Cutting speed (steel 1000) suitability  1  Cutting speed (steel 1300) suitability  3	Surface	Vaporised				
Twist angle 0° Shaft diameter 2.5 mm  Application type/machine type CNC, Conventional Core hole diameter 0.75 mm  Coolant supply External Length 40 mm Shank square 2.1 mm  Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3	Lead angle shape	В				
Shaft diameter 2.5 mm  Application type/machine type CNC, Conventional  Core hole diameter 0.75 mm  Coolant supply External  Length 40 mm  Shank square 2.1 mm  Cutting speed (steel 1000) suitability 1  Cutting speed (steel 1300) suitability 3	Tolerance of screw taps	ISO 2 (6H)				
Application type/machine type  CNC, Conventional  Core hole diameter  0.75 mm  Coolant supply  External  Length  40 mm  Shank square  2.1 mm  Cutting speed (steel 1000) suitability  1  Cutting speed (steel 1300) suitability  3	Twist angle	0°				
Core hole diameter     0.75 mm       Coolant supply     External       Length     40 mm       Shank square     2.1 mm       Cutting speed (steel 1000) suitability     1       Cutting speed (steel 1300) suitability     3	Shaft diameter	2.5 mm				
Coolant supply External  Length 40 mm  Shank square 2.1 mm  Cutting speed (steel 1000) suitability 1  Cutting speed (steel 1300) suitability 3	Application type/machine type	CNC, Conventional				
Length 40 mm  Shank square 2.1 mm  Cutting speed (steel 1000) suitability 1  Cutting speed (steel 1300) suitability 3	Core hole diameter	0.75 mm				
Shank square 2.1 mm  Cutting speed (steel 1000) suitability 1  Cutting speed (steel 1300) suitability 3	Coolant supply	External				
Cutting speed (steel 1000) suitability 1 Cutting speed (steel 1300) suitability 3	Length	40 mm				
Cutting speed (steel 1300) suitability 3	Shank square	2.1 mm				
and open (control of our control our control of our control our contr	Cutting speed (steel 1000) suitability	1				
	Cutting speed (steel 1300) suitability	3				
Overall stainless steel suitability 3	Overall stainless steel suitability	3				
fitness not iron total 1	fitness not iron total	1				
fitness Titan/Nickel/Super total 3	fitness Titan/Nickel/Super total	3				
Cutting speed (cast) suitability 2	Cutting speed (cast) suitability	2				
Cutting speed (hard 55) suitability 3	Cutting speed (hard 55) suitability	3				
Cutting speed (hard 65) suitability 3	Cutting speed (hard 65) suitability	3				
<b>DIN</b> 371	DIN	371				

## **EAN-Code**

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