

## Thread former, HSSE Carbo M ISO 2X (6HX) 0° 371 similar to C

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

**ATORN**<sup>®</sup>



### Application

For manufacturing metric threads in through holes and blind holes on CNC and conventional machines in the NF metal material group up to a strength of 1300 N/mm<sup>2</sup> with a material expansion of > 10%.

### Version

- With lubrication grooves, structural dimensions according to: DIN 371 = reinforced shank (up to M10), DIN 376 = protruding shank (from M12)

### 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.
- Innovative carbo coating for very good gliding properties and emergency operating function if coolant supply is interrupted.

| 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 |
|             |                            |       |       |                 |         | 40    | 50   | 35    | 45   | 27     | 32   |           |                 |            |             |              |             |           |         |

|   |                            |
|---|----------------------------|
| <b>Art. No.</b>                               | <b>13398 031</b>           |
| <b>Surface</b>                                | Carbo coating              |
| <b>Lead angle shape</b>                       | C                          |
| <b>Thread type</b>                            | Metric thread              |
| <b>Thread type x nominal diameter</b>         | M3                         |
| <b>Pitch</b>                                  | 0.5 mm                     |
| <b>Cutting material</b>                       | HSSE-PM                    |
| <b>Core hole diameter</b>                     | 2.8 mm                     |
| <b>Length</b>                                 | 56 mm                      |
| <b>Hole type</b>                              | Clearance/blind hole ≤ 1xD |
| <b>Shaft diameter</b>                         | 3.5 mm                     |
| <b>Shank square</b>                           | 2.7 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> | 3                          |
| <b>Cutting speed (steel 1300) suitability</b> | 3                          |
| <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>                                    | Similar to 371             |

### EAN-Code

4050293580495