

for universal use up to 1200 N/mm²

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/mm²



Advantage

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

Application	Steel (N/mm ²)			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		

Art. no.	13204 780
Thread type	Metric thread
Thread type x nominal diameter	M8
Pitch	1.25 mm
Cutting material	HSSE-PM
Surface	ULTRA HL
Lead angle shape	C
Tolerance of screw taps	ISO 2X (6HX)
Twist angle	50°
Shaft diameter	6 mm
Coolant supply	External
Length	90 mm
Shank square	8 mm
Cutting speed (steel 1000) suitability	1
Cutting speed (steel 1300) suitability	1
Overall stainless steel suitability	1
fitness not iron total	2
fitness Titan/Nickel/Super total	1
Cutting speed (cast) suitability	1
Cutting speed (hard 55) suitability	3
Cutting speed (hard 65) suitability	3
DIN	376

EAN-Code

4050293731637