

## Thread former, oversize with internal cooling axial HSSE-PM Carbo M ISO

### 3X (6GX) 0° 376 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 and internal cooling, 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.
- 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 520</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>	M12
<b>Pitch</b>	1.75 mm
<b>Cutting material</b>	HSSE
<b>Core hole diameter</b>	11.2 mm
<b>Length</b>	110 mm
<b>Hole type</b>	Clearance/blind hole ≤ 3xD
<b>Shaft diameter</b>	9 mm
<b>Shank square</b>	7 mm
<b>Coolant supply</b>	Internal axial
<b>Tolerance of screw taps</b>	ISO 3X (6GX)
<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 376

#### EAN-Code

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