

Thread former with internal cooling rad HSSE TiCN MF ISO 2X (6HX) 0° 374 C

For universal use up to 1300 N/mm²



Application

For manufacturing metric threads in through and blind holes on CNC or conventional machines in the **steel, stainless steel and non-ferrous metals up to a strength of 1500 N/mm²**.

Advantage

- Innovative shape geometry optimised for machining high-strength materials
- High-quality, torsion-resistant HSSE cutting material and surface finish ensure a long service life

Application	Steel (N/mm ²)			Stainless steel		Alu		Brass		Bronze		Plastics	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
	28	12	10			30	40	30	40	25	35	30							

Art. No.	13396 418
Surface	TiCN
Lead angle shape	C
Thread type	Metric fine thread
Thread type x nominal diameter	MF20
Pitch	1.5 mm
Cutting material	HSSE
Core hole diameter	19.3 mm
Length	125 mm
Hole type	Clearance/blind hole ≤ 3xD
Shaft diameter	16 mm
Shank square	12 mm
Coolant supply	Internal radial
Tolerance of screw taps	ISO 2X (6HX)
Application type/machine type	CNC, Conventional
Cutting speed (steel 1000) suitability	1
Cutting speed (steel 1300) suitability	1
Overall stainless steel suitability	3
fitness not iron total	2
Cutting speed (cast) suitability	3
fitness Titan/Nickel/Super total	3
Cutting speed (hard 65) suitability	3
DIN	374

EAN-Code

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