

## Multi-range thread milling cutter with neck recess solid carbide 15° straight shank HA

For universal use up to 1500 N/mm<sup>2</sup> in female threads.

**ATORN®**

### Application

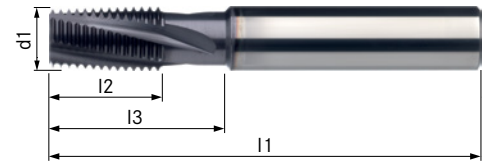
For manufacturing right-handed and left-handed NPT threads (National Piper Tap) in through and blind holes on CNC and conventional machines in the steel, stainless steel, NF metal, cast and special alloy material groups up to a strength of 1500 N/mm<sup>2</sup> in single part and series production.

### Version

- With collar recess.

### Advantage

- Innovative cutting geometry for very high dimensional accuracy, process reliability and chip removal.
- Deep thread depth achievable due to collar recess between thread part and shank.



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
	120	110	90		80	220	240			180	180	220	150	90	50	40	40		

<b>Art. No.</b>	<b>13498 428</b>
<b>Tool holding device</b>	HA parallel shank
<b>Cutting material</b>	VHM
<b>Surface</b>	Uncoated
<b>Hole type</b>	Clearance/blind hole ≤ 2xD
<b>Coolant supply</b>	Internal
<b>Cutting edge diameter</b>	18.5 mm
<b>Suitable from thread size</b>	NPT 1 inch
<b>Length</b>	90 mm
<b>Cutting edge length</b>	23.19 mm
<b>Effective length of thread milling</b>	23.19 mm
<b>Shaft diameter</b>	20 mm
<b>Number of cutting edges</b>	5 PCS
<b>f steel 1000</b>	0.08 mm/r

### EAN-Code

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