

## Screw tap, HSSE-PM Ultra HL (short cut E) M ISO 2X (6HX) 50° (right) 371

E

For universal use up to 1200 N/mm<sup>2</sup>

**ATORN**<sup>®</sup>



### Application

For manufacturing metric threads in **blind holes** on CNC or conventional machines in the steel, stainless steel, non-ferrous metal and cast iron material groups up to -1200 N/mm<sup>2</sup>

### Advantage

- Universal application for maximum flexibility
- Innovative cutting geometry ensures high process reliability even under difficult machining conditions
- Short cut shape E to cut slightly above base

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
	22	16	12	12	12	14	30	17	24	12	20	30	16	18	7	6	6		

<b>Art. no.</b>	<b>13217 980</b>
<b>Type</b>	UNI MAX 45HL Speed
<b>Thread type</b>	Metric thread
<b>Thread type x nominal diameter</b>	M20
<b>Pitch</b>	2.5 mm
<b>Hole type</b>	Blind hole ≤ 3xD
<b>Cutting material</b>	HSSE-PM
<b>Surface</b>	ULTRA HL
<b>Lead angle shape</b>	E
<b>Tolerance of screw taps</b>	ISO 2X (6HX)
<b>Twist angle</b>	50° (right)
<b>Shaft diameter</b>	16 mm
<b>Application type/machine type</b>	CNC, Conventional
<b>Core hole diameter</b>	17.5 mm
<b>Coolant supply</b>	External
<b>Length</b>	140 mm
<b>Shank square</b>	12 mm
<b>Cutting speed (steel 1000) suitability</b>	1
<b>Cutting speed (steel 1300) suitability</b>	1
<b>Overall stainless steel suitability</b>	1
<b>fitness not iron total</b>	2
<b>fitness Titan/Nickel/Super total</b>	1
<b>Cutting speed (cast) suitability</b>	1
<b>Cutting speed (hard 55) suitability</b>	3
<b>Cutting speed (hard 65) suitability</b>	3
<b>DIN</b>	376

### EAN-Code

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