

Multi-range thread milling cutter with 45° countersink, solid carbide straight shank HA

for universal use up to 1500 N/mm² in female threads

ATORN[®]



Application

For producing metric right-hand threads and left-hand threads with countersink on CNC machines in blind holes and through holes, in steel, stainless steel, non-ferrous metals, cast iron and special alloy material groups up to a strength of 1500 N/mm².

Version

- Precision-ground thread milling cutter with countersink for maximum requirements in terms of process reliability and service life

Advantage

- Innovative cutting geometry and coating technology ensure very high degree of dimensional accuracy, process reliability and chip removal
- High-quality cutting material and cutting edge finish for very high service life requirements
- Low tool costs thanks to high variability in the thread diameter, just one tool required for right-hand thread and left-hand thread
- Significantly optimised process times, as thread and countersink are produced in one step

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

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|---------------------------------|------------------------------|
| Art. no. | 13496 706 |
| Cutting material | VHM |
| Surface | TiAIN |
| Hole type | Clearance/blind hole ≤ 1.5xD |
| Tool holding device | HA parallel shank |
| Suitable for thread type | M, M-L |
| Pitch | 1.75 mm |
| Length | 84 mm |
| Cutting edge length | 20.1 mm |
| Countersunk length | 21.2 mm |
| Countersink diameter | 11.7 |
| Shaft diameter | 12 mm |
| Number of cutting edges | 7 PCS |
| f steel 1000 | 0.07 mm/r |

EAN-Code

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