

## Screw tap, HSSE M ISO 2 (6H) 15° (left) 371 D

For universal conventional use up to 1000 N/mm<sup>2</sup>

**ATORN**<sup>®</sup>



### Application

For producing metric threads on conventional machines in **through holes** in the steel, (stainless steel), non-ferrous metals and (cast iron) material groups up to a strength of 1000 N/mm<sup>2</sup>.

### Version

- Dimensions pursuant to: DIN 371 = reinforced shank (up to M10), DIN 376 = transition-fit shank (from M12)

### Advantage

- Long service life and high level of process reliability thanks to innovative cutting geometry and universal application for maximum flexibility in use
- Reliable chip removal through a 15° left-hand spiral in long-chipping materials

| Application | Steel (N/mm <sup>2</sup> ) |       |       | 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 |
|             | 16                         | 11    |       | 9               |         | 18    | 18   | 15    | 18   | 15     | 15   | 13       |                 | 16         |             |              |             |           |         |

|                                               |                      |
|-----------------------------------------------|----------------------|
| <b>Art. No.</b>                               | <b>13100 060</b>     |
| <b>Type</b>                                   | P MAX 1000 Control   |
| <b>Thread type</b>                            | Metric thread        |
| <b>Thread type x nominal diameter</b>         | M6                   |
| <b>Pitch</b>                                  | 1 mm                 |
| <b>Hole type</b>                              | Clearance hole ≤ 3xD |
| <b>Cutting material</b>                       | HSSE                 |
| <b>Surface</b>                                | Uncoated             |
| <b>Lead angle shape</b>                       | D                    |
| <b>Tolerance of screw taps</b>                | ISO 2 (6H)           |
| <b>Twist angle</b>                            | 15° (left)           |
| <b>Shaft diameter</b>                         | 6 mm                 |
| <b>Application type/machine type</b>          | Conventional         |
| <b>Core hole diameter</b>                     | 5 mm                 |
| <b>Coolant supply</b>                         | External             |
| <b>Length</b>                                 | 80 mm                |
| <b>Shank square</b>                           | 4.9 mm               |
| <b>Cutting speed (steel 1000) suitability</b> | 1                    |
| <b>Cutting speed (steel 1300) suitability</b> | 3                    |
| <b>Overall stainless steel suitability</b>    | 3                    |
| <b>fitness not iron total</b>                 | 1                    |
| <b>fitness Titan/Nickel/Super total</b>       | 3                    |
| <b>Cutting speed (cast) suitability</b>       | 2                    |
| <b>Cutting speed (hard 55) suitability</b>    | 3                    |
| <b>Cutting speed (hard 65) suitability</b>    | 3                    |
| <b>DIN</b>                                    | 371                  |

### EAN-Code

4050293016970