

## Screw tap, HSSE V3 M ISO 2 (6H) 0° 376 B

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

**ATORN**<sup>®</sup>



### Application

For producing metric threads on CNC machines or conventional machines in **through holes** in the steel, stainless steel, non-ferrous metals, cast and special alloys material groups up to a strength of 1200 N/mm<sup>2</sup>.

### Advantage

- Universal use for maximum flexibility of application
- Innovative cutter geometry ensures high process reliability even in difficult machining conditions

| 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 |
|             | 18                         | 12    | 6     | 8               | 8       | 8     | 18   | 6     | 16   | 10     | 14   | 15        |                 | 15         | 3           | 3            | 3           |           |         |

|   |                      |
|---|----------------------|
| <b>Art. No.</b>                               | <b>13217 280</b>     |
| <b>Type</b>                                   | UNI MAX 40 Control   |
| <b>Thread type</b>                            | Metric thread        |
| <b>Thread type x nominal diameter</b>         | M8                   |
| <b>Pitch</b>                                  | 1.25 mm              |
| <b>Hole type</b>                              | Clearance hole ≤ 3xD |
| <b>Cutting material</b>                       | HSSE V3              |
| <b>Surface</b>                                | Vaporised            |
| <b>Lead angle shape</b>                       | B                    |
| <b>Tolerance of screw taps</b>                | ISO 2 (6H)           |
| <b>Twist angle</b>                            | 0°                   |
| <b>Shaft diameter</b>                         | 6 mm                 |
| <b>Application type/machine type</b>          | CNC, Conventional    |
| <b>Core hole diameter</b>                     | 6.8 mm               |
| <b>Coolant supply</b>                         | External             |
| <b>Length</b>                                 | 90 mm                |
| <b>Shank square</b>                           | 4.9 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>       | 2                    |
| <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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