

## Screw tap, HSSE V3 G 0° 5156 B

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

**ATORN**<sup>®</sup>



### Application

For manufacturing pipe threads on CNC or conventional machines in **through holes** in the steel, stainless steel, NF metal, cast and special alloy 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		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
	18	12	6	8	8	8	18	6	16	10	14	15		15	3	3	3		

<b>Art. No.</b>	<b>13221 020</b>
<b>Type</b>	UNI MAX 40 Control
<b>Thread type</b>	Pipe thread
<b>Thread type x nominal diameter in inches</b>	G 1/4 in
<b>Number of thread starts per inch</b>	19
<b>Hole type</b>	Clearance hole ≤ 3xD
<b>Cutting material</b>	HSSE V3
<b>Surface</b>	Vaporised
<b>Lead angle shape</b>	B
<b>Twist angle</b>	0°
<b>Shaft diameter</b>	11 mm
<b>Application type/machine type</b>	CNC, Conventional
<b>Core hole diameter</b>	11.8 mm
<b>Length</b>	100 mm
<b>Shank square</b>	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>	5156

### EAN-Code

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