

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

For universal use up to 1500 N/mm², in female thread 2.0xD

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 alloys material groups up to a strength of 1500 N/mm² in single-part production and series production.



Version

- Precision-ground thread milling cutter with chamfer 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 treatment 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 bore 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	90	70	50	40	250	250	220	220			180	160		40	30	30		

Art. No.	13496 112
Cutting material	VHM
Surface	TiAlN
Hole type	Clearance/blind hole ≤ 2xD
Coolant supply	Internal
Tool holding device	HA parallel shank
Suitable for thread type	M, M-L
Nominal diameter	12 mm
Pitch	1.75 mm
Length	90 mm
Cutting edge length	25.32 mm
Countersunk length	26.7 mm
Countersink diameter	13.5 mm
Shaft diameter	14 mm
Number of cutting edges	4 PCS
f steel 1000	0.07 mm/r

EAN-Code

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