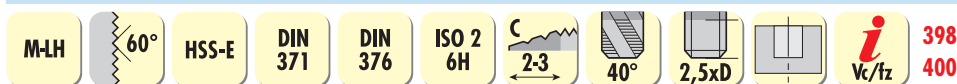


ATORN Left-hand thread machine tap

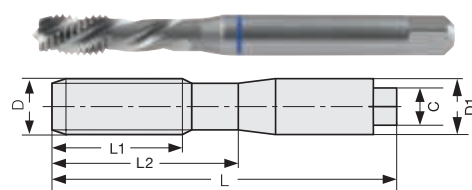
- **ISO 6H metric left-hand thread**
- 40°, spiral-flute
- Type C, 2,3 thread chamfer
- DIN 371 construction dimensions = up to M10, DIN 376 = from M12
- **Cutting material: HSS-E**
- For blind-hole threads
- Strong chip removal to the rear for long-chipping materials
- Minimal thread relief grinding
- Possible thread depth 2.5 x D

material	● very well suited ○ well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper Cu-alloy	graphite GRP/CFP/thermo.	hardened steel		
		< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si			< 55 HRc	< 60 HRc	≥ 60 HRc
		12	10		8	8			14										

Cutting speed Vc m/min. Please adjust these guidelines according to clamping operation and machine set-up.

D mm	Pitch mm	L mm	L1 mm	L2 mm	D1 mm	C mm	Tapping hole Ø mm	art.no.	€
M 3-LH	0.5	56	6	18	3.5	2.7	2.50	134215 0030	48,80
M 4-LH	0.7	63	7	21	4.5	3.4	3.30	134215 0040	48,80
M 5-LH	0.8	70	8	25	6	4.9	4.20	134215 0050	48,20
M 6-LH	1	80	10	30	6	4.9	5.00	134215 0060	46,80
M 8-LH	1.25	90	13	35	8	6.2	6.80	134215 0080	57,60
M 10-LH	1.5	100	15	39	10	8	8.50	134215 0100	65,10
M 12-LH	1.75	110	18	-	9	7	10.25	134215 0120	80,30
M 16-LH	2	110	20	-	12	9	14.00	134215 0160	138,—
M 20-LH	2.5	140	25	-	16	12	17.50	134215 0200	186,50

1127

**ATORN** Left-hand thread machine tap

- **ISO 6H metric left-hand thread**
- Straight-fluted with spiral point, type B, 3.5 to 5-thread chamfer
- Constructional dimensions DIN 371 = up to M 10, DIN 376 = from M12
- **Cutting material: HSS-E**
- For through-hole threads
- The spiral point ensures strong chip removal to the front
- Possible thread depth 3 x D

material	● very well suited ○ well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper Cu-alloy	graphite GRP/CFP/thermo.	hardened steel		
		< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si			< 55 HRc	< 60 HRc	≥ 60 HRc
		12	10		8	8			14										

Cutting speed Vc m/min. Please adjust these guidelines according to clamping operation and machine set-up.

D mm	Pitch mm	L mm	L1 mm	L2 mm	D1 mm	C mm	Tapping hole Ø mm	art.no.	€
M 4-LH	0.7	63	12	21	4.5	3.4	3.30	134120 0040	48,20
M 5-LH	0.8	70	14	25	6	4.9	4.20	134120 0050	46,—
M 6-LH	1.0	80	16	30	6	4.9	5.00	134120 0060	46,—
M 8-LH	1.25	90	18	35	8	6.2	6.80	134120 0080	56,90
M 10-LH	1.5	100	20	39	10	8	8.50	134120 0100	63,90
M 12-LH	1.75	110	22	-	9	7	10.25	134120 0120	78,50
M 14-LH	2.0	110	25	-	11	9	12.00	134120 0140	112,—
M 16-LH	2.0	110	28	-	12	9	14.00	134120 0160	124,50
M 20-LH	2.5	140	32	-	16	12	17.50	134120 0200	184,—

1127

