



### PRODUCT DESCRIPTION

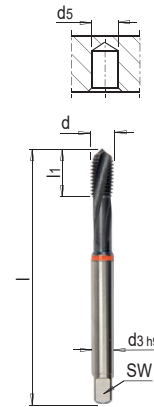
» For ISO metric threads

### MATERIAL

» HSS-E-PM, TiAlN coated

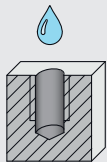


Z	SW	d3	d5	l	l1	P	d	No.	EUR
3	3.4	4.5	3.3	63	7.5	0.7	<b>M 4</b>	WZG 341318/ 4	< >
3	4.9	6	4.2	70	8.5	0.8	<b>M 5</b>	WZG 341318/ 5	< >
3	4.9	6	5	80	11	1	<b>M 6</b>	WZG 341318/ 6	< >
3	6.2	8	6.8	90	14	1.25	<b>M 8</b>	WZG 341318/ 8	< >
3	8	10	8.5	100	16	1.5	<b>M10</b>	WZG 341318/10	< >
3	7	9	10.2	110	18.5	1.75	<b>M12</b>	WZG 341318/12	< >
4	9	12	14	110	20	2	<b>M16</b>	WZG 341318/16	< >
4	12	16	17.5	140	25	2.5	<b>M20</b>	WZG 341318/20	< >



### GUIDELINE FOR TAPPING

#### WZG 341318



Material	Strength	Vc <sup>1</sup> m/min.
1.1730	640 N/mm <sup>2</sup>	10
1.2083	780 N/mm <sup>2</sup>	8
1.2085	1080 N/mm <sup>2</sup>	6
1.2162	660 N/mm <sup>2</sup>	10
1.2311	1080 N/mm <sup>2</sup>	8
1.2312	1080 N/mm <sup>2</sup>	8
1.2316	1010 N/mm <sup>2</sup>	8
1.2343	780 N/mm <sup>2</sup>	10
1.2379	780 N/mm <sup>2</sup>	6
1.2767	830 N/mm <sup>2</sup>	8
1.2842	775 N/mm <sup>2</sup>	10
1.2714HH	1350 N/mm <sup>2</sup>	4

1) Vc: cutting speed (m/min.)

**i** You can find further materials and cutting values in the cutting data calculator.