



### PRODUCT DESCRIPTION

- » For hardened steel
- » For ISO metric threads

### MATERIAL

- » HSS-E-PM, TiCN coated



SW	d3	d5	l	l1	P	d	No.	EUR
2.7	3.5	2.6	56	10	0.5	<b>M 3</b>	WZG 32141/ 3	< >
3.4	4.5	3.4	63	12	0.7	<b>M 4</b>	WZG 32141/ 4	< >
4.9	6	4.3	70	14	0.8	<b>M 5</b>	WZG 32141/ 5	< >
4.9	6	5.1	80	16	1	<b>M 6</b>	WZG 32141/ 6	< >
6.2	8	6.9	90	17	1.25	<b>M 8</b>	WZG 32141/ 8	< >
8	10	8.6	100	20	1.5	<b>M10</b>	WZG 32141/10	< >
9	12	10.4	110	24	1.75	<b>M12</b>	WZG 32141/12	< >



### GUIDELINE FOR TAPPING

WZG 32141 WZG 32241	Material	Strength	Vc <sup>1)</sup> m/min.
	1.2083	52 HRC	2
	1.2162	52 HRC	2
	1.2343	52 HRC	2
	1.2714HH	1350 N/mm <sup>2</sup>	6
	1.2767	52 HRC	2

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

- » Drill the hole diameter larger by approx. 0.1 mm (using WZB 10253).
- » Use cutting oil
- » Clamp with a rigid or synchro chuck

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