

PRODUCT DESCRIPTION

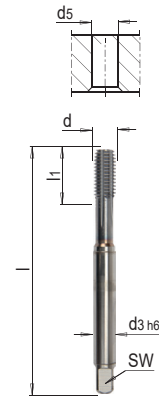
» Fluteless tap with oil grooves for ISO metric threads

MATERIAL

» HSS-E-PM, TiCN coated



Z	SW	d3	d5	l	l1	P	d	No.	EUR
4	2.7	3.5	2.8	56	10	0.5	M 3	WZG 32130/ 3	< >
4	3.4	4.5	3.7	63	13	0.7	M 4	WZG 32130/ 4	< >
5	4.9	6	4.65	70	14	0.8	M 5	WZG 32130/ 5	< >
5	4.9	6	5.55	80	16	1	M 6	WZG 32130/ 6	< >
5	6.2	8	7.4	90	17	1.25	M 8	WZG 32130/ 8	< >
5	8	10	9.3	100	20	1.5	M10	WZG 32130/10	< >
7	7	9	11.2	110	24	1.75	M12	WZG 32130/12	< >
8	9	12	15.1	110	26	2	M16	WZG 32130/16	< >



REFERENCE VALUES FOR WORKING WITH FLUTELESS TAPS

WZG 32130 WZG 36130		Material	Strength	Vc ¹ m/min.
		1.1730	640 N/mm ²	25
		1.2083	780 N/mm ²	25
		1.2162	660 N/mm ²	25
		1.2311	1080 N/mm ²	15
		1.2312	1080 N/mm ²	15
		1.2343	780 N/mm ²	15
		1.2379	780 N/mm ²	15
		1.2767	830 N/mm ²	25
		1.2842	775 N/mm ²	25
		1.2767	830 N/mm ²	15
		1.2842	775 N/mm ²	25

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

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