



PRODUCT DESCRIPTION

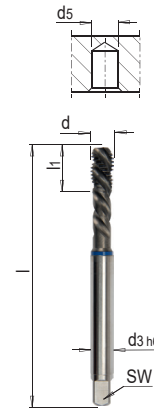
» For ISO metric threads

MATERIAL

» HSS-E-PM, TiAlN coated



Z	SW	d3	d5	l	l1	P	d	No.	EUR
3	2.7	3.5	2.5	56	6	0.5	M 3	WZG 341317/ 3	< >
3	3.4	4.5	3.3	63	7.5	0.7	M 4	WZG 341317/ 4	< >
3	4.9	6	4.2	70	8.5	0.8	M 5	WZG 341317/ 5	< >
3	4.9	6	5	80	11	1	M 6	WZG 341317/ 6	< >
3	6.2	8	6.8	90	14	1.25	M 8	WZG 341317/ 8	< >
3	8	10	8.5	100	16	1.5	M10	WZG 341317/10	< >
3	7	9	10.2	110	18.5	1.75	M12	WZG 341317/12	< >
4	9	12	14	110	20	2	M16	WZG 341317/16	< >



GUIDELINE FOR TAPPING

WZG 341317 WZG 361317	WZG 341337	Material	Strength	Vc ¹ m/min.
		1.1730	640 N/mm ²	20
		1.2083	780 N/mm ²	12
		1.2085	1080 N/mm ²	10
		1.2162	660 N/mm ²	18
		1.2311	1080 N/mm ²	10
		1.2312	1080 N/mm ²	10
		1.2316	1010 N/mm ²	10
		1.2343	780 N/mm ²	18
		1.2379	780 N/mm ²	10
		1.2767	830 N/mm ²	15
1.2842	775 N/mm ²	18		

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

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