



### PRODUCT DESCRIPTION

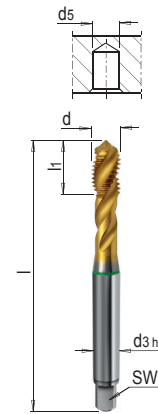
» For ISO metric threads

### MATERIAL

» HSS-E (5% Co), TiN coated



SW	d3	d5	l	l1	P	d	No.	EUR
2.7	3.5	2.5	56	6	0.5	<b>M 3</b>	WZG 341215/ 3	< >
3.4	4.5	3.3	63	7	0.7	<b>M 4</b>	WZG 341215/ 4	< >
4.9	6	4.2	70	8	0.8	<b>M 5</b>	WZG 341215/ 5	< >
4.9	6	5	80	10	1	<b>M 6</b>	WZG 341215/ 6	< >
6.2	8	6.8	90	13	1.25	<b>M 8</b>	WZG 341215/ 8	< >
8	10	8.5	100	15	1.5	<b>M10</b>	WZG 341215/10	< >
7	9	10.2	110	18	1.75	<b>M12</b>	WZG 341215/12	< >



### GUIDELINE FOR TAPPING

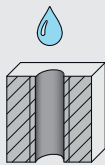
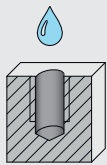
**WZG 341112**  
**WZG 34121**  
**WZG 341215**  
**WZG 34221**  
**WZG 34521**

**WZG 34123**  
**WZG 341235**  
**WZG 34223**  
**WZG 34523**

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>	6
1.2312	1080 N/mm <sup>2</sup>	6
1.2316	1010 N/mm <sup>2</sup>	6
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) Vc: cutting speed (m/min.)



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