



PRODUCT DESCRIPTION

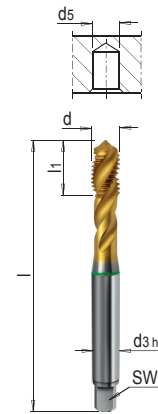
» For metric ISO fine threads

MATERIAL

» HSS-E (5% Co), TiN coated



SW	d3	d5	l	l1	d	P	No.	EUR
2.7	3.5	4.5	70	5	M 5	0.5	WZG 34221/ 5x0,5	< >
3.4	4.5	5.2	80	8	M 6	0.75	WZG 34221/ 6x0,75	< >
4.3	5.5	6	80	8	M 7	1	WZG 34221/ 7x1	< >
4.9	6	7.2	80	8	M 8	0.75	WZG 34221/ 8x0,75	< >
4.9	6	7	90	11	M 8	1	WZG 34221/ 8x1	< >
5.5	7	8	90	11	M 9	1	WZG 34221/ 9x1	< >
5.5	7	9	90	11	M10	1	WZG 34221/10x1	< >
6.2	8	10	90	11	M11	1	WZG 34221/11x1	< >
7	9	10.5	100	16	M12	1.5	WZG 34221/12x1,5	< >
9	11	12.5	100	15	M14	1.5	WZG 34221/14x1,5	< >
9	12	14.5	100	15	M16	1.5	WZG 34221/16x1,5	< >
11	14	16.5	110	16	M18	1.5	WZG 34221/18x1,5	< >
12	16	18.5	125	16	M20	1.5	WZG 34221/20x1,5	< >
14.5	18	20.5	125	16	M22	1.5	WZG 34221/22x1,5	< >
14.5	18	22.5	140	16	M24	1.5	WZG 34221/24x1,5	< >
14.5	18	22	140	22	M24	2	WZG 34221/24x2	< >



GUIDELINE FOR TAPPING

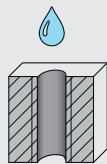
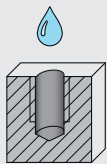
WZG 341112
WZG 34121
WZG 341215
WZG 34221
WZG 34521

WZG 34123
WZG 341235
WZG 34223
WZG 34523

Material

Strength

Vc¹
m/min.



1.1730	640 N/mm ²	10
1.2083	780 N/mm ²	8
1.2085	1080 N/mm ²	6
1.2162	660 N/mm ²	10
1.2311	1080 N/mm ²	6
1.2312	1080 N/mm ²	6
1.2316	1010 N/mm ²	6
1.2343	780 N/mm ²	10
1.2379	780 N/mm ²	6
1.2767	830 N/mm ²	8
1.2842	775 N/mm ²	10

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



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