



PRODUCT DESCRIPTION

- » For ISO metric threads
- » Extra long version

MATERIAL

- » HSS-E (5% Co), TiAlN coated



SW	d3	d5	l	l1	P	d	No.	EUR
2.7	3.5	2.5	112	6	0.5	M 3	WZG 341219/ 3	< >
3.4	4.5	3.3	125	7	0.7	M 4	WZG 341219/ 4	< >
4.9	6	4.2	140	8	0.8	M 5	WZG 341219/ 5	< >
4.9	6	5	160	10	1	M 6	WZG 341219/ 6	< >
4.9	6	6.8	180	13	1.25	M 8	WZG 341219/ 8	< >
5.5	7	8.5	200	15	1.5	M10	WZG 341219/10	< >
7	9	10.2	220	18	1.75	M12	WZG 341219/12	< >
9	12	14	220	20	2	M16	WZG 341219/16	< >
12	16	17.5	280	25	2.5	M20	WZG 341219/20	< >



GUIDELINE FOR TAPPING

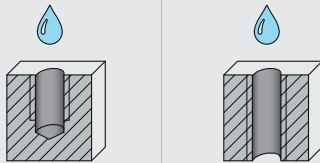
WZG 341312
WZG 341217
WZG 341219
WZG 342217
WZG 345217

WZG 341237

Material

Strength

Vc¹
m/min.



1.1730	640 N/mm ²	12
1.2083	780 N/mm ²	10
1.2085	1080 N/mm ²	8
1.2162	660 N/mm ²	12
1.2311	1080 N/mm ²	8
1.2312	1080 N/mm ²	8
1.2316	1010 N/mm ²	8
1.2343	780 N/mm ²	12
1.2379	780 N/mm ²	8
1.2767	830 N/mm ²	10
1.2842	775 N/mm ²	8

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

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