

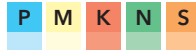


PRODUCT DESCRIPTION

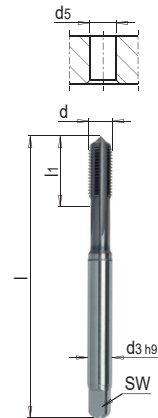
- » For hardened steel
- » For metric ISO fine threads

MATERIAL

- » HSS-E-PM, TiCN coated



| SW | d3 | d5 | l | l1 | d | P | No. | EUR |
|-----|----|------|-----|----|-----|-----|------------------|-----|
| 6.2 | 8 | 7.1 | 90 | 17 | M 8 | 1 | WZG 32241/ 8x1 | < > |
| 8 | 10 | 9.1 | 90 | 17 | M10 | 1 | WZG 32241/10x1 | < > |
| 9 | 12 | 11.1 | 100 | 20 | M12 | 1 | WZG 32241/12x1 | < > |
| 9 | 12 | 10.6 | 100 | 20 | M12 | 1.5 | WZG 32241/12x1,5 | < > |



GUIDELINE FOR TAPPING

| WZG 32141 WZG 32241 | Material | Strength | Vc ¹⁾ m/min. |
|------------------------|----------|------------------------|----------------------------|
| | 1.2083 | 52 HRC | 2 |
| | 1.2162 | 52 HRC | 2 |
| | 1.2343 | 52 HRC | 2 |
| | 1.2714HH | 1350 N/mm ² | 6 |
| | 1.2767 | 52 HRC | 2 |

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

- » Drill the hole diameter larger by approx. 0.1 mm (using WZB 10253).
- » Use cutting oil
- » Clamp with a rigid or synchro chuck

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