



PRODUCT DESCRIPTION

» For ISO metric threads

MATERIAL

» HSS-E (5% Co), TiAlN coated

Content	No.	EUR
WZB 30213: d = 2.5, 3.3, 4.2, 5, 6.8, 8.5, 10.2 WZG 341217: d = M3, M4, M5, M6, M8, M10, M12	WZG 341217/Set 3-12 KB	< >



HSS-E METRIC THREAD TAP FOR BLIND HOLE

WZG 341217



PRODUCT DESCRIPTION

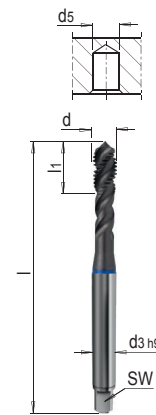
» For ISO metric threads

MATERIAL

» HSS-E (5% Co), TiAlN coated



SW	d3	d5	l	l1	P	d	No.	EUR
2.1	2.8	1.6	45	5	0.4	M 2	WZG 341217/ 2	< >
2.7	3.5	2.5	56	6	0.5	M 3	WZG 341217/ 3	< >
3	4	2.9	60	8	0.6	M 3,5	WZG 341217/ 3,5	< >
3.4	4.5	3.3	63	7	0.7	M 4	WZG 341217/ 4	< >
4.9	6	4.2	70	8	0.8	M 5	WZG 341217/ 5	< >
4.9	6	5	80	10	1	M 6	WZG 341217/ 6	< >
6.2	8	6.8	90	13	1.25	M 8	WZG 341217/ 8	< >
8	10	8.5	100	15	1.5	M10	WZG 341217/10	< >
7	9	10.2	110	18	1.75	M12	WZG 341217/12	< >
9	11	12	110	20	2	M14	WZG 341217/14	< >
9	12	14	110	20	2	M16	WZG 341217/16	< >
12	16	17.5	140	25	2.5	M20	WZG 341217/20	< >



GUIDELINE FOR TAPPING

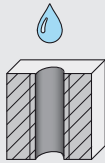
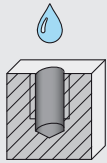
WZG 341312
WZG 341217
WZG 341219
WZG 342217
WZG 345217

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.)



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