

Application values

Screw tap, HSSE-PM Ultra HL with internal cooling M ISO 2X (6HX) 0° 371 B
(Art. no. 1003140 243-252)



Material groups for cutting values	Strength Class [N/mm²]	Description regarding DIN	Vc [m/min]
1. Steels			
1.1 Free machining steel	< 900	9 S 20	10-25
1.2 Structural steel	<500	ST 37-2	10-25
1.3 Structural steel	> 500	ST 60-2	10-20
1.4 Heat-treated steel	<1000	42 CrMo 4	10-20
1.5 Cast iron	<1000	GS-45	10-15
1.6 Case-hardened steel	<1200	16 MnCr 5	8-20
1.7 Ferritic/martensitic stainless steel	<1100	X 10 Cr 13	8-15
1.8 Heat-treated steel	>1000	43 CrMo 4	8-12
1.9 Nitriding steel	<1300	31 CrMoV 9	8-12
1.10 Tool steel	<1300	X 38 CrMoV 5 1	8-20
2. Stainless steels			
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	8-12
3. Non-ferrous metals			
3.1 Long-chipping aluminium	<500	Al99.9	15-30
3.2 Short-chipping aluminium	<500	G-AlSi12	15-25
3.3 Copper alloy bronze, long-chipping	<1200	CuSn4	10-20
3.4 Copper alloy bronze, short-chipping	<850	CuNi12Zn24	10-20
3.5 Copper alloy brass, long-chipping	<600	Cu Zn 20	15-25
3.7 Thermoplastic	<600	Cu Zn 39 Pb 3	15-22
	<100	PVC, Acrylglas	10-20
3.8 Duroplast	<150	Bakelit, Melamin	8-15
3.9 Fibre-reinforced plastics	<1500	CFK, GFK	5-12
3.10 Graphite	<60	C8000	15-25
3.11 Composite materials			5-12
4. Cast metal			
4.1 Grey cast iron	<260 HB	GG10	10-25
4.2 Spheroidal graphite iron	<310 HB	GGG 40	10-25
4.3 Ductile iron	<280 HB	GTW-55	10-25
5. Special alloys			
5.1 Titanium alloy	<1200	TiAl5Sn2,5	5-8
5.2 Nickel-based alloy	<1400	NiCr21Mo	5-8
5.3 Super alloys	<1400	X45CrSi 9 3	5-8

