

Application values Blind-hole screw tap (Art. no. 1014506 101-112)



| Material groups for cutting values | Strength Class [N/mm ²] | Description regarding DIN | Vc [m/min] |
|--|-------------------------------------|---------------------------|------------|
| 1. Steels | | | |
| 1.1 Free machining steel | < 900 | 9 S 20 | 5-15 |
| 1.2 Structural steel | <500 | ST 37-2 | 5-20 |
| 1.3 Structural steel | > 500 | ST 60-2 | 5-15 |
| 1.4 Heat-treated steel | <1000 | 42 CrMo 4 | 5-15 |
| 1.6 Case-hardened steel | <1200 | 16 MnCr 5 | 5-12 |
| 1.7 Ferritic/martensitic stainless steel | <1100 | X 10 Cr 13 | 5-12 |
| 1.8 Heat-treated steel | >1000 | 43 CrMo 4 | 2-8 |
| 1.10 Tool steel | <1300 | X 38 CrMoV 5 1 | 2-8 |
| 2. Stainless steels | | | |
| 2.1 Austenitic stainless steel | <1100 | G-X 2 CrNiMo 18 15 | 5-12 |

