

Application values Blind-hole screw tap (Art. no. 1014447 101-106)



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	10-35
1.2 Structural steel	<500	ST 37-2	10-40
1.3 Structural steel	> 500	ST 60-2	10-30
1.7 Ferritic/martensitic stainless steel	<1100	X 10 Cr 13	8-20
2. Stainless steels			
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	5-15

