

## Application values Through-hole screw tap (Art. no. 1014320 107-110)

Material groups for cutting values	Strength Class [N/mm <sup>2</sup> ]	Description regarding DIN	Vc [m/min]
<b>1. Steels</b>			
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
<b>2. Stainless steels</b>			
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	5-15

