

Application values Blind-hole screw tap (Art. no. 1014440 111-117)

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

