

## Application values Through-hole screw tap (Art. no. 1014360 203-212)



Material groups for cutting values	Strength Class [N/mm <sup>2</sup> ]	Description regarding DIN	Vc [m/min]
<b>3. Non-ferrous metals</b>			
3.1 Long-chipping aluminium	<500	Al99.9	20-30
3.2 Short-chipping aluminium	<500	G-AlSi12	20-30
3.3 Copper alloy bronze, long-chipping	<1200	CuSn4	10-15
3.4 Copper alloy bronze, short-chipping	<850	CuNi12Zn24	10-15
3.5 Copper alloy brass, long-chipping	<600	Cu Zn 20	20-25
3.7 Thermoplastic	<600	Cu Zn 39 Pb 3	20-25
	<100	PVC, Acrylglas	20-30

