

Application values Blind-hole screw tap (Art. no. 1014459 201-209)



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	5-25
1.2 Structural steel	<500	ST 37-2	5-25
1.3 Structural steel	> 500	ST 60-2	5-20
1.4 Heat-treated steel	<1000	42 CrMo 4	5-20
1.6 Case-hardened steel	<1200	16 MnCr 5	2-15
1.8 Heat-treated steel	>1000	43 CrMo 4	2-15
1.10 Tool steel	<1300	X 38 CrMoV 5 1	2-15
3. Non-ferrous metals			
3.5 Copper alloy brass, long-chipping	<600	Cu Zn 20	10-40

