

Application values Blind-hole screw tap (Art. no. 1014579 101-109)



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	15-45
1.2 Structural steel	<500	ST 37-2	15-45
1.3 Structural steel	> 500	ST 60-2	10-40
1.4 Heat-treated steel	<1000	42 CrMo 4	10-40
1.6 Case-hardened steel	<1200	16 MnCr 5	5-25
1.7 Ferritic/martensitic stainless steel	<1100	X 10 Cr 13	5-12
1.8 Heat-treated steel	>1000	43 CrMo 4	5-15
1.10 Tool steel	<1300	X 38 CrMoV 5 1	5-15
2. Stainless steels			
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	2-8
3. Non-ferrous metals			
3.1 Long-chipping aluminium	<500	Al99.9	15-40
3.3 Copper alloy bronze, long-chipping	<1200	CuSn4	5-30
3.5 Copper alloy brass, long-chipping	<600	Cu Zn 20	10-40
4. Cast metal			
4.1 Grey cast iron	<260 HB	GG10	5-25
4.2 Spheroidal graphite iron	<310 HB	GGG 40	5-20
4.3 Ductile iron	<280 HB	GTW-55	5-20
5. Special alloys			
5.1 Titanium alloy	<1200	TiAl5Sn2,5	1-5

