

Application values Blind-hole screw tap Hyper Z (VA) (Art. no. 1014411 005-011)



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	5-10
1.2 Structural steel	<500	ST 37-2	5-10
1.3 Structural steel	> 500	ST 60-2	5-10
1.4 Heat-treated steel	<1000	42 CrMo 4	5-10
1.6 Case-hardened steel	<1200	16 MnCr 5	5-10
1.7 Ferritic/martensitic stainless steel	<1100	X 10 Cr 13	5-10
1.8 Heat-treated steel	>1000	43 CrMo 4	5-10
1.9 Nitriding steel	<1300	31 CrMoV 9	5-10
1.10 Tool steel	<1300	X 38 CrMoV 5 1	5-10
2. Stainless steels			
2.1 Austenitic stainless steel	<1100	G-X 2 CrNiMo 18 15	5-10
3. Non-ferrous metals			
3.1 Long-chipping aluminium	<500	Al99.9	10-25
3.2 Short-chipping aluminium	<500	G-AlSi12	10-25
3.3 Copper alloy bronze, long-chipping	<1200	CuSn4	6-11
3.4 Copper alloy bronze, short-chipping	<850	CuNi12Zn24	6-11
3.5 Copper alloy brass, long-chipping	<600	Cu Zn 20	6-11
3.7 Thermoplastic	<600	Cu Zn 39 Pb 3	6-11
	<100	PVC, Acrylglas	10-20
3.8 Duroplast	<150	Bakelit, Melamin	10-20

