



### PRODUCT DESCRIPTION

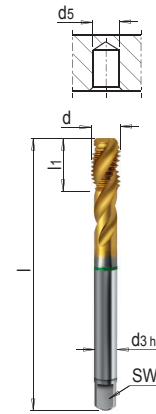
» For ISO metric threads

### MATERIAL

» HSS-E (5% Co), TiN coated



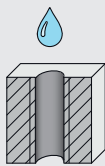
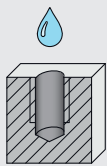
SW	d3	d5	l	l1	P	d	No.	EUR
-	2.2	2.5	56	6	0.5	<b>M 3</b>	WZG 34121/ 3	< >
2.1	2.8	3.3	63	7.5	0.7	<b>M 4</b>	WZG 34121/ 4	< >
2.7	3.5	4.2	70	8.5	0.8	<b>M 5</b>	WZG 34121/ 5	< >
3.4	4.5	5	80	11	1	<b>M 6</b>	WZG 34121/ 6	< >
4.9	6	6.8	90	14	1.25	<b>M 8</b>	WZG 34121/ 8	< >
5.5	7	8.5	100	16	1.5	<b>M10</b>	WZG 34121/10	< >
7	9	10.2	110	18.5	1.75	<b>M12</b>	WZG 34121/12	< >
9	11	12	110	20	2	<b>M14</b>	WZG 34121/14	< >
9	12	14	110	20	2	<b>M16</b>	WZG 34121/16	< >
11	14	15.5	125	25	2.5	<b>M18</b>	WZG 34121/18	< >
12	16	17.5	140	25	2.5	<b>M20</b>	WZG 34121/20	< >
14.5	18	21	160	30	3	<b>M24</b>	WZG 34121/24	< >



### GUIDELINE FOR TAPPING

WZG 341112  
WZG 34121  
WZG 341215  
WZG 34221  
WZG 34521

WZG 34123  
WZG 341235  
WZG 34223  
WZG 34523



Material	Strength	Vc <sup>1</sup> m/min.
1.1730	640 N/mm <sup>2</sup>	10
1.2083	780 N/mm <sup>2</sup>	8
1.2085	1080 N/mm <sup>2</sup>	6
1.2162	660 N/mm <sup>2</sup>	10
1.2311	1080 N/mm <sup>2</sup>	6
1.2312	1080 N/mm <sup>2</sup>	6
1.2316	1010 N/mm <sup>2</sup>	6
1.2343	780 N/mm <sup>2</sup>	10
1.2379	780 N/mm <sup>2</sup>	6
1.2767	830 N/mm <sup>2</sup>	8
1.2842	775 N/mm <sup>2</sup>	10

1) Vc: cutting speed (m/min.)

**i** You can find further materials and cutting values in the cutting data calculator.