



### PRODUCT DESCRIPTION

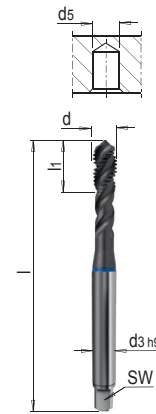
» For ISO metric threads

### MATERIAL

» HSS, TiAlN coated



SW	d3	d5	l	l1	d	P	No.	EUR
3.4	4.5	5.2	80	8	M 6	0.75	WZG 342217/ 6x0,75	< >
4.9	6	7.2	80	8	M 8	0.75	WZG 342217/ 8x0,75	< >
4.9	6	7	90	11	M 8	1	WZG 342217/ 8x1	< >
5.5	7	9	90	11	M10	1	WZG 342217/10x1	< >
5.5	7	8.8	100	14	M10	1.25	WZG 342217/10x1,25	< >
7	9	11	100	11	M12	1	WZG 342217/12x1	< >
7	9	10.8	100	16	M12	1.25	WZG 342217/12x1,25	< >
7	9	10.5	100	16	M12	1.5	WZG 342217/12x1,5	< >
9	11	12.5	100	15	M14	1.5	WZG 342217/14x1,5	< >
9	12	14.5	100	15	M16	1.5	WZG 342217/16x1,5	< >
11	14	16.5	110	16	M18	1.5	WZG 342217/18x1,5	< >



**i** Cutting data on page IL

### GUIDELINE FOR TAPPING

WZG 341312 WZG 341217 WZG 341219 WZG 342217 WZG 345217	WZG 341237	Material	Strength	Vc <sup>1)</sup> m/min.
		1.1730	640 N/mm <sup>2</sup>	12
		1.2083	780 N/mm <sup>2</sup>	10
		1.2085	1080 N/mm <sup>2</sup>	8
		1.2162	660 N/mm <sup>2</sup>	12
		1.2311	1080 N/mm <sup>2</sup>	8
		1.2312	1080 N/mm <sup>2</sup>	8
		1.2316	1010 N/mm <sup>2</sup>	8
		1.2343	780 N/mm <sup>2</sup>	12
		1.2379	780 N/mm <sup>2</sup>	8
		1.2767	830 N/mm <sup>2</sup>	10
		1.2842	775 N/mm <sup>2</sup>	8

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

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