



### PRODUCT DESCRIPTION

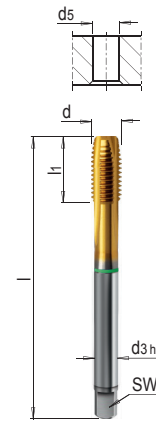
» For metric ISO fine threads

### MATERIAL

» HSS-E (5% Co), TiN coated



SW	d3	d5	l	l1	d	P	No.	EUR
4.9	6	7.2	80	14	M 8	0.75	WZG 34223/ 8x0,75	< >
5.5	7	9	90	17	M10	1	WZG 34223/10x1	< >
9	11	12.5	100	20	M14	1.5	WZG 34223/14x1,5	< >
9	12	14.5	100	22	M16	1.5	WZG 34223/16x1,5	< >
14.5	18	22.5	140	28	M24	1.5	WZG 34223/24x1,5	< >
14.5	18	22	140	28	M24	2	WZG 34223/24x2	< >



### GUIDELINE FOR TAPPING

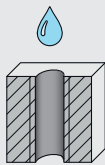
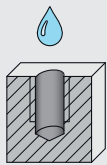
WZG 341112  
WZG 34121  
WZG 341215  
WZG 34221  
WZG 34521

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.