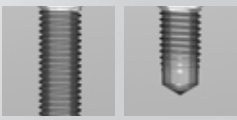
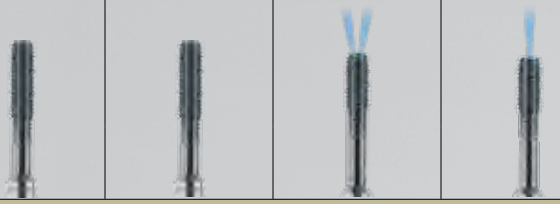


	Thread depth	≤3xD				
	Tool material	HSS-E-PM				
	Lead form	C	E	C	E	
	Surface	C	C	C	C	
	Coolant delivery	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	
	Shank tolerance	h6	h6	h6	h6	
						
<ul style="list-style-type: none"> ● = Neat oil ○ = Soluble oil △ = Paste □ = MQL 	Thread type	Tolerance	Article no./page			
	M	6HX	4487 p. 4	4494 p. 4	4485 p. 6	4483 p. 5
		6GX	4488 p. 4			
	MF	6HX	4489 p. 7	4495 p. 7	4486 p. 9	4484 p. 8
		6GX	4490 p. 7			
	UNC	2BX	4491 p. 10			
	UNF	2BX	4492 p. 11			
G	- X	4493 p. 12				
Suitable lubricant:		○/●/△	○/●/△	○/●/△/□	○/●/△/□	

Group of materials		Tensile strength	Material example	Material no.	Recommended cutting speed v _c [SFM]				
P	P1 Structural and free cutting steels, heat-treatable steels unalloyed	≤800 N/mm ²	S235JR C15 11SMnPb30	1.0037 1.0401 1.0718	80	80	80	80	
	P2 Free-cutting steels, unalloyed case hardened steels, nitriding steels	800 - 1000 N/mm ²	S355J2 C60 31CrMo12	1.0577 1.0601 1.8515	80	80	80	80	
	P3 Alloyed heat-treatable steels, tool steels, high speed steels	800 - 1200 N/mm ²	42CrMo4 36CrNiMo4 X36CrMo17 HS 6-5-2	1.7225 1.6511 1.2316 1.3343	50	50	50	50	
M	M1 Stainless steels, sulphured, austenitic	≤1000 N/mm ²	X5CrNi18-10 X6CrNiTi18-10 X8CrNiS18-9	1.4301 1.4571 1.4305	50	50	50	50	
	M2 Stainless- and acidresistant steels, martensitic	≤1000 N/mm ²	X17CrNi16-2 X90CrMoV18 X2CrTi12	1.4057 1.4112 1.4512	35	35	35	35	
	M3 Duplex and Super Duplex	≤1300 N/mm ²	X2CrNiMoN22-5-3 X2CrNiMoN25-7-4 X2CrNiMoCuWN25-7-4	1.4462 1.4410 1.4501	20	20	20	20	
K	K1 Cast Iron	300 HB	EN-GJL-150 EN-GJL-250 EN-GJL-300	0.6015 0.6025 0.6030					
	K2 Spheroidal graphite iron and malleable cast iron	350 HB	EN-GJS-400-15 EN-GJS-600-3 EN-GJS-700-2	0.7040 0.7060 0.7070	100	100	100	100	
	K3 ADI GGV	1000 N/mm ² 350 HB	EN-GJS1000-5 EN-GJV250 EN-GJV400		80	80	80	80	
N	N1 Aluminium and wrought alloys	≤450 N/mm ²	Al99,5H AlMgSi1 AlZn4,5Mg	3.0250 3.2315 3.4335	50	50	50	50	
	N2 Al cast alloys	≤600 N/mm ²	GD-AlSi8Cu1Mg GD-AlSi8Cu3 G-AlSi9Mg G-AlSi12	3.2134 3.2162 3.2373 3.2581	100	100	100	100	
	N3 Magnesium alloys	≤500 N/mm ²	GDMgAl8Zn1	3.5812.08					
	N4 Copper and copper alloys	long-chipping		CuZn20 CuZn37Pb0,5	2.0250 2.0332	100	100	100	100
		short-chipping		CuZn39Pb2 CuZn43Pb2	2.0380 2.0410				
	N5 Copper special alloys	≤1400 N/mm ²	Ampco						
N6 Plastics (Thermoplastics, Duroplastics)	long-chipping short-chipping	PMMA, POM,PVC Pertinax							
S	S1 Titanium and Titanium alloys	≤ 1200 N/mm ²	Titan TiAl5Sn2 TiAl6V4	3.702<5 3.7115 3.7165	25	25	25	25	
	S2 Nickel, cobalt, iron alloys	≤ 1400 N/mm ²	Hastelloy C4 Inconel 718 Nimonic 105	2.4610 2.4668 2.4634	25	25	25	25	
H	H1 High tensile/	45 - 55 HRC							
	H2 hardened steels	55 - 62 HRC							