



PRODUCT DESCRIPTION

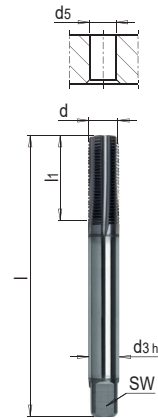
- » For hardened steel
- » For metric ISO fine threads

MATERIAL

- » Carbide, TiCN coated



SW	d3	d5	l	l1	d	P	No.	EUR
4.9	6	5.6	80	15	M6	0.5	WZG 12251/ 6x0,5	< >
6.2	8	7.1	90	18	M8	1	WZG 12251/ 8x1	< >
8	10	9.1	90	22	M10	1	WZG 12251/10x1	< >
9	12	11.1	100	25	M12	1	WZG 12251/12x1	< >
9	12	10.6	100	28	M12	1.5	WZG 12251/12x1,5	< >



GUIDELINE FOR TAPPING

WZG 12151 WZG 12251	Material	Strength	Vc ¹⁾ m/min.
	1.2379	60 HRC	1
	1.2842	60 HRC	1

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

- » Drill the hole diameter larger by approx. 0.1 mm (using WZB 10253).
- » Use cutting oil
- » Clamp with a rigid or synchro chuck

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