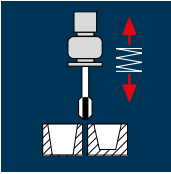




## Application



## Material

Steel  
< 500 N/mm<sup>2</sup>



Steel  
500 - 850 N/mm<sup>2</sup>



Steel  
850 - 1100 N/mm<sup>2</sup>



Wrought aluminium alloys  
Si < 6%  
hardened



Cast iron  
GG



NPTF	P(TPI)	d [mm]	P [mm]	$v_c$ [m/min]	n [min <sup>-1</sup> ]	$v_f$ [mm/min]
1/16	-27.0	6.250	0.941	8	405	381
1/8	-27.0	8.500	0.941	8	300	282
1/4	-18.0	11.100	1.411	8	230	325
3/8	-18.0	14.700	1.411	8	175	247
1/2	-14.0	18.000	1.814	8	140	254
1/16	-27.0	6.250	0.941	6	305	287
1/8	-27.0	8.500	0.941	6	225	212
1/4	-18.0	11.100	1.411	6	170	240
3/8	-18.0	14.700	1.411	6	130	183
1/2	-14.0	18.000	1.814	6	105	191
1/16	-27.0	6.250	0.941	5	255	240
1/8	-27.0	8.500	0.941	5	185	174
1/4	-18.0	11.100	1.411	5	145	205
3/8	-18.0	14.700	1.411	5	110	155
1/2	-14.0	18.000	1.814	5	90	163
1/16	-27.0	6.250	0.941	10	510	480
1/8	-27.0	8.500	0.941	10	375	353
1/4	-18.0	11.100	1.411	10	285	402
3/8	-18.0	14.700	1.411	10	215	303
1/2	-14.0	18.000	1.814	10	175	318
1/16	-27.0	6.250	0.941	6	305	287
1/8	-27.0	8.500	0.941	6	225	212
1/4	-18.0	11.100	1.411	6	170	240
3/8	-18.0	14.700	1.411	6	130	183
1/2	-14.0	18.000	1.814	6	105	191