

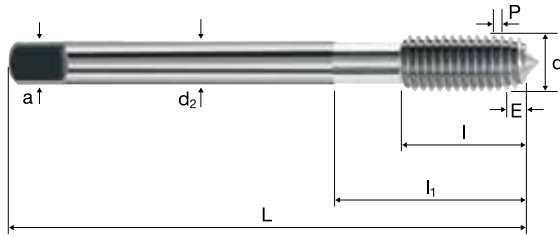
Cold forming



M
ISO 2
(6H)

HSS
PM/F

Form E



Rm
 < 850

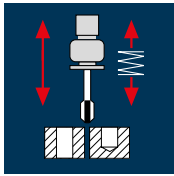
Rm
 850-1100

Inox
 Stainless

										TiCN
										EH10071
Example: Order-N°. EH10071 240										
Ø Code	d	P	L	I	I ₁	d ₂	a			
240	M 12	1.75	110	24.00	40.0	9.0	7.0	7	11.20	●
244	M 14	2.00	110	26.00	40.0	11.0	9.0	7	13.10	●
246	M 16	2.00	110	27.00	40.0	12.0	9.0	7	15.10	●

CF

Application



Material

Steel
 $< 850 \text{ N/mm}^2$
 $A_5 > 10\%$



Steel
 $850 - 1100 \text{ N/mm}^2$
 $A_5 > 10\%$



Stainless steel
 ferritic/martensitic
 $A_5 > 10\%$



Stainless steel
 [Cr-Ni/1.4301]



M	d [mm]	P [mm]	v_c $1.5 \times d$			v_c $2.0 \times d$			v_c $3.0 \times d$		
			n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	
M12	12.000	1.75	20	530	928	15	400	700	10	265	464
M14	14.000	2.00	20	455	910	15	340	680	10	225	450
M16	16.000	2.00	20	400	800	15	300	600	10	200	400
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-
M12	12.000	1.75	15	400	700	10	265	464	-	-	-
M14	14.000	2.00	15	340	680	10	225	450	-	-	-
M16	16.000	2.00	15	300	600	10	200	400	-	-	-