



### PRODUCT DESCRIPTION

» Fluteless tap with oil grooves for ISO metric threads

### MATERIAL

» HSS-E (5% Co), TiN coated



SW	d3	d5	l	l1	P	d	No.	EUR
2.7	3.5	2.8	56	10	0.5	<b>M 3</b>	WZG 32120/ 3	< >
3.4	4.5	3.7	63	12	0.7	<b>M 4</b>	WZG 32120/ 4	< >
4.9	6	4.65	70	14	0.8	<b>M 5</b>	WZG 32120/ 5	< >
4.9	6	5.55	80	16	1	<b>M 6</b>	WZG 32120/ 6	< >
6.2	8	7.4	90	17	1.25	<b>M 8</b>	WZG 32120/ 8	< >
8	10	9.3	100	20	1.5	<b>M10</b>	WZG 32120/10	< >
7	9	11.2	110	24	1.75	<b>M12</b>	WZG 32120/12	< >



### REFERENCE VALUES FOR WORKING WITH FLUTELESS TAPS

WZG 32120 WZG 32520		Material	Strength	Vc <sup>1</sup> m/min.
		1.1730	640 N/mm <sup>2</sup>	20
		1.2083	780 N/mm <sup>2</sup>	20
		1.2162	660 N/mm <sup>2</sup>	20
		1.2311	1080 N/mm <sup>2</sup>	10
		1.2312	1080 N/mm <sup>2</sup>	10
		1.2343	780 N/mm <sup>2</sup>	20
		1.2379	780 N/mm <sup>2</sup>	20
		1.2767	830 N/mm <sup>2</sup>	10
		1.2842	775 N/mm <sup>2</sup>	20
		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.

### WHICH CUTTING FLUID IS RIGHT FOR WORKING WITH FLUTELESS TAPS?

When working with fluteless taps the main task of the cutting fluids is the lubrication. The more lubricant used with the maximum possible grease concentration, the longer the service life of the fluteless taps.

For water-miscible cutting fluids the grease concentration must not be less than 6%. A grease content of >12% is ideal to reach the optimal service life.

