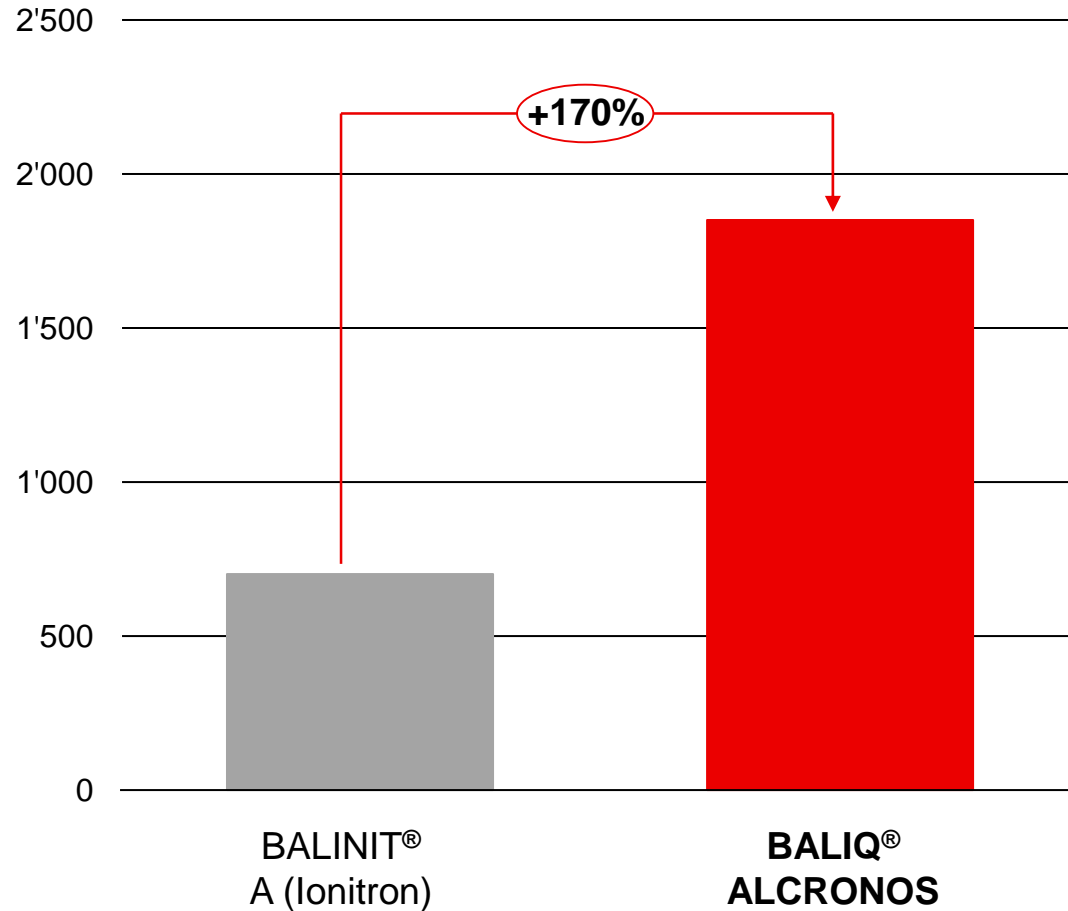


# Process reliability in thread forming

## Application: Stainless steel

Tool life [number of threads]



### Tool

PM-HSS thread former M3

### Workpiece

Steel 1.4571, X6CrNiMoTi1712  
(AISI 316Ti, SUS 316 Ti)

### Machining

$v_c = 12$  m/min  
Thread depth: 7.5 mm  
Blind hole  
Emulsion 6%

### Source

Oerlikon Balzers and  
University of Hamburg