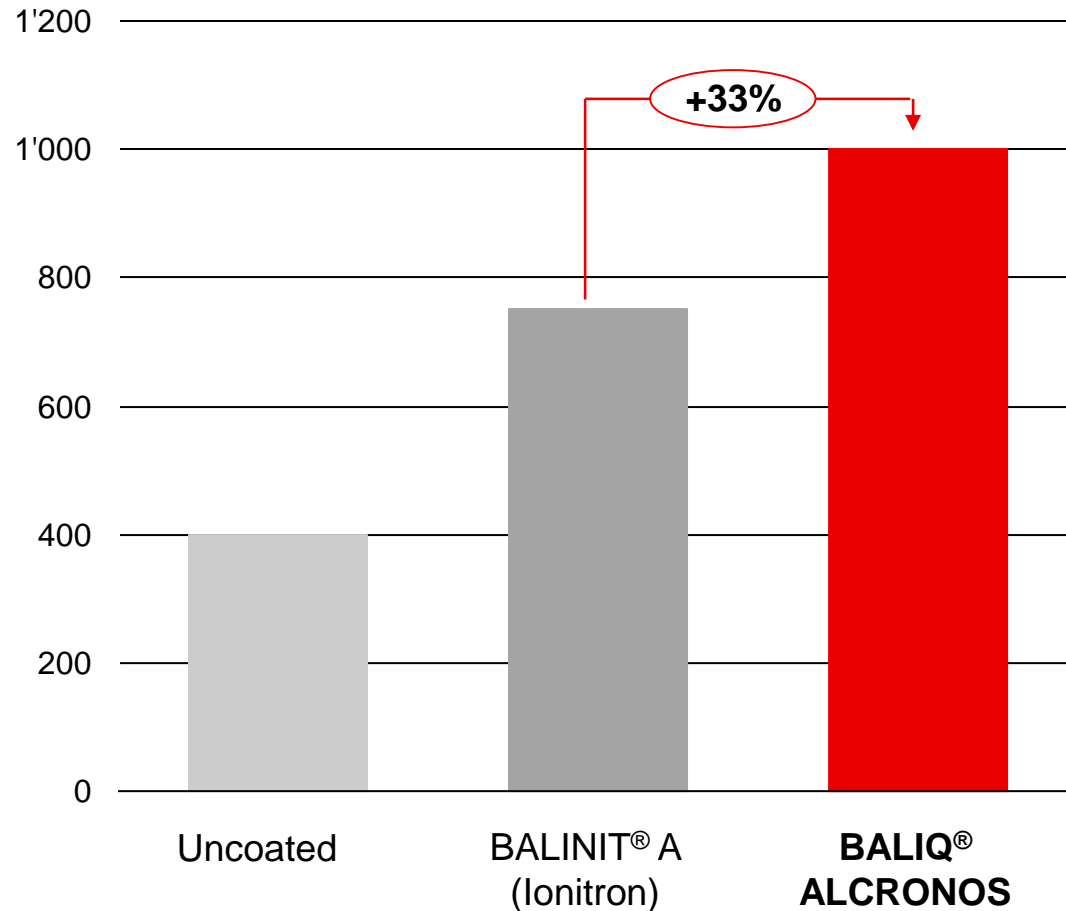


BALIQ ALCRONOS

Tapping of steel at moderate cutting conditions

Tool life [parts]



Tool:

HSS Taps M12 x 1.25
Spiral Flute

Workpiece :

Steel 1.1141, Ck15
(AISI 1015, JIS S15C)
120-140 HB

Cutting data :

Spindle speed 600 rpm

Criteria for end of tool life

Thread quality

Source:

Enduser automotive industry