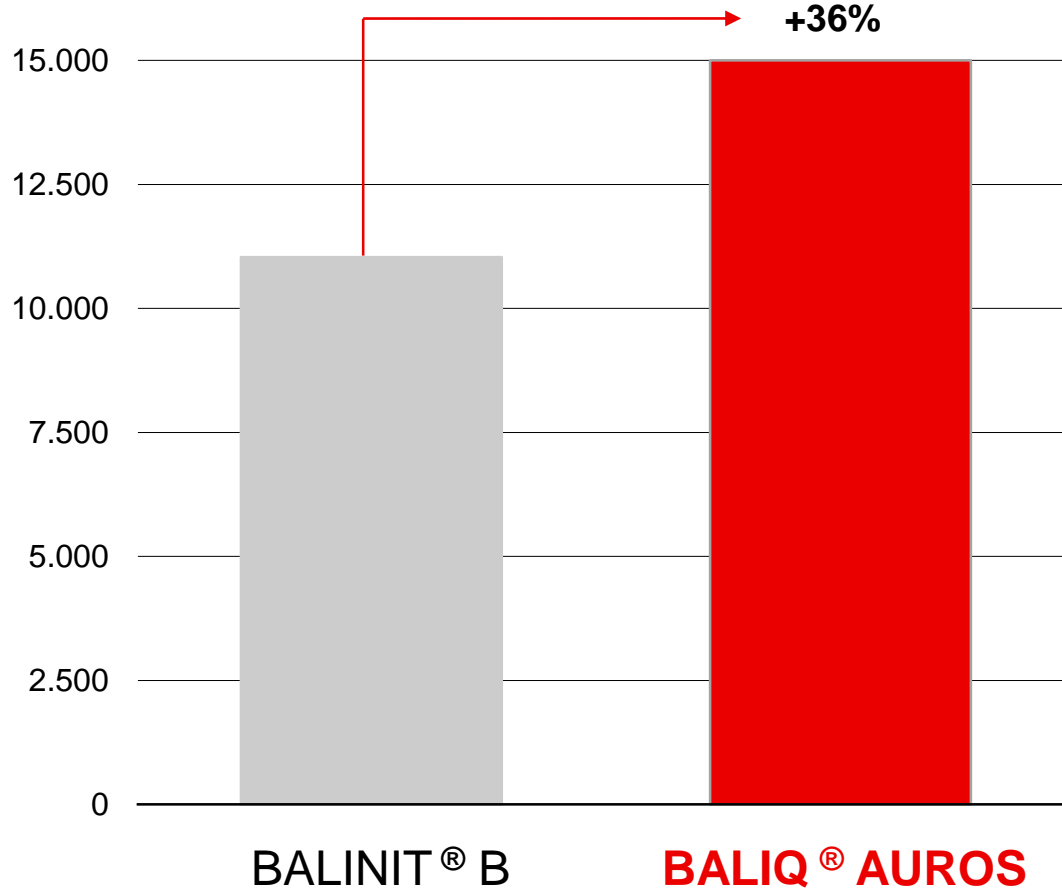


BALIQ AUROS

Tapping of carbon steel

Tool life [number of threads]



Tool

PM-HSS tap M6

Workpiece

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

Cutting parameters

$v_c = 30$ m/min
Thread depth: 10 mm
Blind hole
Emulsion

Source

Tool manufacturer