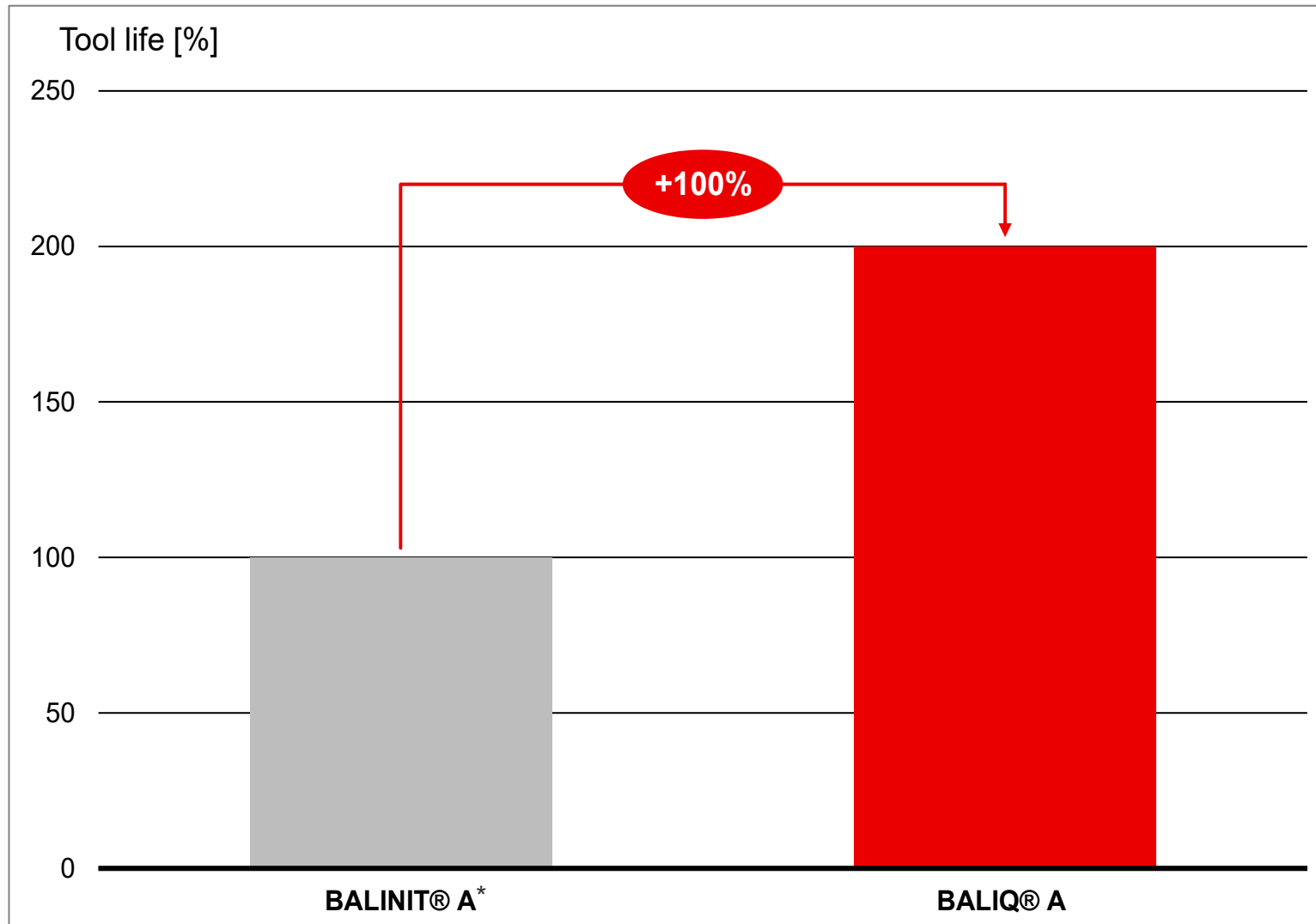


BALIQ A

Spiral flute tap

oerlikon



* Based on Ionitron Technology (BAI 830)

Tool:

Spiral flute tap M6x1

Workpiece:

Mid-strength steel ($R_m \approx 800$ MPa)
Blind hole

Cutting data:

Cutting speed $v_c = 10$ m/min
Spindle speed = 532 min^{-1}
Thread depth $l = 12.3 \text{ mm} / 2xD$

Benefit:

Longer tool life
Reduced wear

Source/Customer:

European tool manufacturer

oerlikon
balzers