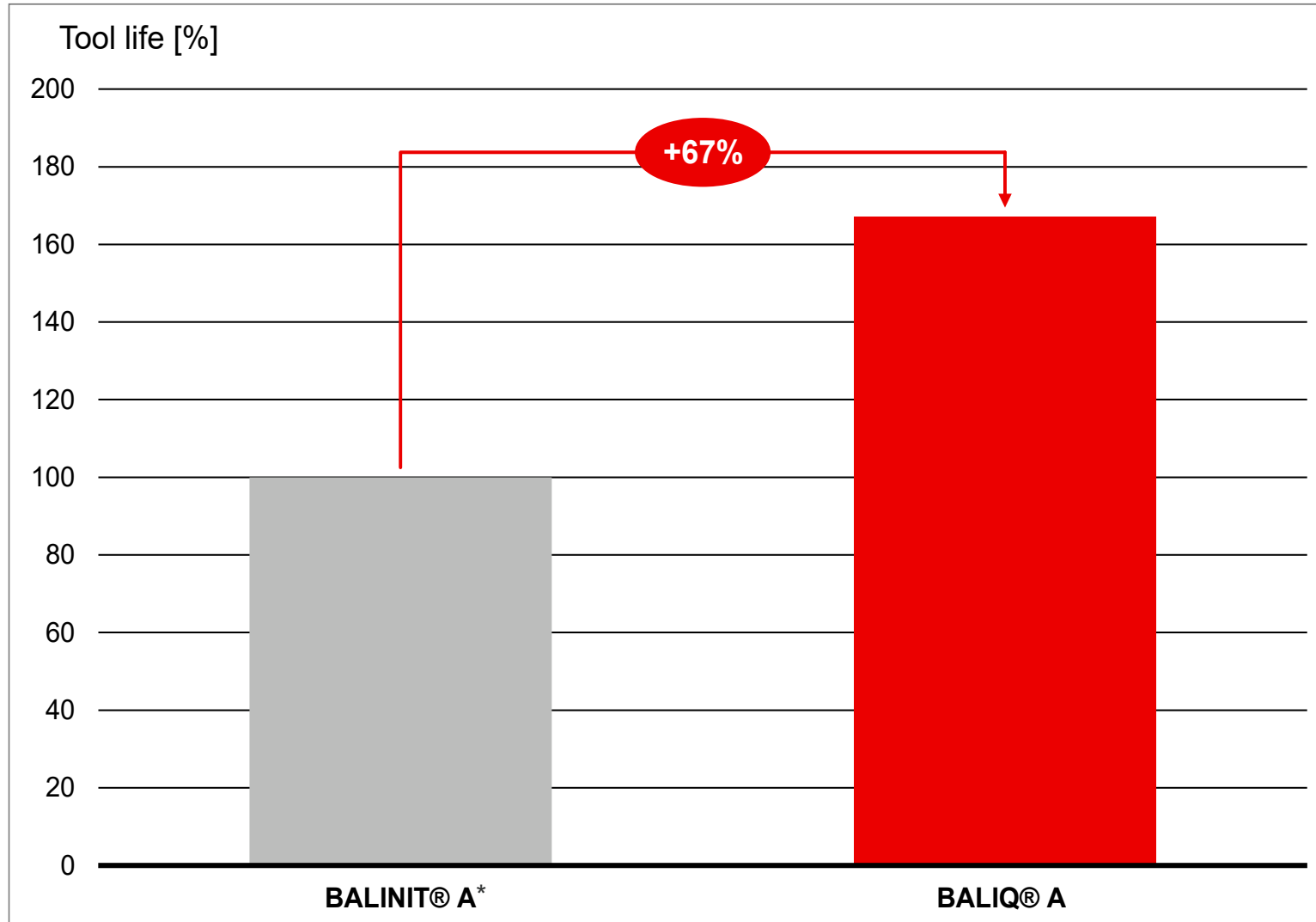


BALIQ A

Thread forming tap

oerlikon



Tool:

Thread forming tap M6x1

Workpiece:

Mid-strength steel ($R_m \approx 800 \text{ MPa}$)

Cutting data:

Cutting speed $v_c = 25 \text{ m/min}$

Spindle speed $n = 1'326 \text{ min}^{-1}$

Thread depth $l = 12.3 \text{ mm} / 2xD$

Benefit:

Longer tool life

Source/Customer:

European tool manufacturer

* Based on Ionitron Technology (BAI 830)

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