It's not allowed to change the master

Tapping of carbon steel

**Tool**
PM-HSS tap M6

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

**Cutting parameters**

\[ v_c = 30 \text{ m/min} \]
Thread depth: 10 mm
Blind hole
Emulsion

**Source**
Tool manufacturer

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BALIQ AUROS - The high-end solution for threading tools (September 2019)