Anschnittform
Chamfer form

A 5–6 Gang Threads
B 3,5–5 Gang Threads
C 2–3 Gang Threads
D 3,5–5 Gang Threads
E 1,5–2 Gang Threads
1. Wahl 1. Choice
2. Wahl 2. Choice

Oberflächenbehandlung/Beschichtung
Subsequent treatment of surface/coating

0 unbeschichtet uncoated
1 TiCN Plus
2 IQ Plus
3 Al2 Plus
4 CrN
5 nitriert nitrited
6 vaporisiert vaporised
7 Polaris (neu new**)**

1. Empfehlung – gut geeignet
Choise – well suited
2. Empfehlung – auch geeignet
Choise – also suited



Kat.-Nr. Cat.-No.	**6411C 6412C 6413C 6417C 6418C 6419C 6701C 6705C G411C G412C G413C**	**6701C 6705C**	**6411C 6412C 6413C 6418C 6419C**		**6491C 6492C**	**6570C 6574C**	**6431 6432 6434**	**6431C 6432C 6434C G431C G432C G434C**	**6431C 6432C 6434C**	**6735C 6736C**	**6741 6742 6744**	**6741C 6742C 6744C 6747C**
Material	HSS-E-PM											
Typ Type	V				VDRY	HPT-IK	H			TiNi	VR15	
Drallwinkel Helix angle	0°										15°	
Anschnitt Chamfer	B										C	C, E
Beschichtung Coating	1	2	2	4	1		5	1	2	3	0	1
Toleranz Tolerance	6H, 6GX, 2B	2B	6H		6H	6HX	6H	6H			6HX	
M	D.18		D.19	D.20	D.24	D.24	D.22	D.22	D.23	D.25	D.26	D.27
MF	D.49		D.49	D.50	D.50		D.51	D.51	D.51		D.52	D.52
UNC	D.61	D.65	D.62									
UNF	D.67	D.69	D.67									
G	D.71											D.72
NPT/NPTF												

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	Werkstoff	**Material**	**R_m/UTS (N/mm²)**	v_c										
P	Unlegierter Baustahl	Plain carbon steel	–700	**25–35**	**25–35**	**20–30**		**25–35**	**30–40**					**20–30**	**25–35**
	Automatenstahl	Free cutting steel	–700	**25–35**	**25–35**	**20–30**		**25–35**	**35–45**					**20–30**	**25–35**
	Baustahl	Structural alloy steel	500–950	**25–35**	**25–35**	**20–30**		**25–35**	**25–40**					**20–30**	**25–35**
	Vergütungsstahl, mittelfest	Heat-treatment steel, medium strength	500–950	**20–25**	**20–25**	**15–20**		**20–25**	**20–30**	15–20	20–25	20–25	20–25	**15–20**	**20–25**
	Stahlguss	Cast steel	–950	**20–25**	**20–25**	**12–18**		**20–25**	**20–25**	15–20	20–25	20–25	20–25	**12–18**	**20–25**
	Einsatzstahl	Case hardening steel	–950	**20–25**	**20–25**	**12–18**		**20–25**	**30–40**	15–20	20–25	20–25	20–25	**12–18**	**20–25**
	Rost- und säurebeständiger Stahl, ferritisch, martensitisch	Stainless steel, ferritic, martensitic	500–950	**10–20**	**10–20**	**10–15**		**10–20**	**15–20**					10–15	**10–20**
	Vergütungsstahl, hochfest	Heat-treatment steel, high strength	950–1400	**10–20**	**10–20**	**8–12**		**10–20**	**15–25**	8–10	**10–20**	**10–20**	**10–20**	8–12	**10–20**
	Nitrierstahl, vergütet	Nitriding steel	950–1400	**10–20**	**10–20**	8–10		**10–20**	**15–25**	8–10	**10–20**	**10–20**	**10–20**	8–10	**10–20**
	Werkzeugstahl (bis 45 HRC)	Tool steel (to 45 HRC)	950–1400	**10–15**	**10–15**	8–10		**10–15**	**15–20**	8–10	**10–15**	**10–15**	**10–15**	8–10	**10–15**
M	Rost- und säurebeständiger Stahl, austenitisch	Stainless steel, austenitic	500–950	**10–15**	**10–15**	8–10		**10–15**	**15–20**					8–10	**10–15**
	Martensitaushärtbarer Stahl	Maraging steel		**8–12**	**8–12**	6– 8		**8–12**	**12–18**					6– 8	**8–12**
K	Grauguss	Grey cast iron	100–400 (120–260 HB)	20–30	20–30	20–30		20–30	30–45	20–30	20–30	20–30	20–30		20–30
	Legierter Grauguss	Alloyed grey cast iron	150–250 (160–230 HB)	20–30	20–30	20–30		20–30	30–40	20–30	20–30	20–30	20–30		20–30
	Sphäroguss	Nodular cast iron	400–800 (120–310 HB)	15–20	15–20	15–20		15–20	34–45	15–20	15–20	15–20	15–20		15–20
	Temperguss	Malleable cast iron	350–700 (150–280 HB)	15–20	15–20	15–20		15–20	35–45	15–20	15–20	15–20	15–20		15–20
N	Rein-Metalle, weich	Pure metals, soft	–500	20–30	20–30	15–20	**20–30**	20–30	20–30					15–20	20–30
	Aluminium-Legierungen, langspanend	Aluminium alloys, long chipping	–550	**25–35**	**25–35**	**20–30**	**25–35**	**25–35**	**30–40**					**20–30**	**25–35**
	Aluminium-Legierungen, kurzspanend	Aluminium alloys, short chipping	–400	**20–30**	**20–30**	**15–20**	20–30	**20–30**	**25–35**	15–25	20–30	20–30	20–30	**15–20**	**20–30**
	Kupfer-Legierungen, langspanend	Copper alloys, long chipping	300–700	**25–35**	**25–35**	**20–30**	**25–35**	**25–35**	**30–40**					**20–30**	**25–35**
	Kupfer-Legierungen, kurzspanend	Copper alloys, short chipping	–500	**15–25**	**15–25**	**10–20**		**15–25**	**20–30**	10–20	15–25	15–25	15–25	**10–20**	**15–25**
	Magnesium-Legierungen	Magnesium alloys	150–300	15–20	15–20	10–20		15–20						10–20	15–20
	Thermoplaste	Thermoplastics	40–70	20–30	20–30	10–20	20–30	20–30						10–20	20–30
	Duroplaste	Duroplastics	20–40	**20–30**	**20–30**	10–20	**20–30**	20–30						10–20	**20–30**
	Graphit	Graphite													
S	Titan-Legierungen, mittelfest	Titanium alloys, medium strength	–950	4– 6	4– 6			4– 6		4– 6	4– 6	4– 6	**8–12**		4– 6
	Titan-Legierungen, hochfest	Titanium alloys, high strength	900–1400	2– 5	2– 5			2– 5		2– 5	2– 5	2– 5	**5–10**		2– 5
	Nickelbasis-Legierungen, mittelfest	Nickel based alloys, medium strength	–950	4– 6	4– 6			4– 6		4– 6	4– 6	4– 6	**5–10**		4– 6
	Nickel-Basis-Legierungen, hochwarmfest	Heat resistant nickel based alloys, high strength	900–1400	2– 5	2– 5			2– 5		2– 5	2– 5	2– 5	**3– 7**		2– 5
H	Hartguss	Chilled cast iron	300–600 HB												