

# Rekord 1A-Z-TICN

## machine taps



applications - materials		cutting speed vc in m/min			
		min.	recommended	max.	
K1.1	Cast iron with lamellar graphite (GJL)	100-250 N/mm <sup>2</sup>	15	30	45
K1.2	Cast iron with lamellar graphite (GJL)	250-450 N/mm <sup>2</sup>	15	30	45
K2.1	Cast iron with nodular graphite (GJS)	350-500 N/mm <sup>2</sup>	15	30	45
K2.2	Cast iron with nodular graphite (GJS)	500-900 N/mm <sup>2</sup>	10	20	40
K3.1	Cast iron with vermicular graphite (GJV)	300-400 N/mm <sup>2</sup>	15	30	45
K3.2	Cast iron with vermicular graphite (GJV)	400-500 N/mm <sup>2</sup>	15	30	45
K4.1	Malleable cast iron (GTMW, GTMB)	250-500 N/mm <sup>2</sup>	10	20	30
K4.2	Malleable cast iron (GTMW, GTMB)	500-800 N/mm <sup>2</sup>	10	20	30
N1.5	Aluminium cast alloys	7% < Si <= 12%	30	50	80
N1.6	Aluminium cast alloys	12% < Si <= 17%	10	20	30
N2.6	Copper-tin alloys (tin bronze, short-chipping)	<= 400 N/mm <sup>2</sup>	10	20	30
N4.1	Duroplastics (short-chipping)		10	20	40