

# Rekord 1B-Z-PM-GLT-1

## machine taps



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P1.1 Construction steels, Free-cutting steels, etc.	<= 600 N/mm <sup>2</sup>	15	<b>25</b>	45
P2.1 Construction steels, Cementation steels, Steel castings, etc.	<= 800 N/mm <sup>2</sup>	10	<b>20</b>	40
P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc.	<= 1000 N/mm <sup>2</sup>	5	<b>15</b>	25
P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.	<= 1200 N/mm <sup>2</sup>	5	<b>10</b>	15
P5.1 High-alloyed steels, Cold work steels, Hot work steels, etc.	<= 1400 N/mm <sup>2</sup>	2	<b>8</b>	10
M1.1 Ferritic, martensitic	<= 950 N/mm <sup>2</sup>	5	<b>8</b>	12
M2.1 Austenitic	<= 950 N/mm <sup>2</sup>	5	<b>8</b>	12
M3.1 Austenitic-ferritic (Duplex)	<= 1100 N/mm <sup>2</sup>	2	<b>5</b>	8
M4.1 Austenitic-ferritic heat-resistant (Super Duplex)	<= 1250 N/mm <sup>2</sup>	2	<b>5</b>	8
K1.1 Cast iron with lamellar graphite (GJL)	100-250 N/mm <sup>2</sup>	5	<b>15</b>	25
K1.2 Cast iron with lamellar graphite (GJL)	250-450 N/mm <sup>2</sup>	5	<b>15</b>	25
K2.1 Cast iron with nodular graphite (GJS)	350-500 N/mm <sup>2</sup>	5	<b>10</b>	20
K2.2 Cast iron with nodular graphite (GJS)	500-900 N/mm <sup>2</sup>	5	<b>10</b>	20
K3.1 Cast iron with vermicular graphite (GJV)	300-400 N/mm <sup>2</sup>	5	<b>10</b>	20
K3.2 Cast iron with vermicular graphite (GJV)	400-500 N/mm <sup>2</sup>	5	<b>10</b>	20
N1.4 Aluminium cast alloys	Si <= 7%	15	<b>30</b>	40
N2.1 Pure copper, low-alloyed copper	<= 400 N/mm <sup>2</sup>	5	<b>15</b>	30
N2.2 Copper-zinc alloys (brass, long-chipping)	<= 550 N/mm <sup>2</sup>	10	<b>25</b>	40
N2.4 Copper-aluminium alloys (alu bronze, long-chipping)	<= 800 N/mm <sup>2</sup>	5	<b>15</b>	25
N2.5 Copper-tin alloys (tin bronze, long-chipping)	<= 700 N/mm <sup>2</sup>	5	<b>15</b>	25
S1.1 Pure titanium	<= 450 N/mm <sup>2</sup>	1	<b>5</b>	7
S2.2 Nickel-base alloys	<= 1000 N/mm <sup>2</sup>	1	<b>3</b>	5
S2.3 Nickel-base alloys	<= 1600 N/mm <sup>2</sup>	1	<b>3</b>	5