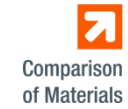


Rekord 1D-TI-TICN

machine taps



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.	$\leq 1200 \text{ N/mm}^2$	5	10	15
P5.1 High-alloyed steels, Cold work steels, Hot work steels, etc.	$\leq 1400 \text{ N/mm}^2$	2	5	10
M3.1 Austenitic-ferritic (Duplex)	$\leq 1100 \text{ N/mm}^2$	2	5	8
M4.1 Austenitic-ferritic heat-resistant (Super Duplex)	$\leq 1250 \text{ N/mm}^2$	2	5	8
N2.4 Copper-aluminium alloys (alu bronze, long-chipping)	$\leq 800 \text{ N/mm}^2$	5	15	25
N2.5 Copper-tin alloys (tin bronze, long-chipping)	$\leq 700 \text{ N/mm}^2$	5	15	25
N2.7 Special copper alloys	$\leq 600 \text{ N/mm}^2$	2	5	10
S1.1 Pure titanium	$\leq 450 \text{ N/mm}^2$	1	5	7
S1.2 Titanium alloys	$\leq 900 \text{ N/mm}^2$	1	3	5
S1.3 Titanium alloys	$\leq 1250 \text{ N/mm}^2$	1	4	8
S2.1 Pure nickel	$\leq 600 \text{ N/mm}^2$	1	3	5
S2.2 Nickel-base alloys	$\leq 1000 \text{ N/mm}^2$	1	3	5
S2.4 Cobalt-base alloys	$\leq 1000 \text{ N/mm}^2$	1	3	5