

InnoForm 1-AL/E-SN-IKZ-PM-GLT-8

machine cold-forming taps



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
N1.1 Aluminium wrought alloys	$\leq 200 \text{ N/mm}^2$	20	40	60
N1.2 Aluminium wrought alloys	$\leq 350 \text{ N/mm}^2$	20	40	60
N1.3 Aluminium wrought alloys	$\leq 550 \text{ N/mm}^2$	20	40	60
N1.4 Aluminium cast alloys	Si $\leq 7\%$	20	40	60
N2.1 Pure copper, low-alloyed copper	$\leq 400 \text{ N/mm}^2$	5	15	30
N2.2 Copper-zinc alloys (brass, long-chipping)	$\leq 550 \text{ N/mm}^2$	10	20	40