

InnoForm 1-STEEL-M-SN-IKZ-PM-TIN-66

machine cold-forming taps



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P2.1 Construction steels, Cementation steels, Steel castings, etc.	$\leq 800 \text{ N/mm}^2$	10	20	40
P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc.	$\leq 1000 \text{ N/mm}^2$	10	15	25
P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.	$\leq 1200 \text{ N/mm}^2$	5	10	20
P5.1 High-alloyed steels, Cold work steels, Hot work steels, etc.	$\leq 1400 \text{ N/mm}^2$	5	10	15