

# Drück 2-STEEL-SN-TIN

## machine cold-forming taps

applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P1.1 Construction steels, Free-cutting steels, etc.	$\leq 600 \text{ N/mm}^2$	15	<b>30</b>	45
P2.1 Construction steels, Cementation steels, Steel castings, etc.	$\leq 800 \text{ N/mm}^2$	10	<b>20</b>	40
P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc.	$\leq 1000 \text{ N/mm}^2$	10	<b>15</b>	25
N1.5 Aluminium cast alloys	$7\% < \text{Si} \leq 12\%$	20	<b>40</b>	60
N1.6 Aluminium cast alloys	$12\% < \text{Si} \leq 17\%$	20	<b>40</b>	60
N2.2 Copper-zinc alloys (brass, long-chipping)	$\leq 550 \text{ N/mm}^2$	10	<b>20</b>	40