

InnoForm 1-Z/E-SN-PM-TIN-80

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	30	45
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
K2.1 Cast iron with nodular graphite (GJS)	350-500 N/mm ²	20	30	60
N2.2 Copper-zinc alloys (brass, long-chipping)	$\leq 550 \text{ N/mm}^2$	10	20	40
N2.4 Copper-aluminium alloys (alu bronze, long-chipping)	$\leq 800 \text{ N/mm}^2$	5	10	20
N2.5 Copper-tin alloys (tin bronze, long-chipping)	$\leq 700 \text{ N/mm}^2$	5	10	20