

Rekord 1A-GJV-IKZN-PM-TICN

machine taps



applications - materials		cutting speed vc in m/min			
		min.	recommended	max.	
K1.1	Cast iron with lamellar graphite (GJL)	100-250 N/mm ²	15	45	60
K1.2	Cast iron with lamellar graphite (GJL)	250-450 N/mm ²	10	40	60
K2.1	Cast iron with nodular graphite (GJS)	350-500 N/mm ²	10	30	60
K2.2	Cast iron with nodular graphite (GJS)	500-900 N/mm ²	10	20	40
K3.1	Cast iron with vermicular graphite (GJV)	300-400 N/mm ²	10	30	60
K3.2	Cast iron with vermicular graphite (GJV)	400-500 N/mm ²	10	30	60
K4.1	Malleable cast iron (GTMW, GTMB)	250-500 N/mm ²	15	30	45
K4.2	Malleable cast iron (GTMW, GTMB)	500-800 N/mm ²	15	30	45