

# Rekord A-STEEL

## 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 <sup>2</sup>	5	<b>15</b>	25
K1.2	Cast iron with lamellar graphite (GJL)	250-450 N/mm <sup>2</sup>	5	<b>15</b>	25
K2.1	Cast iron with nodular graphite (GJS)	350-500 N/mm <sup>2</sup>	5	<b>10</b>	20
K2.2	Cast iron with nodular graphite (GJS)	500-900 N/mm <sup>2</sup>	5	<b>10</b>	20
K3.1	Cast iron with vermicular graphite (GJV)	300-400 N/mm <sup>2</sup>	5	<b>10</b>	20
K3.2	Cast iron with vermicular graphite (GJV)	400-500 N/mm <sup>2</sup>	5	<b>10</b>	20
K4.1	Malleable cast iron (GTMW, GTMB)	250-500 N/mm <sup>2</sup>	5	<b>10</b>	20
K4.2	Malleable cast iron (GTMW, GTMB)	500-800 N/mm <sup>2</sup>	5	<b>10</b>	20
N2.3	Copper-zinc alloys (brass, short-chipping)	<= 550 N/mm <sup>2</sup>	10	<b>20</b>	40