

Rekord 1B-Z-IKZN-PM-GLT-1

machine 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	25	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.	$\leq 1000 \text{ N/mm}^2$	5	15	25
P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.	$\leq 1200 \text{ N/mm}^2$	5	10	15
P5.1 High-alloyed steels, Cold work steels, Hot work steels, etc.	$\leq 1400 \text{ N/mm}^2$	2	8	10
M1.1 Ferritic, martensitic	$\leq 950 \text{ N/mm}^2$	5	8	12
M2.1 Austenitic	$\leq 950 \text{ N/mm}^2$	5	8	12
M3.1 Austenitic-ferritic (Duplex)	$\leq 1100 \text{ N/mm}^2$	2	5	8
M4.1 Austenitic-ferritic heat-resistant (Super Duplex)	$\leq 1250 \text{ N/mm}^2$	2	5	8
N1.4 Aluminium cast alloys	Si $\leq 7\%$	15	30	40
N2.1 Pure copper, low-alloyed copper	$\leq 400 \text{ N/mm}^2$	5	15	30
N2.2 Copper-zinc alloys (brass, long-chipping)	$\leq 550 \text{ N/mm}^2$	10	25	40
N2.4 Copper-aluminium alloys (alu bronze, long-chipping)	$\leq 800 \text{ N/mm}^2$	5	15	25
N2.5 Copper-tin alloys (tin bronze, long-chipping)	$\leq 700 \text{ N/mm}^2$	5	15	25
S1.1 Pure titanium	$\leq 450 \text{ N/mm}^2$	1	5	7
S2.2 Nickel-base alloys	$\leq 1000 \text{ N/mm}^2$	1	3	5
S2.3 Nickel-base alloys	$\leq 1600 \text{ N/mm}^2$	1	3	5