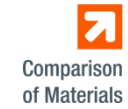


Rekord 2-VA-AZ

machine taps



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
P2.1 Construction steels, Cementation steels, Steel castings, etc.	$\leq 800 \text{ N/mm}^2$	2	3	6
P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc.	$\leq 1000 \text{ N/mm}^2$	1	4	8
P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.	$\leq 1200 \text{ N/mm}^2$	1	3	5
K2.1 Cast iron with nodular graphite (GJS)	350-500 N/mm ²	1	3	5
K2.2 Cast iron with nodular graphite (GJS)	500-900 N/mm ²	1	3	5
K3.1 Cast iron with vermicular graphite (GJV)	300-400 N/mm ²	1	3	5
K3.2 Cast iron with vermicular graphite (GJV)	400-500 N/mm ²	1	3	5
K4.1 Malleable cast iron (GTMW, GTMB)	250-500 N/mm ²	1	3	5
K4.2 Malleable cast iron (GTMW, GTMB)	500-800 N/mm ²	1	3	5
N1.5 Aluminium cast alloys	7% < Si \leq 12%	1	3	5
N2.6 Copper-tin alloys (tin bronze, short-chipping)	$\leq 400 \text{ N/mm}^2$	1	3	5