



YG TAP CAST IRON

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

					T0993	TE821 TE403 TE434 TE454	TD821	TI821	TY821
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)				
P	1	Non-alloy steel	125						
	2		190	13					
	3		250	25					
	4		270	28					
	5		300	32					
	6	Low alloy steel	180	10					
	7		275	29					
	8		300	32					
	9		350	38					
	10	High alloyed steel, and tool steel	200	15					
	11		325	35					
M	12	Stainless steel	200	15					
	13		240	23					
	14		180	10					
K	15	Grey cast iron	180	10	10-15	10-15	15-20	15-20	15-20
	16		260	26	5-8	5-8	8-11	8-11	8-11
	17	Nodular cast iron	160	3	10-15	10-15	15-20	15-20	15-20
	18		250	25	5-8	5-8	8-11	8-11	8-11
	19	Malleable cast iron	130		10-15	10-15	15-20	15-20	15-20
	20		230	21	5-8	5-8	8-11	8-11	8-11
N	21	Aluminum-wrought alloy	60						
	22		100						
	23	Aluminum-cast, alloyed	75		15-20				
	24		90						
	25		130		10-15				
	26		110						
	27	Copper and Copper Alloys (Bronze / Brass)	90			8-12	12-16	12-16	12-16
	28		100						
	29								
	30	Non Metallic Materials							
S	31	Heat Resistant Super Alloys	200	15					
	32		280	30					
	33		250	25					
	34		350	38					
	35		320	34					
	36	Titanium Alloys	400 Rm						
	37		1050 Rm						
H	38	Hardened steel	550	55					
	39		630	60					
	40	Chilled Cast Iron	400	42	3-5				
	41	Hardened Cast Iron	550	55					

CARBIDE

HSS

THREAD MILLS

SYNCHRO TAPS

COMBO TAPS

YG TAP GENERAL

YG TAP STEEL

YG TAP HARDENED

YG TAP INOX

YG TAP CAST IRON

YG TAP ALU

YG TAP Ti Ni

YG TAP FORMING

NUT TAPS

STI TAPS

PIPE TAPS

TECHNICAL DATA