

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												
					TC804 TC844 TC824 TC864	TD804 TD844 TD824 TD864	TB804 TB844 TB824 TB864	TCE05 TCE09 TCE01 TCE02	TDE05 TDE09 TDE01 TDE02	TBE05	TCE06	TDE06
ISO	VDI 3323	Material Description	HB	HRc	Vc (m/min)							
P	1	Non-alloy steel	125		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	2		190	13	15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	3		250	25	12-18	18-24	12-18	12-18	18-24	12-18	12-18	18-24
	4		270	28	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	5		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	6	Low alloy steel	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	7		275	29	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	8		300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14
	9		350	38	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7
	10	High alloyed steel, and tool steel	200	15	3-5	5-7	3-5	3-5	5-7	3-5	3-5	5-7
	11		325	35								
M	12	Stainless steel	200	15	7-10	10-15	7-10	7-10	10-15	7-10	7-10	10-15
	13		240	23	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	14		180	10	4-6	6-8	4-6	4-6	6-8	4-6	4-6	6-8
K	15	Grey cast iron	180	10	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	16		260	26	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	17	Nodular cast iron	160	3	10-15	15-20	10-15	10-15	15-20	10-15	10-15	15-20
	18		250	25	5-8	8-11	5-8	5-8	8-11	5-8	5-8	8-11
	19	Malleable cast iron	130									
	20		230	21								
N	21	Aluminum-wrought alloy	60									
	22		100									
	23	Aluminum-cast, alloyed	75		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	24		90									
	25		130									
	26	Copper and Copper Alloys (Bronze / Brass)	110		25-35	35-40	25-35	25-35	35-40	25-35	25-35	35-40
	27		90		8-12	12-17	8-12	8-12	12-17	8-12	8-12	12-17
	28		100		15-20	20-25	15-20	15-20	20-25	15-20	15-20	20-25
	29	Non Metallic Materials										
	30											
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								
	41	Hardened Cast Iron	550	55								

 COMBO TAPS											CARBIDE
RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN											HSS
	TBE06	TCE07	TDE07	TBE07	TCE08	TDE08	TBE08	TC804-IC	TC633	TC807	THREAD MILLS
VDI 3323	Vc (m/min)										SYNCHRO TAPS
1	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20	COMBO TAPS
2	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20	YG TAP GENERAL
3	12-18	12-18	18-24	12-18	12-18	18-24	12-18	12-18	12-18	12-18	YG TAP STEEL
4	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15	YG TAP HARDENED
5	6-10	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10	YG TAP INOX
6	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15	YG TAP CAST IRON
7	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15	YG TAP ALU
8	6-10	6-10	10-14	6-10	6-10	10-14	6-10	6-10	6-10	6-10	YG TAP Ti Ni
9	3-5	3-5	5-7	3-5	3-5	5-7	3-5	3-5	3-5	3-5	YG TAP FORMING
10	3-5	3-5	5-7	3-5	3-5	5-7	3-5	3-5	3-5	3-5	NUT TAPS
11											STI TAPS
12	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10	7-10	7-10	PIPE TAPS
13	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8	TECHNICAL DATA
14	4-6	4-6	6-8	4-6	4-6	6-8	4-6	4-6	4-6	4-6	
15	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15	
16	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8	
17	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15	10-15	10-15	
18	5-8	5-8	8-11	5-8	5-8	8-11	5-8	5-8	5-8	5-8	
19											
20											
21											
22											
23	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20	
24											
25											
26	25-35	25-35	35-40	25-35	25-35	35-40	25-35	25-35	25-35	25-35	
27	8-12	8-12	12-17	8-12	8-12	12-17	8-12	8-12	8-12	8-12	
28	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20	15-20	15-20	
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RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

					TB744 TB754 TQ744 TQ754	TC814 TC854 TC834 TC874	TD814 TD854 TD834 TD874	TB814 TB854 TB834 TB874	TCJ05 TCJ09 TCJ01 TCJ02	TDJ05 TDJ09 TDJ01 TDJ02	TBJ05	TCJ06	
					Vc (m/min)								
COMBO TAPS	P	1	Non-alloy steel	125			15-20	20-25	15-20	15-20	20-25	15-20	15-20
YG TAP GENERAL		2		190	13	15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
		3		250	25		12-18	18-24	12-18	12-18	18-24	12-18	12-18
YG TAP STEEL		4		270	28	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
		5		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10
YG TAP HARDENED		6	Low alloy steel	180	10	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
		7		275	29	10-15	10-15	15-20	10-15	10-15	15-20	10-15	10-15
YG TAP INOX		8		300	32		6-10	10-14	6-10	6-10	10-14	6-10	6-10
		9		350	38		3-5	5-7	3-5	3-5	5-7	3-5	3-5
		10		High alloyed steel, and tool steel	200	15		3-5	5-7	3-5	3-5	5-7	3-5
		11	325		35								
YG TAP CAST IRON	M	12	Stainless steel	200	15	7-10	7-10	10-15	7-10	7-10	10-15	7-10	7-10
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YG TAP ALU	K	15	Grey cast iron	180	10		10-15	15-20	10-15	10-15	15-20	10-15	10-15
		16		260	26		5-8	8-11	5-8	5-8	8-11	5-8	5-8
YG TAP Ti Ni		17	Nodular cast iron	160	3		10-15	15-20	10-15	10-15	15-20	10-15	10-15
		18		250	25		5-8	8-11	5-8	5-8	8-11	5-8	5-8
YG TAP FORMING		19	Malleable cast iron	130									
		20		230	21								
NUT TAPS	N	21	Aluminum- wrought alloy	60									
		22		100									
		23	Aluminum- cast, alloyed	75			15-20	20-25	15-20	15-20	20-25	15-20	15-20
		24		90									
25		130											
STI TAPS		26	Copper and Copper Alloys (Bronze / Brass)	110			25-35	35-40	25-35	25-35	35-40	25-35	25-35
		27		90			8-12	12-17	8-12	8-12	12-17	8-12	8-12
PIPE TAPS		28		100		15-20	15-20	20-25	15-20	15-20	20-25	15-20	15-20
		29	Non Metallic Materials										
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		32		280	30								
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