

COMBO TAP

RECOMMENDED CUTTING CONDITIONS
EMPOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRC	Vc (m/min.)					
P	1	Non-alloy steel	125	15-20	20-25	15-20	20-25	15-20	20-25	15-20
	2		190 13	15-20	20-25	15-20	20-25	15-20	20-25	15-20
	3		250 25	12-18	18-24	12-18	18-24	12-18	18-24	12-18
	4		270 28	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	5		300 32	6-10	10-14	6-10	10-14	6-10	10-14	6-10
M	6	Low alloy steel	180 10	15-20	10-15	15-20	10-15	10-15	15-20	10-15
	7		275 29	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	8		300 32	6-10	10-14	6-10	10-14	6-10	10-14	6-10
	9		350 38	3-5	5-7	3-5	5-7	3-5	5-7	3-5
	10		200 15	3-5	5-7	3-5	5-7	3-5	5-7	3-5
K	12	Grey cast iron	200 15	7-10	10-15	7-10	10-15	7-10	10-15	7-10
	13		240 23	5-8	8-11	5-8	8-11	5-8	8-11	5-8
	14		180 10	4-6	6-8	4-6	6-8	4-6	6-8	4-6
	15		180 10	10-15	15-20	10-15	15-20	10-15	15-20	10-15
	16		260 26	5-8	8-11	5-8	8-11	5-8	8-11	5-8
N	17	Nodular cast iron	160 3	10-15	15-20	10-15	15-20	10-15	15-20	10-15
	18		250 25	5-8	8-11	5-8	8-11	5-8	8-11	5-8
	23		75	15-20	20-25	15-20	20-25	15-20	20-25	15-20
	26		110	25-35	35-40	25-35	35-40	25-35	35-40	25-35
	27		90	8-12	12-17	8-12	12-17	8-12	12-17	8-12
	28		100	15-20	20-25	15-20	20-25	15-20	20-25	15-20

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	8		300 32	6-10	10-14	6-10	10-14	6-10	10-14	6-10
	9		350 38	3-5	5-7	3-5	5-7	3-5	5-7	3-5
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	14		180 10	4-6	6-8	4-6	6-8	4-6	6-8	4-6
	15		180 10	10-15	15-20	10-15	15-20	10-15	15-20	10-15
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	18		250 25	5-8	8-11	5-8	8-11	5-8	8-11	5-8
	23		75	15-20	20-25	15-20	20-25	15-20	20-25	15-20
	26		110	25-35	35-40	25-35	35-40	25-35	35-40	25-35
	27		90	8-12	12-17	8-12	12-17	8-12	12-17	8-12
	28		100	15-20	20-25	15-20	20-25	15-20	20-25	15-20

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YG YG-1 CO, LTD.

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	23		75	15-20	20-25	15-20	20-25	15-20	20-25	15-20
	26		110	25-35	35-40	25-35	35-40	25-35	35-40	25-35
	27		90	8-12	12-17	8-12	12-17	8-12	12-17	8-12
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	23		75	15-20	20-25	15-20	20-25	15-20	20-25	15-20
	26		110	25-35	35-40	25-35	35-40	25-35	35-40	25-35
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