



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

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

					TM903	TZ903	TM293	TZ293	TM933	TZ933	TM923	TZ923	TQ833	TR833	TQ873	TR873
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					10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15
	7		275	29	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	
	8		300	32	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	6-10	
	9		350	38	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	3-5	
	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												
	16		260	26												
	17	Nodular cast iron	160	3												
	18		250	25												
	19		130													
20	Malleable cast iron	230	21													
N	21	Aluminum-wrought alloy	60													
	22		100													
	23	Aluminum-cast, alloyed	75													
	24		90													
	25		130													
	26		110													
	27	Copper and Copper Alloys (Bronze / Brass)	90													
	28		100													
	29															
	30	Non Metallic Materials														
S	31	Heat Resistant Super Alloys	200	15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15	
	32		280	30			10-15	10-15	10-15	10-15	10-15	10-15	10-15	10-15		
	33		250	25			2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4		
	34		350	38			2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4		
	35		320	34			2-4	2-4	2-4	2-4	2-4	2-4	2-4	2-4		
	36	Titanium Alloys	400Rm		10-15	10-15	10-15	10-15					10-15	10-15	10-15	
	37		1050Rm		4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6	4-6			
H	38	Hardened steel	550	55								3-5				
	39		630	60												
	40	Chilled Cast Iron	400	42			3-5	3-5			3-5	3-5		3-5		
	41	Hardened Cast Iron	550	55												