



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.)				
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	23	Aluminum-cast, alloyed	75		15-20				
	25		130		10-15				
	27	Copper and Copper Alloys (Bronze / Brass)	90			8-12	12-16	12-16	12-16
H	40	Chilled Cast Iron	400	42	3-5				