



# COMBO TAP

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

|     |             |                                                 |     |     | TC814<br>TD854<br>TC834<br>TC874 | TD814<br>TD854<br>TD834<br>TD874 | TB814<br>TB854<br>TB834<br>TB874 | TCJ05<br>TCJ09<br>TCJ01<br>TCJ02 | TDJ05<br>TDJ09<br>TDJ01<br>TDJ02 | TBJ05 | TCJ06 | TDJ06 | TBJ06 |
|-----|-------------|-------------------------------------------------|-----|-----|----------------------------------|----------------------------------|----------------------------------|----------------------------------|----------------------------------|-------|-------|-------|-------|
| ISO | VDI<br>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 | 15-20 |
|     | 2           |                                                 | 190 | 13  | 15-20                            | 20-25                            | 15-20                            | 15-20                            | 20-25                            | 15-20 | 15-20 | 20-25 | 15-20 |
|     | 3           |                                                 | 250 | 25  | 12-18                            | 18-24                            | 12-18                            | 12-18                            | 18-24                            | 12-18 | 12-18 | 18-24 | 12-18 |
|     | 4           |                                                 | 270 | 28  | 10-15                            | 15-20                            | 10-15                            | 10-15                            | 15-20                            | 10-15 | 10-15 | 15-20 | 10-15 |
|     | 5           | Low alloy steel                                 | 300 | 32  | 6-10                             | 10-14                            | 6-10                             | 6-10                             | 10-14                            | 6-10  | 6-10  | 10-14 | 6-10  |
|     | 6           |                                                 | 180 | 10  | 10-15                            | 15-20                            | 10-15                            | 10-15                            | 15-20                            | 10-15 | 10-15 | 15-20 | 10-15 |
|     | 7           |                                                 | 275 | 29  | 10-15                            | 15-20                            | 10-15                            | 10-15                            | 15-20                            | 10-15 | 10-15 | 15-20 | 10-15 |
|     | 8           |                                                 | 300 | 32  | 6-10                             | 10-14                            | 6-10                             | 6-10                             | 10-14                            | 6-10  | 6-10  | 10-14 | 6-10  |
|     | 9           |                                                 | 350 | 38  | 3-5                              | 5-7                              | 3-5                              | 3-5                              | 5-7                              | 3-5   | 3-5   | 5-7   | 3-5   |
|     | 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   | 3-5   |
| M   | 12          | Stainless steel                                 | 200 | 15  | 7-10                             | 10-15                            | 7-10                             | 7-10                             | 10-15                            | 7-10  | 7-10  | 10-15 | 7-10  |
|     | 13          |                                                 | 240 | 23  | 5-8                              | 8-11                             | 5-8                              | 5-8                              | 8-11                             | 5-8   | 5-8   | 8-11  | 5-8   |
|     | 14          |                                                 | 180 | 10  | 4-6                              | 6-8                              | 4-6                              | 4-6                              | 6-8                              | 4-6   | 4-6   | 6-8   | 4-6   |
| K   | 15          | Grey cast iron                                  | 180 | 10  | 10-15                            | 15-20                            | 10-15                            | 10-15                            | 15-20                            | 10-15 | 10-15 | 15-20 | 10-15 |
|     | 16          |                                                 | 260 | 26  | 5-8                              | 8-11                             | 5-8                              | 5-8                              | 8-11                             | 5-8   | 5-8   | 8-11  | 5-8   |
|     | 17          | Nodular cast iron                               | 160 | 3   | 10-15                            | 15-20                            | 10-15                            | 10-15                            | 15-20                            | 10-15 | 10-15 | 15-20 | 10-15 |
|     | 18          |                                                 | 250 | 25  | 5-8                              | 8-11                             | 5-8                              | 5-8                              | 8-11                             | 5-8   | 5-8   | 8-11  | 5-8   |
| N   | 23          | Aluminum-cast, alloyed                          | 75  |     | 15-20                            | 20-25                            | 15-20                            | 15-20                            | 20-25                            | 15-20 | 15-20 | 20-25 | 15-20 |
|     | 26          | Copper and Copper<br>Alloys<br>(Bronze / Brass) | 110 |     | 25-35                            | 35-40                            | 25-35                            | 25-35                            | 35-40                            | 25-35 | 25-35 | 35-40 | 25-35 |
|     | 27          |                                                 | 90  |     | 8-12                             | 12-17                            | 8-12                             | 8-12                             | 12-17                            | 8-12  | 8-12  | 12-17 | 8-12  |
|     | 28          |                                                 | 100 |     | 15-20                            | 20-25                            | 15-20                            | 15-20                            | 20-25                            | 15-20 | 15-20 | 20-25 | 15-20 |