



# COMBO TAP

## RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDKONDITIONEN

					TC814 TC854 TC834 TC874	TD814 TD854 TD834 TD874	TB814 TB854 TB834 TB874	TCJ05 TCJ09 TCJ01 TCJ02	TDJ05 TDJ09 TDJ01 TDJ02	TBJ05	TCJ06	TDJ06	TBJ06
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	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	300	32	6-10	10-14	6-10	6-10	10-14	6-10	6-10	10-14	6-10	
	6	Low alloy steel	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 Alloys (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