YG TAP INOX

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

ISO	VDI 3323	Material Description	HB	HRc	TB711	TQ813	TR813	TB914 TB183 TB904 TB924	TI914	TBE15	TBE16	TBE17	TBE18	TCH14	TQ853	TR853	TB623 TB123 TB264 TB274	TCH23
					Vc (m/min)													
P	1	Non-alloy steel	125		15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	20-25
	2		190	13	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	15-20	20-25	15-20	15-20	15-20	20-25
	3		250	25		12-18	12-18	12-18	18-24	12-18	12-18	12-18	12-18	18-24	12-18	12-18	12-18	18-24
	4		270	28		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	5		300	32														
	6	Low alloy steel	180	10		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	7		275	29														
	8		300	32														
	9		350	38														
	10	High alloyed steel, and tool steel	200	15														
	11		325	35														
M	12	Stainless steel	200	15	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	7-10	10-13	7-10	7-10	7-10	10-13
	13		240	23	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	5-8	8-11	5-8	5-8	5-8	8-11
	14		180	10	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	4-6	6-8	4-6	4-6	4-6	6-8
K	15	Grey cast iron	180	10														
	16		260	26														
	17	Nodular cast iron	160	3														
	18		250	25														
	19	Malleable cast iron	130															
	20		230	21														
N	21	Aluminum-wrought alloy	60		10-15													
	22		100															
	23	Aluminum-cast, alloyed	75															
	24		90															
	25		130															
	26	Copper and Copper Alloys (Bronze / Brass)	110															
	27		90															
	28		100		15-20													
	29	Non Metallic Materials																
	30																	
S	31	Heat Resistant Super Alloys	200	15		10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	32		280	30														
	33		250	25														
	34		350	38														
	35		320	34														
	36	Titanium Alloys	400 Rm			10-15	10-15	10-15	15-20	10-15	10-15	10-15	10-15	15-20	10-15	10-15	10-15	15-20
	37		1050 Rm															
H	38	Hardened steel	550	55														
	39		630	60														
	40	Chilled Cast Iron	400	42														
	41	Hardened Cast Iron	550	55														