



RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

HSS

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
	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
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
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
	36	Titanium Alloys	400Rm			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

THREAD MILL

SYNCHRO TAP

PRIME TAP

COMBO TAP

YG TAP STEEL

YG TAP CHIP BREAKER

YG TAP INOX

YG TAP CAST IRON

YG TAP HARDENED STEEL

YG TAP Ti Ni

YG TAP ALU

YG TAP FORMING

YG TAP GENERAL

PIPE TAP

STI TAP

NUT TAP