

Rekord 1A-H-LS-NT

machine taps



applications - materials		cutting speed vc in m/min		
		min.	recommended	max.
K1.1	Cast iron with lamellar graphite (GJL) 100-250 N/mm ²	10	15	25
K1.2	Cast iron with lamellar graphite (GJL) 250-450 N/mm ²	10	15	25
K2.1	Cast iron with nodular graphite (GJS) 350-500 N/mm ²	10	15	25
K2.2	Cast iron with nodular graphite (GJS) 500-900 N/mm ²	5	10	15
K3.1	Cast iron with vermicular graphite (GJV) 300-400 N/mm ²	5	10	15
K3.2	Cast iron with vermicular graphite (GJV) 400-500 N/mm ²	5	10	15
K4.1	Malleable cast iron (GTMW, GTMB) 250-500 N/mm ²	10	15	25
K4.2	Malleable cast iron (GTMW, GTMB) 500-800 N/mm ²	10	15	25
N4.1	Duroplastics (short-chipping)	5	10	25