

# Selection of Taps and Cutting Conditions

Work Material	Production	Recommandable Type							Coolant		
		Cutting Taps				Forming Taps					
		Hole Type									
		1,2,4		Vc m/min	3,5		1,2,4			Vc m/min	
DIN	JIS	DIN	JIS		DIN	DIN					
Carbon Steel up to 700 N/mm <sup>2</sup> ex. 1.0100 St34 1.0140 St42 1.0301 C10 1.0501 C35 1.0726 35S20 1.1141 CK15	Job	968, 2950		18	972, 2951		15	6992 - D	6992 - C	20	(Forming) Oil  (Cutting) Oil Emulsion
		986, 2952		18	988, 2953		15	6994 - D	6994 - C	20	
		978, 2960		18	980, 2961		15				
					970		15				
					950		15				
	Manufacture	6986		18	6980		15				
		6990		18	6984		15				
		6988		18	6982		15				
		6940		20	6928		20				
		6930		20	6944		20				
					6936		20				
					6938		20				
	Mass-production	6931P		25	972P		25	6992P - D	6992P - C	25	
		6941P		25	988P		25	6994P - D	6994P - C	25	
	968P		30	6929P		25					
	986P		30	6945P		25					
				6937P		25					
				6939P		25					
		7900P	40	7906P		40					
				7900P		40					
Carbon Steel over 700 N/mm <sup>2</sup> Alloy Steel up to 1000 N/mm <sup>2</sup> ex. 1.0503 C45 1.1167 36Mn5 1.1191 Ck45 1.5755 31 NiCr5 1.7033 34Cr4 1.7220 34 CrMo4	Job	968, 2950		12	972, 2951		10	6992 - D	6992 - C	15	(Forming) Oil  (Cutting) Oil Emulsion
		986, 2952		12	988, 2953		10	6994 - D	6994 - C	15	
		978, 2960		12	980, 2961		10				
	Manufacture	6986		12	6980		10				
		6990		12	6984		10				
		6988		12	6982		10				
		6940		20	6928		20				
		6930		20	6944		20				
					6936		20				
					6938		20				
	Mass-production	968P		25	972P		20	6992P - D	6992P - C	20	
		986P		25	988P		20	6994P - D	6994P - C	20	
		6941P		25	6929P		25				
		6931P		25	6945P		25				
				6937P		25					
				6939P		25					
		7900P	30	7900P		30					
				7906P		30					
Alloy Steel 1000-1300N/mm <sup>2</sup> ex. 1.5736 NiCr5 1.7147 MnCr5 1.7225 42 CrMo4	Job	6986		10	6980		8				Oil Emulsion
		6990		10	6984		8				
		6988		10	6982		8				
		6940		20	6928		20				
		6930		20	6936		20				
					6938		20				
					6944		20				
	Mass-production	968P		15	972P		12				
		986P		15	988P		12				
		6941P		25	6929P		25				
		6931P		25	6937P		25				
					6939P		25				
					6945P		25				
			7900P	20	7900P		20				
				7906P		20					

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		Hole Type									
		1,2,4		Vc m/min	3,5		1,2,4			Vc m/min	
DIN	JIS	DIN	JIS		DIN	DIN					
Steel 1300 - 1600 N/mm <sup>2</sup> elastic Steel up to 440 HB ex. 1.0908 60MnSi5 1.2713 55NiCrMoV6 1.8161 58CrV4	Job	7900P		10	7900P		10			Oil	
Stainless Steel Ferritic (Ni < 2%), Martensite ex. 1.4021 X20Cr13 1.4057 X22CrNi17 1.4722 X10CrSi13	Job	6986		10	6980		8	6992 - D	6992 - C	10	(Forming) Oil
		6990		10	6984		8	6994 - D	6994 - C	10	
		6988		10	6982		8				
Mass- production		968P		15	972P		12	6992P - D	6992P - C	15	(Cutting) Oil Emulsion
		986P		15	988P		12	6994P - D	6994P - C	15	
			7900P	20		7900P	20				
Stainless Steel Austenitic, Austenitic- Ferritic (Ni > 4%) ex. 1.4301X5CrNi1810 1.4401X5CrNiMo1712 1.4541X6CrNiTi1810	Job	6986		6	6980		5	6992 - D	6992 - C	6	(Forming) Oil
		6990		6	6984		5	6994 - D	6994 - C	6	
		6988		6	6982		5				
Mass- production		968P		8	972P		7	6992P - D	6992P - C	8	(Cutting) Oil Emulsion
		986P		8	988P		7	6994P - D	6994P - C	8	
			7900P	12		7900P	12				
Special Steel ex. 2.4602 Hastelloy C 2.4816 Inconel 600 2.4876 Inconel 800	Job	6986		4	6980		3				Oil Emulsion
		6990		4	6984		3				
		6988		4	6982		3				
Mass- production		968P		6	968P		5				Oil Emulsion
		986P		6	986P		5				
			7900P	8		7906P	8				
Cast Iron Lamellargraphite ex. 0.6015 GG - 15 0.6030 GG - 30 0.6040 GG - 40	Job	968P		25	972P		20				Emulsion
		986P		25	988P		20				
		6930		15	6928		15				
Mass- production		6926		15	6944		15				Emulsion
		6931P		20	6929P		20				
		6927P		20	6945P		20				
Spheroidal Graphite Cast Iron ex. 0.7040 GGG - 40 0.7050 GGG - 50 GTW - 40 GTS - 35	Job	968P		25	972P		20				Emulsion
		986P		25	988P		20				
		6930		15	6928		15				
Mass- production		6926		15	6944		15				Emulsion
		6931P		20	6929P		20				
		6927P		20	6945P		20				
		7900P	30		7906P	30					
		9236	40		7900P	40					
			30		9236	30					

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