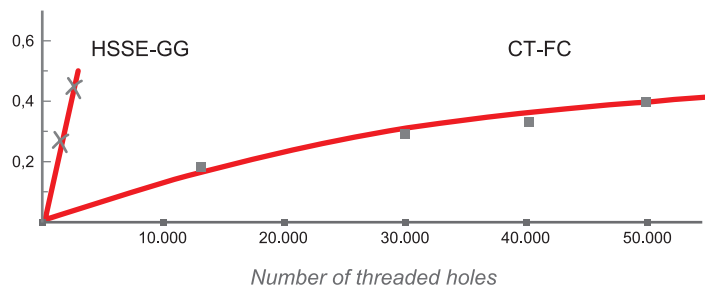


CARBIDE TIPPED	M / MF	G	UNC / UNF
	≥ 12	$\geq 1 / 4$	$\geq 1 / 2$

EXAMPLE: tap 3626 M 5 x 0.8 (ct-fc), workpiece material cast iron, hole 4.2mm, lubricant non-water soluble oil

Wear of chamfer relief



MATERIAL	V (m/min)	LUBRICANT
gray cast iron	15 - 25	1 2 3
spheroidal cast iron	12 - 20	2 3
malleable cast iron	12 - 20	3
aluminium	23 - 40	2 3
copper	15 - 33	2 3
brass	23 - 33	2 3
phosphor bronze	18 - 33	2 3
aluminium alloy casting	15 - 25	4
zinc alloy casting	12 - 20	4
thermosetting plastic	15 - 25	3 5
thermo plastic	15 - 25	3 5

1 dry, 2 gas oil, 3 water soluble oil, 4 mixed lard oil and petroleum, 5 air