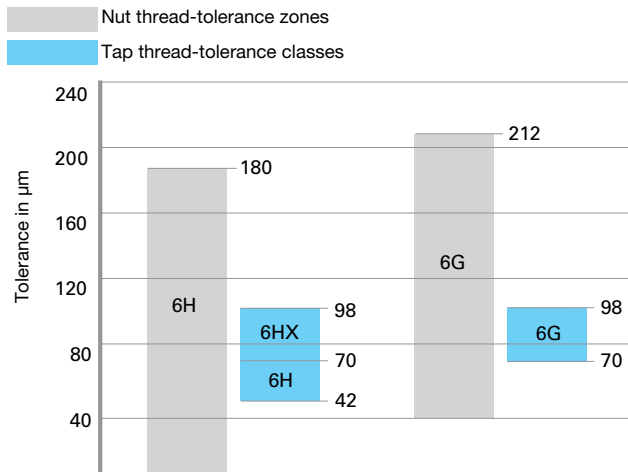


	Hardness		Cutting speed SFM	
	Rc	BRN	Steam Oxide	Hard Coatings
Structural steels	–	< 250	30 - 45	30 - 60
Free-cutting steels	–	< 250	30 - 60	30 - 70
Unalloyed case hardened steels	< 20	< 230	30 - 45	30 - 65
Unalloyed heat-treatable steels	< 24	< 250	30 - 45	30 - 65
Alloyed case hardened steels	< 30	< 285	25 - 35	25 - 30
Alloyed heat-treatable steels	< 30	< 285	20 - 30	20 - 45
Alloyed tool steels	< 30	< 285	20 - 30	20 - 45
High speed tool steels	< 30	< 290	20 - 30	20 - 45
Stainl./acid-resist. steels, sulphured		< 24	< 250	20 - 35
	austenitic	< 24	< 250	20 - 35
	martensitic	< 24	< 250	20 - 35
Aluminum and Al-alloys	–	< 120	45 - 60	45 - 85
Al wrought alloys	–	< 120	45 - 60	45 - 85
Al cast alloys ≤ 10 % Si		–	< 180	45 - 60
	> 10 % Si	–	< 180	45 - 60
Cast iron	–	< 240	45 - 60	45 - 85
Spheroidal graphite iron	–	< 240	45 - 60	45 - 85
Malleable cast iron	–	< 300	30 - 50	45 - 85

Tolerance zone / tolerance class allocation



DIN EN 22857	
Application class of tap	
Class 2 ISO 2	Class 3 ISO 3
Tolerance zone of internal thread to be cut	
6H	6G
DIN 802 part 1 (withdrawn)	
Tolerance class of tap	
6H	6G

6H: The tolerance zone 6H corresponds with the standard tolerance for taps to DIN EN 22857.

6HX: The additional letter "X" (6HX) indicates taps produced with deviating tolerance to standard. These deviations are based upon the company standard. Taps produced to tolerance 6HX are, for example, selected for abrasive or tough materials.

6G: The tolerance zone 6G corresponds with an over-size condition tolerance for taps to DIN EN 22857 and is applied for components that are, for example, surface treated.

