TOOLEX

www.toolex.co.uk

1st CHOICE = IDEAL ☺
2nd CHOICE = GOOD 😐
3rd CHOICE = SUITABLE O

CHAMFER:
FORM A = 6 - 7 THREADS
FORM B = 4 - 5 THREADS
FORM C = 2 - 3 THREADS
FORM D = 3.5 - 5 THREADS

Recommended Speeds and Selection of Taps

	TAPPING SPEED v=m/min	COOLING PRODUCT & LUB. OILS	FORM																					
			B	C	B	C	C	B	C	B	C	B	C	B	C	B	C	B	C	D	C	C	C
Structural steels up to 1000 N/mm²	14	Cutting oil	😐	😐	☺	☺		O	O			😐	😐	☺	☺	☺	☺					☺	☺
Structural steels above 900 N/mm²	14	Cutting Oil						😐	😐	☺	☺							☺	☺				
Case hardening steels up to 1000 N/mm²	10	Cutting Oil			☺	☺		O	O							☺	☺	☺	☺				
Case hardening steels up to 900 N/mm²	10	Cutting Oil						😐	😐	☺	☺							☺	☺				
Heat treatable steels up to 1000 N/mm²	8	Cutting Oil	O	O	☺	☺		O	O			😐	😐			☺	☺	☺	☺				
Heat treatable steels up to 1900 N/mm²	8	Cutting Oil						😐	😐	☺	☺							☺	☺				
Nitriding steels	7	Cutting Oil						☺	☺									☺	☺				
Carbon tool steels	6	Cutting Oil Special Oil			☺	☺		O	O	O	O							☺	☺				
Heat resisting steels	4	Cutting Oil Special Oil						☺	☺							☺	☺	☺	☺				
Stainless steel	6	Cutting Oil Special Oil						☺	☺									☺	☺			O	O
Free cutting steels	17	Cutting Oil	😐	😐	☺	☺								☺	☺	☺	☺					☺	☺
Cast steel up to 1000 N/mm²	10	Cutting Oil	O	O	☺	☺		O	O			😐	😐			☺	☺	☺	☺				
Cast steel above 900 N/mm²	10	Cutting Oil						😐	😐	☺	☺							☺	☺				
Malleable cast iron	12	Cutting Oil Soluble					☺																
Grey cast iron (graphite in strips)	10	Cutting Oil					☺																
Spheroidal graphite cast iron	12	Cutting Oil					☺																
Copper	14	Cutting Oil Soluble	😐	😐	😐	😐						😐	😐									😐	😐
Brass 58 (hard brass)	30	Cutting Oil Soluble					O																
Soft Brass	19	Cutting Oil Soluble	☺	☺	😐	😐						☺	☺									O	O
Phosphor Brass	10	Cutting Oil	😐	😐	O	O	😐													O	O		
Red Brass	12	Cutting Oil	☺	☺	😐	😐	😐					O	O										
Wrought Alloy of aluminium	36	Cutting Oil Soluble	☺	☺	😐	😐						O	O									☺	☺
Aluminium/ cast alloy	22	Cutting Oil Soluble			O	O	☺																
Alloy of nickel	2	Special Oil						😐	😐														
Alloy of titanium	4	Special Oil										O	O							☺	☺		
Ferro-Tic	4	Dry, Compressed Air			O	O								O	O	😐	😐			😐	😐		
Thermoplastic compounds/Synthetic	24	Dry, Compressed Air			O	O				😐	😐												