

# Enorm 1-Z-GLT-1

## machine taps



| applications - materials                                               |                            | cutting speed vc<br>in m/min |             |      |
|------------------------------------------------------------------------|----------------------------|------------------------------|-------------|------|
|                                                                        |                            | min.                         | recommended | max. |
| P1.1 Construction steels, Free-cutting steels, etc.                    | $\leq 600 \text{ N/mm}^2$  | 15                           | <b>25</b>   | 45   |
| P2.1 Construction steels, Cementation steels, Steel castings, etc.     | $\leq 800 \text{ N/mm}^2$  | 10                           | <b>20</b>   | 40   |
| P3.1 Cementation steels, Heat-treatable steels, Cold work steels, etc. | $\leq 1000 \text{ N/mm}^2$ | 5                            | <b>15</b>   | 25   |
| P4.1 Heat-treatable steels, Cold work steels, Nitriding steels, etc.   | $\leq 1200 \text{ N/mm}^2$ | 5                            | <b>10</b>   | 15   |
| M1.1 Ferritic, martensitic                                             | $\leq 950 \text{ N/mm}^2$  | 5                            | <b>8</b>    | 12   |
| M2.1 Austenitic                                                        | $\leq 950 \text{ N/mm}^2$  | 2                            | <b>5</b>    | 8    |
| M3.1 Austenitic-ferritic (Duplex)                                      | $\leq 1100 \text{ N/mm}^2$ | 2                            | <b>5</b>    | 8    |
| M4.1 Austenitic-ferritic heat-resistant (Super Duplex)                 | $\leq 1250 \text{ N/mm}^2$ | 2                            | <b>5</b>    | 8    |
| N1.4 Aluminium cast alloys                                             | Si $\leq 7\%$              | 15                           | <b>25</b>   | 40   |
| N2.1 Pure copper, low-alloyed copper                                   | $\leq 400 \text{ N/mm}^2$  | 5                            | <b>15</b>   | 30   |
| N2.2 Copper-zinc alloys (brass, long-chipping)                         | $\leq 550 \text{ N/mm}^2$  | 10                           | <b>25</b>   | 40   |
| N2.4 Copper-aluminium alloys (alu bronze, long-chipping)               | $\leq 800 \text{ N/mm}^2$  | 5                            | <b>15</b>   | 25   |
| N2.5 Copper-tin alloys (tin bronze, long-chipping)                     | $\leq 700 \text{ N/mm}^2$  | 5                            | <b>15</b>   | 25   |
| S1.1 Pure titanium                                                     | $\leq 450 \text{ N/mm}^2$  | 1                            | <b>3</b>    | 5    |