

Speeds and Feeds



Aluminum Taps

SPIRAL FLUTE

ISO	VDI 3323	Material Description	Composition / Structure / Heat Treatment		HB	HRC	Examples	M/min	SFM
P	1	Non-alloy steel	About 0.15% C	Annealed	125		S15C, C15, 1015	15-20	50-80
P	2		About 0.45% C	Annealed	190	13	S45C, C45, 1045	15-20	50-80
P	3		About 0.45% C	Quenched & tempered	250	25		12-18	40-60
N	21	Aluminum-wrought alloy	Not Curable		60		SAE 1000, AlMg 1, 3.3315	10-15	33-50
N	22		Curable		100		SAE 7050, AlCuMg 1, 3.1325	10-15	33-50
N	23	Aluminum-cast, alloyed	≤ 12% Si, Not Curable		75		ADC12, G-ALSi12, 3.2581	15-20	50-65
N	24		≤ 12% Si, Curable		90		C4BS, G-ALSi10Mg, 3.2381	15-20	50-65
N	27	Copper & Copper Alloys	CuZn, CuSnZn (Brass)		90		CuZn 15, 2.0240	8-12	26-40

