

# BLACK RING CUT TAPS

Aluminum  
Aluminum Alloys

Material group	Approximate Rc	Approximate HB	Recommended SFM					
			HSS-E		HSS-E-PM		Solid carbide	
			bright finish	hard coated	bright finish	hard coated	bright finish	hard coated
Aluminium and Al-alloys	SILICON CONTENT	WROUGHT ALUMINUM						
Al cast alloys	< 6%	n/a	30-50	50-75	—	—	80-140	—
	6-10%	n/a	25-35	40-50	—	—	80-140	—
Al wrought alloys	>10%	n/a	-	25-35	—	—	60-130	—
	n/a	30-80	50-65	65-100	—	—	—	—
	n/a	75-150	35-60	50-65	—	—	—	—