

# WHITE RING CUT TAPS

Cast iron

Spheroidal graphite iron

Malleable cast iron

| 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 |
| Cast iron                |                | <180           | 50-70           | 60-90       | 55-85         | 65-110      | 70-100        | 80-130      |
| Spheroidal graphite iron | <25            | <250           | 30-50           | 45-85       | 40-70         | 60-100      | 70-100        | 80-130      |
| Malleable cast iron      | <35            | <320           | 15-35           | 20-40       | 25-45         | 35-55       | 60-110        | 70-120      |