

# GREEN RING CUT TAPS

Structural steels,  
 free-cutting steels  
 Case hardened steels,  
 heat-treatable steels  
 Nitriding steels,  
 spheroidal graphite iron

Material group	Approximate Rc	Approximate HB	Recommended SFM			
			HSS-E		HSS-E-PM	
			bright finish	hard coated	bright finish	hard coated
Structural steels, free-cutting steels	<20	<230	40-50	40-75	40-65	40-80
Case hardened steels, heat-treatable steels	<25	<250	30-45	30-65	30-60	35-75
Nitriding steels, spheroidal graphite iron	<30	<280	20-30	30-55	30-50	35-65
	<35	<320	15-25	20-35	25-45	30-60
	<38	<380	10-23	20-40	20-45	30-55