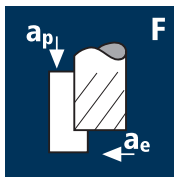



Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
2.00	3	60	0.005	2.000	0.200	9550	145
3.00	3	60	0.010	3.000	0.300	6365	190
4.00	3	60	0.015	4.000	0.400	4775	215
5.00	3	60	0.015	5.000	0.500	3820	170
6.00	3	60	0.020	6.000	0.600	3185	190
8.00	3	60	0.025	8.000	0.800	2385	180
10.00	3	60	0.035	10.000	1.000	1910	200

Short-chipping brass
[CuZn]





2.00	3	140	0.005	2.000	0.200	22280	335
3.00	3	140	0.010	3.000	0.300	14855	445
4.00	3	140	0.010	4.000	0.400	11140	335
5.00	3	140	0.020	5.000	0.500	8915	535
6.00	3	140	0.025	6.000	0.600	7425	555
8.00	3	140	0.030	8.000	0.800	5570	500
10.00	3	140	0.040	10.000	1.000	4455	535

Gold




2.00	3	160	0.005	2.000	0.200	25465	380
3.00	3	160	0.010	3.000	0.300	16975	510
4.00	3	160	0.010	4.000	0.400	12730	380
5.00	3	160	0.020	5.000	0.500	10185	610
6.00	3	160	0.025	6.000	0.600	8490	635
8.00	3	160	0.030	8.000	0.800	6365	575
10.00	3	160	0.040	10.000	1.000	5095	610

Wrought aluminium
Construction aluminium




2.00	3	250	0.005	2.000	0.200	39790	595
3.00	3	250	0.010	3.000	0.300	26525	795
4.00	3	250	0.015	4.000	0.400	19895	895
5.00	3	250	0.020	5.000	0.500	15915	955
6.00	3	250	0.025	6.000	0.600	13265	995
8.00	3	250	0.030	8.000	0.800	9945	895
10.00	3	250	0.040	10.000	1.000	7960	955

Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
2.00	3	45	0.005	1.000	2.000	7160	105	0.2
3.00	3	45	0.010	1.500	3.000	4775	145	0.6
4.00	3	45	0.010	2.000	4.000	3580	105	0.9
5.00	3	45	0.015	2.500	5.000	2865	130	1.6
6.00	3	45	0.015	3.000	6.000	2385	105	1.9
8.00	3	45	0.020	4.000	8.000	1790	105	3.4
10.00	3	45	0.030	5.000	10.000	1430	130	6.4

Short-chipping brass
[CuZn]




2.00	3	120	0.005	1.000	2.000	19100	285	0.6
3.00	3	120	0.005	1.500	3.000	12730	190	0.9
4.00	3	120	0.010	2.000	4.000	9550	285	2.3
5.00	3	120	0.015	2.500	5.000	7640	345	4.3
6.00	3	120	0.015	3.000	6.000	6365	285	5.2
8.00	3	120	0.025	4.000	8.000	4775	360	11.5
10.00	3	120	0.035	5.000	10.000	3820	400	20.1

Gold




2.00	3	140	0.005	1.000	2.000	22280	335	0.7
3.00	3	140	0.005	1.500	3.000	14855	225	1.0
4.00	3	140	0.010	2.000	4.000	11140	335	2.7
5.00	3	140	0.015	2.500	5.000	8915	400	5.0
6.00	3	140	0.015	3.000	6.000	7425	335	6.0
8.00	3	140	0.025	4.000	8.000	5570	420	13.4
10.00	3	140	0.035	5.000	10.000	4455	470	23.4

Wrought aluminium
Construction aluminium



2.00	3	200	0.005	1.000	2.000	31830	475	1.0
3.00	3	200	0.005	1.500	3.000	21220	320	1.4
4.00	3	200	0.010	2.000	4.000	15915	475	3.8
5.00	3	200	0.015	2.500	5.000	12730	575	7.2
6.00	3	200	0.015	3.000	6.000	10610	475	8.6
8.00	3	200	0.025	4.000	8.000	7960	595	19.1
10.00	3	200	0.035	5.000	10.000	6365	670	33.4