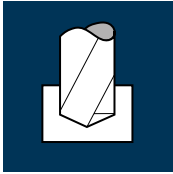


Application

Material



Steel
< 500 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



Cast iron
(lamellar / spheroidal)



d ₁ [mm]	v _c [m/min]	f [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
3.00	90	0.1200	9550	1146	8.1
4.00	90	0.1200	7160	859	10.8
5.00	90	0.1200	5730	688	13.5
6.00	90	0.1500	4775	716	20.3
8.00	90	0.1500	3580	537	27.0
9.00	90	0.2000	3185	637	40.5
10.00	90	0.2000	2865	573	45.0
12.00	90	0.2000	2385	477	53.9
14.00	90	0.2400	2045	491	75.6
3.00	70	0.1150	7425	854	6.0
4.00	70	0.1150	5570	641	8.1
5.00	70	0.1150	4455	512	10.1
6.00	70	0.1450	3715	539	15.2
8.00	70	0.1450	2785	404	20.3
9.00	70	0.1900	2475	470	29.9
10.00	70	0.1900	2230	424	33.3
12.00	70	0.1900	1855	353	39.9
14.00	70	0.2300	1590	366	56.3
3.00	45	0.1000	4775	478	3.4
4.00	45	0.1000	3580	358	4.5
5.00	45	0.1000	2865	287	5.6
6.00	45	0.1400	2385	334	9.4
8.00	45	0.1400	1790	251	12.6
9.00	45	0.1800	1590	286	18.2
10.00	45	0.1800	1430	257	20.2
12.00	45	0.1800	1195	215	24.3
14.00	45	0.2200	1025	226	34.7
3.00	30	0.0900	3185	287	2.0
4.00	30	0.0900	2385	215	2.7
5.00	30	0.0900	1910	172	3.4
6.00	30	0.1250	1590	199	5.6
8.00	30	0.1250	1195	149	7.5
9.00	30	0.1600	1060	170	10.8
10.00	30	0.1600	955	153	12.0
12.00	30	0.1600	795	127	14.4
14.00	30	0.2000	680	136	20.9
3.00	35	0.1000	3715	372	2.6
4.00	35	0.1000	2785	279	3.5
5.00	35	0.1000	2230	223	4.4
6.00	35	0.1400	1855	260	7.3
8.00	35	0.1400	1395	195	9.8
9.00	35	0.1800	1240	223	14.2
10.00	35	0.1800	1115	201	15.8
12.00	35	0.1800	930	167	18.9
14.00	35	0.2200	795	175	26.9
3.00	70	0.1600	7425	1188	8.4
4.00	70	0.1600	5570	891	11.2
5.00	70	0.1600	4455	713	14.0
6.00	70	0.2100	3715	780	22.1
8.00	70	0.2100	2785	585	29.4
9.00	70	0.2600	2475	644	40.9
10.00	70	0.2600	2230	580	45.5
12.00	70	0.2600	1855	482	54.5
14.00	70	0.3200	1590	509	78.3