

Application



Material

Steel
850 - 1100 N/mm²



Steel
1300 - 1500 N/mm²



Hardened tool steel
48 - 52 HRC



Stainless steel
[Cr-Ni/1.4301]



Cast iron
(lamellar / spheroidal)



Wrought aluminium alloys
Si < 6%
hardened



Cast aluminium



Titanium alloys
> 300 HB
[Ti6Al4V]



G	D ₁ [mm]	P(TPI)	z	v _c [m/min]	f _z [mm]	L _K [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
G 1/8	7.95	28.0	4	80	0.0180	22.4	3205	42	231
G 1/4	9.95	19.0	4	80	0.0240	30.4	2560	60	246
G 3/8	13.60	19.0	4	80	0.0310	37.3	1870	43	232
G 1/8	7.95	28.0	4	50	0.0160	22.4	2000	23	128
G 1/4	9.95	19.0	4	50	0.0210	30.4	1600	33	134
G 3/8	13.60	19.0	4	50	0.0275	37.3	1170	24	129
G 1/8	7.95	28.0	4	30	0.0120	22.4	1200	11	58
G 1/4	9.95	19.0	4	30	0.0160	30.4	960	15	61
G 3/8	13.60	19.0	4	30	0.0205	37.3	700	11	57
G 1/8	7.95	28.0	4	50	0.0120	22.4	2000	18	96
G 1/4	9.95	19.0	4	50	0.0160	30.4	1600	25	102
G 3/8	13.60	19.0	4	50	0.0205	37.3	1170	18	96
G 1/8	7.95	28.0	4	120	0.0180	22.4	4805	63	346
G 1/4	9.95	19.0	4	120	0.0240	30.4	3840	90	369
G 3/8	13.60	19.0	4	120	0.0310	37.3	2810	64	348
G 1/8	7.95	28.0	4	150	0.0250	22.4	6005	110	601
G 1/4	9.95	19.0	4	150	0.0335	30.4	4800	157	643
G 3/8	13.60	19.0	4	150	0.0430	37.3	3510	111	604
G 1/8	7.95	28.0	4	200	0.0250	22.4	8010	146	801
G 1/4	9.95	19.0	4	200	0.0335	30.4	6400	209	858
G 3/8	13.60	19.0	4	200	0.0430	37.3	4680	148	805
G 1/8	7.95	28.0	4	40	0.0120	22.4	1600	14	77
G 1/4	9.95	19.0	4	40	0.0160	30.4	1280	20	82
G 3/8	13.60	19.0	4	40	0.0205	37.3	935	14	77