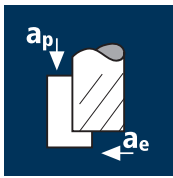


Application

Material



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
3.00	4	86	0.013	3.750	1.200	9125	475	2.1
4.00	4	86	0.017	5.000	1.600	6845	465	3.7
5.00	4	72	0.020	6.250	3.250	4585	370	7.5
6.00	4	72	0.024	9.000	3.900	3820	370	13.0
8.00	4	72	0.032	12.000	5.200	2865	370	23.2
10.00	4	72	0.041	15.000	6.500	2290	370	36.2
12.00	4	72	0.049	18.000	7.800	1910	370	52.1
16.00	4	72	0.058	20.000	10.400	1430	330	68.6
20.00	4	72	0.072	25.000	13.000	1145	330	107.3

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex steel
[17-4 PH]



3.00	4	53	0.013	3.750	1.200	5625	290	1.3
4.00	4	53	0.017	5.000	1.600	4220	285	2.3
5.00	4	53	0.020	6.250	3.250	3375	275	5.6
6.00	4	53	0.024	9.000	3.900	2810	275	9.6
8.00	4	53	0.032	12.000	5.200	2110	275	17.1
10.00	4	53	0.041	15.000	6.500	1685	275	26.6
12.00	4	53	0.049	18.000	7.800	1405	275	38.4
16.00	4	53	0.058	20.000	10.400	1055	245	50.5
20.00	4	53	0.072	25.000	13.000	845	245	79.0

Inox difficile
[Cr-Ni-Mo+/1.4529]
Heat resistant steel
[1.4841]



3.00	4	44	0.012	3.750	1.200	4670	215	1.0
4.00	4	44	0.015	5.000	1.600	3500	210	1.7
5.00	4	40	0.018	6.250	3.250	2545	185	3.7
6.00	4	40	0.022	9.000	3.900	2120	180	6.4
8.00	4	40	0.029	12.000	5.200	1590	185	11.5
10.00	4	40	0.036	15.000	6.500	1275	185	17.9
12.00	4	40	0.043	18.000	7.800	1060	180	25.6
16.00	4	40	0.050	20.000	10.400	795	160	33.1
20.00	4	40	0.061	25.000	13.000	635	155	50.5

Inox martensitic
C < 0.3%
[Cr/1.4021]



3.00	4	110	0.017	3.750	1.200	11670	780	3.5
4.00	4	110	0.023	5.000	1.600	8755	790	6.3
5.00	4	92	0.027	6.250	3.250	5855	635	12.8
6.00	4	92	0.032	9.000	3.900	4880	635	22.3
8.00	4	92	0.043	12.000	5.200	3660	630	39.3
10.00	4	92	0.054	15.000	6.500	2930	635	61.7
12.00	4	92	0.065	18.000	7.800	2440	635	89.1
16.00	4	92	0.079	20.000	10.400	1830	580	120.3
20.00	4	92	0.097	25.000	13.000	1465	570	184.6



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



3.00	4	63	0.007	2.250	3.000	6685	175	1.2
4.00	4	63	0.009	3.000	4.000	5015	170	2.0
5.00	4	63	0.013	6.250	5.000	4010	210	6.6
6.00	4	63	0.019	9.000	6.000	3340	260	14.0
8.00	4	63	0.026	12.000	8.000	2505	260	24.9
10.00	4	63	0.032	15.000	10.000	2005	260	39.0
12.00	4	63	0.039	18.000	12.000	1670	260	56.1
16.00	4	63	0.046	20.000	16.000	1255	230	73.9
20.00	4	63	0.058	25.000	20.000	1005	230	115.5

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex steel
[17-4 PH]



3.00	4	42	0.007	2.250	3.000	4455	115	0.8
4.00	4	42	0.009	3.000	4.000	3340	115	1.4
5.00	4	46	0.013	6.250	5.000	2930	155	4.8
6.00	4	46	0.019	9.000	6.000	2440	190	10.2
8.00	4	46	0.026	12.000	8.000	1830	190	18.2
10.00	4	46	0.032	15.000	10.000	1465	190	28.5
12.00	4	46	0.039	18.000	12.000	1220	190	41.0
16.00	4	46	0.046	20.000	16.000	915	170	54.0
20.00	4	46	0.058	25.000	20.000	730	170	84.3

Inox difficile
[Cr-Ni-Mo+/1.4529]
Heat resistant steel
[1.4841]



3.00	4	35	0.006	2.250	3.000	3715	85	0.6
4.00	4	35	0.007	3.000	4.000	2785	85	1.0
5.00	4	35	0.012	6.250	5.000	2230	105	3.3
6.00	4	35	0.017	9.000	6.000	1855	130	6.9
8.00	4	35	0.023	12.000	8.000	1395	130	12.4
10.00	4	35	0.029	15.000	10.000	1115	130	19.3
12.00	4	35	0.034	18.000	12.000	930	130	27.6
16.00	4	35	0.040	20.000	16.000	695	110	35.7
20.00	4	35	0.049	25.000	20.000	555	110	54.4

Inox martensitic
C < 0.3%
[Cr/1.4021]



3.00	4	81	0.007	2.250	3.000	8595	230	1.6
4.00	4	81	0.009	3.000	4.000	6445	230	2.8
5.00	4	81	0.014	5.000	5.000	5155	280	7.0
6.00	4	81	0.020	7.500	6.000	4295	335	15.1
8.00	4	81	0.026	10.000	8.000	3225	335	26.6
10.00	4	81	0.032	12.500	10.000	2580	335	41.8
12.00	4	81	0.039	15.000	12.000	2150	335	60.3
16.00	4	81	0.047	16.000	16.000	1610	305	78.2
20.00	4	81	0.058	20.000	20.000	1290	300	120.0