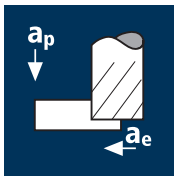


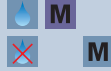


## Application



## Material

Steel  
850 - 1100 N/mm<sup>2</sup>



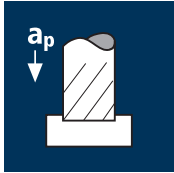
Steel  
1100 - 1300 N/mm<sup>2</sup>



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



Titanium alloys  
up to 300 HB  
[Ti5Al2.5Sn]



Steel  
850 - 1100 N/mm<sup>2</sup>



Steel  
1100 - 1300 N/mm<sup>2</sup>



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



Titanium alloys  
up to 300 HB  
[Ti5Al2.5Sn]



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>t</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [mm <sup>3</sup> /min]
1.00	2	132	0.022	0.400	0.090	42015	1850	66.6
1.20	2	158	0.026	0.480	0.110	41910	2180	115.1
1.50	2	180	0.034	0.600	0.140	38195	2595	218.2
2.00	2	180	0.044	0.800	0.180	28650	2520	363.0
2.50	2	180	0.056	1.000	0.230	22920	2565	590.4
3.00	2	180	0.066	1.200	0.270	19100	2520	816.8
1.00	2	132	0.020	0.400	0.090	42015	1680	60.5
1.20	2	158	0.024	0.480	0.110	41910	2010	106.2
1.50	2	160	0.030	0.600	0.140	33955	2035	171.1
2.00	2	160	0.040	0.800	0.180	25465	2035	293.4
2.50	2	160	0.050	1.000	0.230	20370	2035	468.6
3.00	2	160	0.060	1.200	0.270	16975	2035	660.0
1.00	2	80	0.018	0.400	0.090	25465	915	33.0
1.20	2	80	0.020	0.480	0.110	21220	850	44.8
1.50	2	80	0.028	0.600	0.140	16975	950	79.9
2.00	2	80	0.036	0.800	0.180	12730	915	132.0
2.50	2	80	0.044	1.000	0.230	10185	895	206.2
3.00	2	80	0.052	1.200	0.270	8490	885	286.0
1.00	2	60	0.016	0.400	0.090	19100	610	22.0
1.20	2	60	0.018	0.480	0.110	15915	575	30.3
1.50	2	60	0.024	0.600	0.140	12730	610	51.3
2.00	2	60	0.030	0.800	0.180	9550	575	82.5
2.50	2	60	0.040	1.000	0.230	7640	610	140.6
3.00	2	60	0.046	1.200	0.270	6365	585	189.8
1.00	2	132	0.018	0.060	1.000	42015	1515	90.8
1.20	2	158	0.022	0.070	1.200	41910	1845	154.9
1.50	2	160	0.028	0.090	1.500	33955	1900	256.7
2.00	2	160	0.036	0.120	2.000	25465	1835	440.0
2.50	2	160	0.046	0.150	2.500	20370	1875	702.8
3.00	2	160	0.054	0.180	3.000	16975	1835	990.1
1.00	2	132	0.018	0.060	1.000	42015	1515	90.8
1.20	2	140	0.020	0.070	1.200	37135	1485	124.8
1.50	2	140	0.026	0.090	1.500	29710	1545	208.6
2.00	2	140	0.034	0.120	2.000	22280	1515	363.6
2.50	2	140	0.044	0.150	2.500	17825	1570	588.2
3.00	2	140	0.052	0.180	3.000	14855	1545	834.2
1.00	2	70	0.016	0.060	1.000	22280	715	42.8
1.20	2	70	0.020	0.070	1.200	18570	745	62.4
1.50	2	70	0.024	0.090	1.500	14855	715	96.3
2.00	2	70	0.032	0.120	2.000	11140	715	171.1
2.50	2	70	0.040	0.150	2.500	8915	715	267.4
3.00	2	70	0.048	0.180	3.000	7425	715	385.0
1.00	2	50	0.014	0.060	1.000	15915	445	26.7
1.20	2	50	0.018	0.070	1.200	13265	475	40.1
1.50	2	50	0.022	0.090	1.500	10610	465	63.0
2.00	2	50	0.028	0.120	2.000	7960	445	107.0
2.50	2	50	0.036	0.150	2.500	6365	460	171.9
3.00	2	50	0.044	0.180	3.000	5305	465	252.1