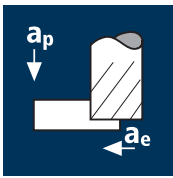


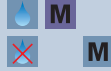


## Application



## Material

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



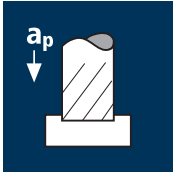
Steel  
1100 - 1300 N/mm<sup>2</sup>



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>s</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	0.018	0.300	0.090	42015	1515	40.8
1.20	2	158	0.022	0.360	0.110	41910	1845	73.0
1.50	2	180	0.028	0.450	0.140	38195	2140	134.8
2.00	2	180	0.036	0.600	0.180	28650	2065	222.8
2.50	2	180	0.046	0.750	0.230	22920	2110	363.7
3.00	2	180	0.054	0.900	0.270	19100	2065	501.2

1.00	2	132	0.016	0.300	0.090	42015	1345	36.3
1.20	2	158	0.020	0.360	0.110	41910	1675	66.4
1.50	2	160	0.026	0.450	0.140	33955	1765	111.2
2.00	2	160	0.032	0.600	0.180	25465	1630	176.0
2.50	2	160	0.042	0.750	0.230	20370	1710	295.2
3.00	2	160	0.048	0.900	0.270	16975	1630	396.0

1.00	2	80	0.014	0.300	0.090	25465	715	19.3
1.20	2	80	0.018	0.360	0.110	21220	765	30.3
1.50	2	80	0.022	0.450	0.140	16975	745	47.1
2.00	2	80	0.028	0.600	0.180	12730	715	77.0
2.50	2	80	0.036	0.750	0.230	10185	735	126.5
3.00	2	80	0.044	0.900	0.270	8490	745	181.5

1.00	2	60	0.012	0.300	0.090	19100	460	12.4
1.20	2	60	0.016	0.360	0.110	15915	510	20.2
1.50	2	60	0.020	0.450	0.140	12730	510	32.1
2.00	2	60	0.026	0.600	0.180	9550	495	53.6
2.50	2	60	0.032	0.750	0.230	7640	490	84.3
3.00	2	60	0.038	0.900	0.270	6365	485	117.6

1.00	2	132	0.016	0.040	1.000	42015	1345	53.8
1.20	2	158	0.018	0.050	1.200	41910	1510	90.5
1.50	2	160	0.024	0.060	1.500	33955	1630	146.7
2.00	2	160	0.030	0.080	2.000	25465	1530	244.5
2.50	2	160	0.038	0.100	2.500	20370	1550	387.1
3.00	2	160	0.046	0.120	3.000	16975	1560	562.3

1.00	2	132	0.016	0.040	1.000	42015	1345	53.8
1.20	2	140	0.018	0.050	1.200	37135	1335	80.2
1.50	2	140	0.022	0.060	1.500	29710	1305	117.6
2.00	2	140	0.028	0.080	2.000	22280	1250	199.6
2.50	2	140	0.036	0.100	2.500	17825	1285	320.9
3.00	2	140	0.044	0.120	3.000	14855	1305	470.6

1.00	2	70	0.014	0.040	1.000	22280	625	25.0
1.20	2	70	0.016	0.050	1.200	18570	595	35.7
1.50	2	70	0.022	0.060	1.500	14855	655	58.8
2.00	2	70	0.026	0.080	2.000	11140	580	92.7
2.50	2	70	0.034	0.100	2.500	8915	605	151.5
3.00	2	70	0.040	0.120	3.000	7425	595	213.9

1.00	2	50	0.012	0.040	1.000	15915	380	15.3
1.20	2	50	0.014	0.050	1.200	13265	370	22.3
1.50	2	50	0.020	0.060	1.500	10610	425	38.2
2.00	2	50	0.024	0.080	2.000	7960	380	61.1
2.50	2	50	0.030	0.100	2.500	6365	380	95.5
3.00	2	50	0.036	0.120	3.000	5305	380	137.5