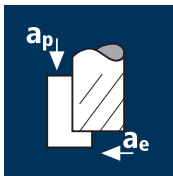




## Application

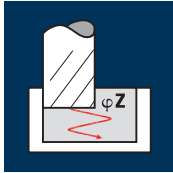


## Material

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



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 [cm <sup>3</sup> /min]	φZ [°]
6.00	5	150	0.040	10.800	2.100	7960	1590	36.1	10°
8.00	5	150	0.050	14.400	2.800	5970	1490	60.2	12°
10.00	5	150	0.065	18.000	3.500	4775	1550	97.8	12°
12.00	5	150	0.075	21.600	4.200	3980	1490	135.4	12°
16.00	5	150	0.085	24.000	5.600	2985	1270	170.5	12°
20.00	5	150	0.100	30.000	7.000	2385	1195	250.7	12°



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



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 [cm <sup>3</sup> /min]	φZ [°]
6.00	5	115	0.035	10.800	2.100	6100	1070	24.2	10°
8.00	5	115	0.045	14.400	2.800	4575	1030	41.5	11°
10.00	5	115	0.055	18.000	3.500	3660	1005	63.4	11°
12.00	5	115	0.065	21.600	4.200	3050	990	89.9	11°
16.00	5	115	0.075	24.000	5.600	2290	860	115.3	11°
20.00	5	115	0.090	30.000	7.000	1830	825	173.0	11°

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



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 [cm <sup>3</sup> /min]	φZ [°]
6.00	5	90	0.030	10.800	2.100	4775	715	16.2	8°
8.00	5	90	0.035	14.400	2.800	3580	625	25.3	8°
10.00	5	90	0.045	18.000	3.500	2865	645	40.6	8°
12.00	5	90	0.055	21.600	4.200	2385	655	59.6	8°
16.00	5	90	0.065	24.000	5.600	1790	580	78.2	8°
20.00	5	90	0.080	30.000	7.000	1430	575	120.3	8°

## Application

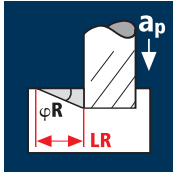


## Material

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



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 [cm <sup>3</sup> /min]	φR [°]	LR [mm]
6.00	5	120	0.024	6.000	6.000	6365	765	27.5	12°	28.2
8.00	5	120	0.030	8.000	8.000	4775	715	45.8	12°	37.6
10.00	5	120	0.039	10.000	10.000	3820	745	74.5	12°	47.0
12.00	5	120	0.045	12.000	12.000	3185	715	103.1	12°	56.5
16.00	5	120	0.051	16.000	16.000	2385	610	155.8	12°	75.3
20.00	5	120	0.060	20.000	20.000	1910	575	229.2	12°	94.1



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



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 [cm <sup>3</sup> /min]	φR [°]	LR [mm]
6.00	5	90	0.021	6.000	6.000	4775	500	18.0	12°	28.2
8.00	5	90	0.027	8.000	8.000	3580	485	30.9	12°	37.6
10.00	5	90	0.033	10.000	10.000	2865	475	47.3	12°	47.0
12.00	5	90	0.039	12.000	12.000	2385	465	67.0	12°	56.5
16.00	5	90	0.045	16.000	16.000	1790	405	103.1	12°	75.3
20.00	5	90	0.054	20.000	20.000	1430	385	154.7	12°	94.1

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



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 [cm <sup>3</sup> /min]	φR [°]	LR [mm]
6.00	5	70	0.018	6.000	6.000	3715	335	12.0	12°	28.2
8.00	5	70	0.021	8.000	8.000	2785	290	18.7	12°	37.6
10.00	5	70	0.027	10.000	10.000	2230	300	30.1	12°	47.0
12.00	5	70	0.033	12.000	12.000	1855	305	44.1	12°	56.5
16.00	5	70	0.039	16.000	16.000	1395	270	69.5	12°	75.3
20.00	5	70	0.048	20.000	20.000	1115	265	107.0	12°	94.1

This way to the cutting data software  
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Quick, easy, reliable.

