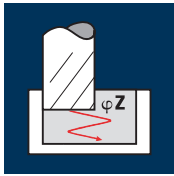


Application



Material

Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



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

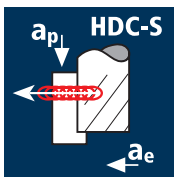


d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	φZ [°]
6.00	4	75	0.033	38.000	5.400	3980	525	8.0°
8.00	4	75	0.044	51.000	7.200	2985	525	8.0°
10.00	4	75	0.055	63.000	9.000	2385	525	8.0°
12.00	4	75	0.066	76.000	10.800	1990	525	8.0°
16.00	4	75	0.075	101.000	14.400	1490	448	8.0°
20.00	4	75	0.090	126.000	18.000	1195	430	8.0°

6.00	4	58	0.028	38.000	5.400	3075	347	8.0°
8.00	4	58	0.038	51.000	7.200	2310	347	8.0°
10.00	4	58	0.047	63.000	9.000	1845	347	8.0°
12.00	4	58	0.056	76.000	10.800	1540	347	8.0°
16.00	4	58	0.066	101.000	14.400	1155	303	8.0°
20.00	4	58	0.080	126.000	18.000	925	296	8.0°

6.00	4	45	0.023	38.000	5.400	2385	218	6.0°
8.00	4	45	0.030	51.000	7.200	1790	218	6.0°
10.00	4	45	0.038	63.000	9.000	1430	217	6.0°
12.00	4	45	0.046	76.000	10.800	1195	218	6.0°
16.00	4	45	0.054	101.000	14.400	895	195	6.0°
20.00	4	45	0.066	126.000	18.000	715	189	6.0°

Application



Material

Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



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



d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6.00	4	143	0.121	38.000	0.150	7585	3671	20.9
8.00	4	143	0.190	51.000	0.200	5690	4324	44.1
10.00	4	143	0.234	63.000	0.250	4550	4259	67.1
12.00	4	143	0.273	76.000	0.300	3795	4144	94.5
16.00	4	143	0.269	101.000	0.400	2845	3061	123.7
20.00	4	143	0.328	126.000	0.500	2275	2985	188.0

6.00	4	113	0.098	38.000	0.150	5995	2350	13.4
8.00	4	113	0.154	51.000	0.200	4495	2769	28.2
10.00	4	113	0.189	63.000	0.250	3595	2718	42.8
12.00	4	113	0.221	76.000	0.300	2995	2648	60.4
16.00	4	113	0.218	101.000	0.400	2250	1962	79.3
20.00	4	113	0.266	126.000	0.500	1800	1915	120.7

6.00	4	119	0.053	38.000	0.150	6315	1339	7.6
8.00	4	119	0.083	51.000	0.200	4735	1572	16.0
10.00	4	119	0.102	63.000	0.250	3790	1546	24.4
12.00	4	119	0.118	76.000	0.300	3155	1489	34.0
16.00	4	119	0.114	101.000	0.400	2365	1078	43.6
20.00	4	119	0.139	126.000	0.500	1895	1054	66.4

Precise cutting data for other applications and materials can be found in the cutting data software **ToolExpert**

