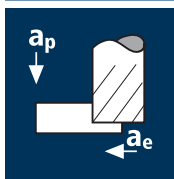


Application



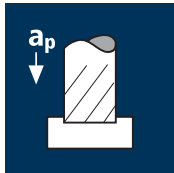
Material

Hardened tool steel
42 - 48 HRC

Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC



Hardened tool steel
42 - 48 HRC

Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

d1 [mm]	z	v _r [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [mm ³ /min]
0.20	2	26	0.001	0.004	0.040	41380	105	0.0
0.40	2	53	0.003	0.008	0.080	42175	215	0.1
0.50	2	66	0.004	0.010	0.100	42015	320	0.3
0.80	2	106	0.005	0.016	0.160	42175	425	1.1
1.00	2	132	0.006	0.020	0.200	42015	530	2.1
1.50	2	140	0.010	0.030	0.300	29710	600	5.4
2.00	2	140	0.013	0.040	0.400	22280	560	9.0
2.50	2	140	0.016	0.050	0.500	17825	585	14.6
3.00	2	140	0.019	0.060	0.600	14855	560	20.2
0.20	2	26	0.001	0.004	0.040	41380	100	0.0
0.40	2	53	0.002	0.008	0.080	42175	200	0.1
0.50	2	66	0.004	0.010	0.100	42015	305	0.3
0.80	2	106	0.005	0.016	0.160	42175	405	1.0
1.00	2	120	0.006	0.020	0.200	38195	460	1.8
1.50	2	120	0.010	0.030	0.300	25465	490	4.4
2.00	2	120	0.012	0.040	0.400	19100	460	7.3
2.50	2	120	0.016	0.050	0.500	15280	475	11.9
3.00	2	120	0.018	0.060	0.600	12730	460	16.5
0.20	2	26	0.001	0.004	0.040	41380	85	0.0
0.40	2	53	0.002	0.008	0.080	42175	170	0.1
0.50	2	66	0.003	0.010	0.100	42015	250	0.3
0.80	2	100	0.004	0.016	0.160	39790	320	0.8
1.00	2	100	0.005	0.020	0.200	31830	320	1.3
1.50	2	100	0.008	0.030	0.300	21220	340	3.1
2.00	2	100	0.010	0.040	0.400	15915	320	5.1
2.50	2	100	0.013	0.050	0.500	12730	330	8.3
3.00	2	100	0.015	0.060	0.600	10610	320	11.5
0.20	2	26	0.001	0.004	0.040	41380	75	0.0
0.40	2	53	0.002	0.008	0.080	42175	150	0.1
0.50	2	60	0.003	0.010	0.100	38195	205	0.2
0.80	2	60	0.004	0.016	0.160	23875	170	0.4
1.00	2	60	0.004	0.020	0.200	19100	170	0.7
1.50	2	60	0.007	0.030	0.300	12730	185	1.7
2.00	2	60	0.009	0.040	0.400	9550	170	2.8
2.50	2	60	0.012	0.050	0.500	7640	180	4.5
3.00	2	60	0.014	0.060	0.600	6365	170	6.2
0.20	2	26	0.001	0.001	0.200	41380	90	0.0
0.40	2	53	0.002	0.003	0.400	42175	185	0.2
0.50	2	66	0.003	0.003	0.500	42015	275	0.4
0.80	2	106	0.004	0.005	0.800	42175	370	1.5
1.00	2	120	0.005	0.006	1.000	38195	420	2.5
1.50	2	120	0.009	0.009	1.500	25465	450	6.1
2.00	2	120	0.011	0.013	2.000	19100	420	10.9
2.50	2	120	0.014	0.016	2.500	15280	435	17.5
3.00	2	120	0.016	0.019	3.000	12730	420	23.9
0.20	2	26	0.001	0.001	0.200	41380	90	0.0
0.40	2	53	0.002	0.003	0.400	42175	185	0.2
0.50	2	66	0.003	0.003	0.500	42015	275	0.4
0.80	2	100	0.004	0.005	0.800	39790	350	1.4
1.00	2	100	0.005	0.006	1.000	31830	350	2.1
1.50	2	100	0.009	0.009	1.500	21220	375	5.0
2.00	2	100	0.011	0.013	2.000	15915	350	9.1
2.50	2	100	0.014	0.016	2.500	12730	365	14.6
3.00	2	100	0.016	0.019	3.000	10610	350	20.0
0.20	2	26	0.001	0.001	0.200	41380	85	0.0
0.40	2	53	0.002	0.003	0.400	42175	170	0.2
0.50	2	66	0.003	0.003	0.500	42015	250	0.4
0.80	2	80	0.004	0.005	0.800	31830	255	1.0
1.00	2	80	0.005	0.006	1.000	25465	255	1.5
1.50	2	80	0.008	0.009	1.500	16975	270	3.7
2.00	2	80	0.010	0.013	2.000	12730	255	6.6
2.50	2	80	0.013	0.016	2.500	10185	265	10.6
3.00	2	80	0.015	0.019	3.000	8490	255	14.5
0.20	2	26	0.001	0.001	0.200	41380	75	0.0
0.40	2	40	0.002	0.003	0.400	31830	115	0.1
0.50	2	40	0.003	0.003	0.500	25465	140	0.2
0.80	2	40	0.004	0.005	0.800	15915	115	0.5
1.00	2	40	0.004	0.006	1.000	12730	115	0.7
1.50	2	40	0.007	0.009	1.500	8490	120	1.7
2.00	2	40	0.009	0.013	2.000	6365	115	3.0
2.50	2	40	0.012	0.016	2.500	5095	120	4.8
3.00	2	40	0.014	0.019	3.000	4245	115	6.5