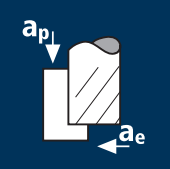













Application	Material	$d_1$ [mm]	$z$	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$n$ [min <sup>-1</sup> ]	$v_f$ [mm/min]	$Q$ [mm <sup>3</sup> /min]
	Steel 850 - 1100 N/mm <sup>2</sup>  	1.00	2	48	0.007	0.200	0.100	15280	214	4.3
		1.50	2	48	0.011	0.300	0.150	10185	214	9.7
		2.00	2	48	0.014	0.400	0.200	7640	214	17.1
		3.00	2	48	0.021	0.600	0.300	5095	214	38.5
	Steel 1100 - 1300 N/mm <sup>2</sup>  	1.00	2	37	0.006	0.200	0.100	11775	141	2.9
		1.50	2	37	0.009	0.300	0.150	7850	141	6.4
		2.00	2	37	0.012	0.400	0.200	5890	141	11.3
		3.00	2	37	0.018	0.600	0.300	3925	141	25.5
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]  	1.00	2	29	0.005	0.200	0.100	9230	83	1.7
		1.50	2	29	0.007	0.300	0.150	6155	83	3.8
		2.00	2	29	0.009	0.400	0.200	4615	83	6.7
		3.00	2	29	0.014	0.600	0.300	3075	83	15.0
	Titanium alloys > 300 HB [Ti6Al4V]  	1.00	2	18	0.005	0.200	0.100	5730	52	1.1
		1.50	2	18	0.007	0.300	0.150	3820	52	2.3
		2.00	2	18	0.009	0.400	0.200	2865	52	4.2
		3.00	2	18	0.014	0.600	0.300	1910	52	9.3

Application	Material	$d_1$ [mm]	$z$	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$n$ [min <sup>-1</sup> ]	$v_f$ [mm/min]	$Q$ [mm <sup>3</sup> /min]
	Steel 850 - 1100 N/mm <sup>2</sup>  	1.00	2	43	0.007	0.100	1.000	13685	192	19.2
		1.50	2	43	0.011	0.150	1.500	9125	192	43.1
		2.00	2	43	0.014	0.200	2.000	6845	192	76.7
		3.00	2	43	0.021	0.300	3.000	4560	192	172.4
	Steel 1100 - 1300 N/mm <sup>2</sup>  	1.00	2	33	0.006	0.100	1.000	10505	126	12.6
		1.50	2	33	0.009	0.150	1.500	7005	126	28.4
		2.00	2	33	0.012	0.200	2.000	5250	126	50.4
		3.00	2	33	0.018	0.300	3.000	3500	126	113.4
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]  	1.00	2	26	0.005	0.100	1.000	8275	75	7.5
		1.50	2	26	0.007	0.150	1.500	5515	75	16.8
		2.00	2	26	0.009	0.200	2.000	4140	75	29.8
		3.00	2	26	0.014	0.300	3.000	2760	75	67.1
	Titanium alloys > 300 HB [Ti6Al4V]  	1.00	2	17	0.005	0.100	1.000	5410	49	4.9
		1.50	2	17	0.007	0.150	1.500	3610	49	11.0
		2.00	2	17	0.009	0.200	2.000	2705	49	19.5
		3.00	2	17	0.014	0.300	3.000	1805	49	43.9