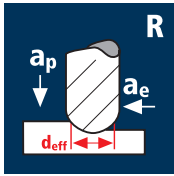


Application



Material

Steel
850 - 1100 N/mm²

Hardened tool steel
52 - 56 HRC

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

Titanium alloys
> 300 HB
[Ti6Al4V]

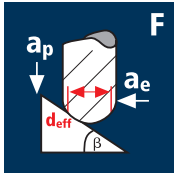
d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	Q [mm ² /min]
1.00	2	37	0.010	0.020	0.150	0.28	42062	824	2.5
1.50	2	78	0.021	0.060	0.150	0.59	42082	1734	15.6
2.00	2	97	0.028	0.080	0.200	0.78	39585	2177	34.9
3.00	2	97	0.041	0.120	0.300	1.18	26166	2156	77.6

1.00	2	37	0.007	0.020	0.150	0.28	42062	581	1.8
1.50	2	49	0.015	0.060	0.150	0.59	26436	772	7.0
2.00	2	49	0.019	0.080	0.200	0.78	19996	776	12.4
3.00	2	49	0.029	0.120	0.300	1.18	13218	772	27.8

1.00	2	37	0.007	0.020	0.150	0.28	42062	606	1.8
1.50	2	49	0.015	0.060	0.150	0.59	26436	798	7.2
2.00	2	49	0.020	0.080	0.200	0.78	19996	804	12.9
3.00	2	49	0.030	0.120	0.300	1.18	13218	798	28.8

1.00	2	32	0.008	0.020	0.150	0.28	36378	560	1.7
1.50	2	32	0.016	0.060	0.150	0.59	17264	556	5.0
2.00	2	32	0.021	0.080	0.200	0.78	13059	559	9.0
3.00	2	32	0.032	0.120	0.300	1.18	8632	556	20.0

Application



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

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d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
1.00	2	108	0.058	0.030	0.090	0.91	37777	4382	45°
1.50	2	127	0.068	0.030	0.105	1.32	30625	4165	45°
2.00	2	127	0.078	0.040	0.120	1.75	23100	3604	45°
3.00	2	127	0.098	0.050	0.150	2.59	15608	3059	45°

1.00	2	79	0.058	0.030	0.090	0.91	27633	3205	45°
1.50	2	79	0.068	0.030	0.105	1.32	19050	2591	45°
2.00	2	79	0.078	0.040	0.120	1.75	14369	2242	45°
3.00	2	79	0.098	0.050	0.150	2.59	9709	1903	45°

1.00	2	79	0.058	0.030	0.090	0.91	27633	3205	45°
1.50	2	79	0.068	0.030	0.105	1.32	19050	2591	45°
2.00	2	79	0.078	0.040	0.120	1.75	14369	2242	45°
3.00	2	79	0.098	0.050	0.150	2.59	9709	1903	45°

1.00	2	59	0.058	0.030	0.090	0.91	20638	2394	45°
1.50	2	59	0.068	0.030	0.105	1.32	14227	1935	45°
2.00	2	59	0.078	0.040	0.120	1.75	10732	1674	45°
3.00	2	59	0.098	0.050	0.150	2.59	7251	1421	45°