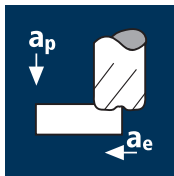


Application




Material



Steel
850 - 1100 N/mm²



 



Steel
1100 - 1300 N/mm²



 

Steel
1300 - 1500 N/mm²


 

Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	4	250	0.315	0.240	3.600	13265	16710	14.4
8.00	4	250	0.420	0.320	4.800	9945	16710	25.7
10.00	4	250	0.525	0.400	6.000	7960	16710	40.1
12.00	4	250	0.630	0.480	7.200	6630	16710	57.8
16.00	4	250	0.695	0.560	9.600	4975	13825	74.3
6.00	4	220	0.270	0.240	3.600	11670	12605	10.9
8.00	4	220	0.355	0.320	4.800	8755	12430	19.1
10.00	4	220	0.445	0.400	6.000	7005	12465	29.9
12.00	4	220	0.535	0.480	7.200	5835	12490	43.2
16.00	4	220	0.590	0.560	9.600	4375	10330	55.5
6.00	4	200	0.245	0.220	3.600	10610	10400	8.2
8.00	4	200	0.330	0.290	4.800	7960	10505	14.6
10.00	4	200	0.410	0.360	6.000	6365	10440	22.6
12.00	4	200	0.490	0.430	7.200	5305	10400	32.2
16.00	4	200	0.540	0.500	9.600	3980	8595	41.3
6.00	4	160	0.180	0.210	3.600	8490	6110	4.6
8.00	4	160	0.240	0.280	4.800	6365	6110	8.2
10.00	4	160	0.300	0.350	6.000	5095	6110	12.8
12.00	4	160	0.360	0.420	7.200	4245	6110	18.5
16.00	4	160	0.480	0.560	9.600	3185	6110	32.9
6.00	4	140	0.150	0.210	3.600	7425	4455	3.4
8.00	4	140	0.200	0.280	4.800	5570	4455	6.0
10.00	4	140	0.250	0.350	6.000	4455	4455	9.4
12.00	4	140	0.300	0.420	7.200	3715	4455	13.5
16.00	4	140	0.400	0.560	9.600	2785	4455	24.0
6.00	4	100	0.090	0.180	3.600	5305	1910	1.2
8.00	4	100	0.120	0.240	4.800	3980	1910	2.2
10.00	4	100	0.150	0.300	6.000	3185	1910	3.4
12.00	4	100	0.180	0.360	7.200	2655	1910	5.0
16.00	4	100	0.240	0.480	9.600	1990	1910	8.8