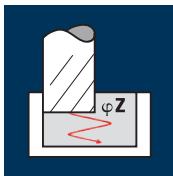


Application



Material

Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



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

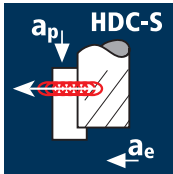


d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	φ _Z [°]
6.00	4	120	0.034	32.000	5.400	6365	865	10°
8.00	4	120	0.043	42.000	7.200	4775	820	10°
10.00	4	120	0.055	53.000	9.000	3820	840	10°
12.00	4	120	0.064	63.000	10.800	3185	815	10°
16.00	4	120	0.072	84.000	14.400	2385	690	10°
20.00	4	120	0.085	105.000	18.000	1910	650	10°

6.00	4	90	0.030	32.000	5.400	4775	575	10°
8.00	4	90	0.038	42.000	7.200	3580	545	10°
10.00	4	90	0.047	53.000	9.000	2865	540	10°
12.00	4	90	0.055	63.000	10.800	2385	525	10°
16.00	4	90	0.064	84.000	14.400	1790	460	10°
20.00	4	90	0.077	105.000	18.000	1430	440	10°

6.00	4	70	0.026	32.000	5.400	3715	385	7°
8.00	4	70	0.030	42.000	7.200	2785	335	7°
10.00	4	70	0.038	53.000	9.000	2230	340	7°
12.00	4	70	0.047	63.000	10.800	1855	350	7°
16.00	4	70	0.055	84.000	14.400	1395	305	7°
20.00	4	70	0.068	105.000	18.000	1115	305	7°

Application



Material

Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



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



d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	4	250	0.124	32.000	0.300	13265	6580	63.2
8.00	4	250	0.165	42.000	0.400	9945	6565	110.3
10.00	4	250	0.207	53.000	0.500	7960	6590	174.6
12.00	4	250	0.241	63.000	0.600	6630	6390	241.5
16.00	4	250	0.268	84.000	0.800	4975	5335	358.5
20.00	4	250	0.330	105.000	1.000	3980	5255	551.8

6.00	4	194	0.103	32.000	0.300	10290	4240	40.7
8.00	4	194	0.145	42.000	0.400	7720	4480	75.3
10.00	4	194	0.172	53.000	0.500	6175	4250	112.6
12.00	4	194	0.213	63.000	0.600	5145	4385	165.8
16.00	4	194	0.241	84.000	0.800	3860	3720	250.0
20.00	4	194	0.296	105.000	1.000	3090	3660	384.3

6.00	4	167	0.062	32.000	0.300	8860	2195	21.1
8.00	4	167	0.086	42.000	0.400	6645	2285	38.4
10.00	4	167	0.107	53.000	0.500	5315	2275	60.3
12.00	4	167	0.124	63.000	0.600	4430	2195	83.0
16.00	4	167	0.141	84.000	0.800	3320	1870	125.7
20.00	4	167	0.179	105.000	1.000	2660	1905	200.0



This way to the cutting data software
ToolExpert MFC.
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