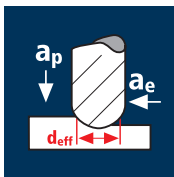




## Application



## 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



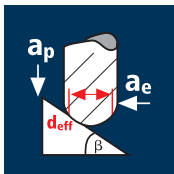
d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>s</sub> [mm]	a <sub>s</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [mm <sup>3</sup> /min]
0.50	2	21	0.019	0.013	0.100	0.16	41780	1580	2.1
0.60	2	25	0.023	0.016	0.120	0.19	41885	1900	3.6
0.80	2	34	0.030	0.021	0.160	0.26	41625	2515	8.5
1.00	2	42	0.038	0.027	0.200	0.32	41780	3160	17.1
1.50	2	63	0.057	0.040	0.300	0.48	41780	4740	56.9
2.00	2	84	0.076	0.053	0.400	0.64	41780	6315	133.9

0.50	2	21	0.018	0.013	0.100	0.16	41780	1505	2.0
0.60	2	25	0.022	0.016	0.120	0.19	41885	1810	3.5
0.80	2	34	0.029	0.021	0.160	0.26	41625	2400	8.1
1.00	2	42	0.036	0.027	0.200	0.32	41780	3010	16.2
1.50	2	63	0.054	0.040	0.300	0.48	41780	4510	54.1
2.00	2	84	0.072	0.053	0.400	0.64	41780	6015	127.5

0.50	2	21	0.015	0.013	0.100	0.16	41780	1255	1.6
0.60	2	25	0.018	0.016	0.120	0.19	41885	1510	2.9
0.80	2	34	0.024	0.021	0.160	0.26	41625	2000	6.7
1.00	2	42	0.030	0.027	0.200	0.32	41780	2505	13.5
1.50	2	63	0.045	0.040	0.300	0.48	41780	3760	45.1
2.00	2	84	0.060	0.053	0.400	0.64	41780	5015	106.3

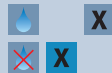
0.50	2	21	0.014	0.013	0.100	0.16	41780	1130	1.5
0.60	2	25	0.016	0.016	0.120	0.19	41885	1355	2.6
0.80	2	34	0.022	0.021	0.160	0.26	41625	1800	6.0
1.00	2	42	0.027	0.027	0.200	0.32	41780	2255	12.2
1.50	2	60	0.041	0.040	0.300	0.48	39790	3225	38.7
2.00	2	60	0.054	0.053	0.400	0.64	29840	3225	68.3

## 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



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>s</sub> [mm]	a <sub>s</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	β [°]
0.50	2	61	0.024	0.020	0.020	0.46	42210	2025	45°
0.60	2	74	0.026	0.024	0.024	0.56	42060	2185	45°
0.80	2	98	0.030	0.032	0.032	0.74	42155	2530	45°
1.00	2	123	0.034	0.040	0.040	0.93	42100	2865	45°
1.50	2	183	0.040	0.060	0.060	1.39	41905	3355	45°
2.00	2	245	0.046	0.080	0.080	1.86	41930	3855	45°

0.50	2	61	0.022	0.020	0.020	0.46	42210	1855	45°
0.60	2	74	0.024	0.024	0.024	0.56	42060	2020	45°
0.80	2	98	0.028	0.032	0.032	0.74	42155	2360	45°
1.00	2	123	0.032	0.040	0.040	0.93	42100	2695	45°
1.50	2	183	0.038	0.060	0.060	1.39	41905	3185	45°
2.00	2	245	0.044	0.080	0.080	1.86	41930	3690	45°

0.50	2	61	0.022	0.020	0.020	0.46	42210	1855	45°
0.60	2	74	0.024	0.024	0.024	0.56	42060	2020	45°
0.80	2	98	0.028	0.032	0.032	0.74	42155	2360	45°
1.00	2	123	0.030	0.040	0.040	0.93	42100	2525	45°
1.50	2	183	0.036	0.060	0.060	1.39	41905	3015	45°
2.00	2	200	0.042	0.080	0.080	1.86	34225	2875	45°

0.50	2	61	0.020	0.020	0.020	0.46	42210	1690	45°
0.60	2	74	0.020	0.024	0.024	0.56	42060	1680	45°
0.80	2	98	0.024	0.032	0.032	0.74	42155	2025	45°
1.00	2	123	0.028	0.040	0.040	0.93	42100	2360	45°
1.50	2	150	0.032	0.060	0.060	1.39	34350	2200	45°
2.00	2	150	0.036	0.080	0.080	1.86	25670	1850	45°