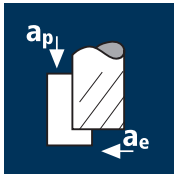


Application



Material

Steel
< 850 N/mm²



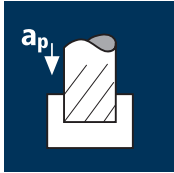
Steel
850 - 1100 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



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



Steel
< 850 N/mm²



Steel
850 - 1100 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



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



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	190	0.050	6.000	2.400	10080	2015	29.0
8.00	4	190	0.065	8.000	3.200	7560	1965	50.3
10.00	4	190	0.080	10.000	4.000	6050	1935	77.4
12.00	4	190	0.095	12.000	4.800	5040	1915	110.3
16.00	4	190	0.125	16.000	3.200	3780	1890	96.8
6.00	4	140	0.050	6.000	2.400	7425	1485	21.4
8.00	4	140	0.065	8.000	3.200	5570	1450	37.1
10.00	4	140	0.080	10.000	4.000	4455	1425	57.0
12.00	4	140	0.095	12.000	4.800	3715	1410	81.3
16.00	4	140	0.125	16.000	3.200	2785	1395	71.3
6.00	4	70	0.045	6.000	2.400	3715	670	9.6
8.00	4	70	0.060	8.000	3.200	2785	670	17.1
10.00	4	70	0.070	10.000	4.000	2230	625	25.0
12.00	4	70	0.085	12.000	4.800	1855	630	36.4
16.00	4	70	0.110	16.000	3.200	1395	615	31.4
6.00	4	90	0.030	6.000	2.400	4775	575	8.3
8.00	4	90	0.040	8.000	3.200	3580	575	14.7
10.00	4	90	0.050	10.000	4.000	2865	575	22.9
12.00	4	90	0.060	12.000	4.800	2385	575	33.0
16.00	4	90	0.080	16.000	3.200	1790	575	29.3
6.00	4	155	0.040	4.200	6.000	8225	1315	33.2
8.00	4	155	0.050	5.600	8.000	6165	1235	55.3
10.00	4	155	0.065	7.000	10.000	4935	1285	89.8
12.00	4	155	0.075	8.400	12.000	4110	1235	124.3
16.00	4	155	0.075	6.400	16.000	3085	925	94.7
6.00	4	105	0.040	4.200	6.000	5570	890	22.5
8.00	4	105	0.050	5.600	8.000	4180	835	37.4
10.00	4	105	0.065	7.000	10.000	3340	870	60.8
12.00	4	105	0.075	8.400	12.000	2785	835	84.2
16.00	4	105	0.075	6.400	16.000	2090	625	64.2
6.00	4	55	0.035	4.200	6.000	2920	410	10.3
8.00	4	55	0.045	5.600	8.000	2190	395	17.6
10.00	4	55	0.055	7.000	10.000	1750	385	27.0
12.00	4	55	0.060	8.400	12.000	1460	350	35.3
16.00	4	55	0.075	6.400	16.000	1095	330	33.6
6.00	4	75	0.030	4.200	6.000	3980	475	12.0
8.00	4	75	0.040	5.600	8.000	2985	475	21.4
10.00	4	75	0.045	7.000	10.000	2385	430	30.1
12.00	4	75	0.050	8.400	12.000	1990	400	40.1
16.00	4	75	0.065	6.400	16.000	1490	390	39.7