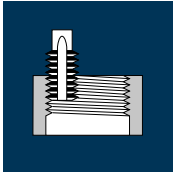


Application



Material

Steel
< 850 N/mm²



M	D ₁ [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M3	2.30	0.50	3	90	0.0160	12455	139	598
M4	3.00	0.70	3	90	0.0160	9550	115	458
M5	4.00	0.80	3	90	0.0200	7160	86	430
M6	4.80	1.00	3	90	0.0240	5970	86	430
M8	6.40	1.25	3	90	0.0280	4475	75	376
M10	7.95	1.50	3	90	0.0400	3605	89	433
M12	9.95	1.75	4	90	0.0480	2880	94	553
M14	11.20	2.00	4	90	0.0480	2560	98	492
M16	12.80	2.00	4	90	0.0480	2240	86	430

Steel
850 - 1100 N/mm²



M3	2.30	0.50	3	80	0.0160	11070	124	531
M4	3.00	0.70	3	80	0.0160	8490	102	408
M5	4.00	0.80	3	80	0.0200	6365	76	382
M6	4.80	1.00	3	80	0.0240	5305	76	382
M8	6.40	1.25	3	80	0.0280	3980	67	334
M10	7.95	1.50	3	80	0.0400	3205	79	385
M12	9.95	1.75	4	80	0.0480	2560	84	492
M14	11.20	2.00	4	80	0.0480	2275	87	437
M16	12.80	2.00	4	80	0.0480	1990	76	382

Steel
1100 - 1300 N/mm²



M3	2.30	0.50	3	60	0.0160	8305	93	399
M4	3.00	0.70	3	60	0.0160	6365	76	306
M5	4.00	0.80	3	60	0.0200	4775	57	287
M6	4.80	1.00	3	60	0.0200	3980	48	239
M8	6.40	1.25	3	60	0.0240	2985	43	215
M10	7.95	1.50	3	60	0.0320	2400	47	230
M12	9.95	1.75	4	60	0.0440	1920	58	338
M14	11.20	2.00	4	60	0.0440	1705	60	300
M16	12.80	2.00	4	60	0.0480	1490	57	286

Steel
1300 - 1500 N/mm²



M3	2.30	0.50	3	45	0.0080	6230	35	150
M4	3.00	0.70	3	45	0.0120	4775	43	172
M5	4.00	0.80	3	45	0.0160	3580	34	172
M6	4.80	1.00	3	45	0.0200	2985	36	179
M8	6.40	1.25	3	45	0.0240	2240	32	161
M10	7.95	1.50	3	45	0.0280	1800	31	151
M12	9.95	1.75	4	45	0.0360	1440	35	207
M14	11.20	2.00	4	45	0.0360	1280	37	184
M16	12.80	2.00	4	45	0.0400	1120	36	179

Wrought aluminium alloys
Si < 6%
hardened



M3	2.30	0.50	3	150	0.0240	20760	349	1495
M4	3.00	0.70	3	150	0.0280	15915	334	1337
M5	4.00	0.80	3	150	0.0320	11935	229	1146
M6	4.80	1.00	3	150	0.0360	9945	215	1074
M8	6.40	1.25	3	150	0.0400	7460	179	895
M10	7.95	1.50	3	150	0.0480	6005	177	865
M12	9.95	1.75	4	150	0.0560	4800	184	1075
M14	11.20	2.00	4	150	0.0560	4265	191	955
M16	12.80	2.00	4	150	0.0640	3730	191	955

Cast iron
(lamellar / spheroidal)



M3	2.30	0.50	3	120	0.0160	16605	186	797
M4	3.00	0.70	3	120	0.0200	12730	191	764
M5	4.00	0.80	3	120	0.0240	9550	138	688
M6	4.80	1.00	3	120	0.0280	7960	134	669
M8	6.40	1.25	3	120	0.0320	5970	115	573
M10	7.95	1.50	3	120	0.0400	4805	118	577
M12	9.95	1.75	4	120	0.0520	3840	136	799
M14	11.20	2.00	4	120	0.0520	3410	142	709
M16	12.80	2.00	4	120	0.0560	2985	134	669

Unalloyed copper



M3	2.30	0.50	3	130	0.0160	17990	201	864
M4	3.00	0.70	3	130	0.0200	13795	207	828
M5	4.00	0.80	3	130	0.0240	10345	149	745
M6	4.80	1.00	3	130	0.0280	8620	145	724
M8	6.40	1.25	3	130	0.0320	6465	124	621
M10	7.95	1.50	3	130	0.0400	5205	128	625
M12	9.95	1.75	4	130	0.0520	4160	148	865
M14	11.20	2.00	4	130	0.0520	3695	154	769
M16	12.80	2.00	4	130	0.0560	3235	145	725

Stainless steel
[Cr-Ni/1.4301]



M3	2.30	0.50	3	55	0.0160	7610	85	365
M4	3.00	0.70	3	55	0.0200	5835	88	350
M5	4.00	0.80	3	55	0.0240	4375	63	315
M6	4.80	1.00	3	55	0.0240	3645	52	262
M8	6.40	1.25	3	55	0.0240	2735	39	197
M10	7.95	1.50	3	55	0.0320	2200	43	211
M12	9.95	1.75	4	55	0.0440	1760	53	310
M14	11.20	2.00	4	55	0.0440	1565	55	275
M16	12.80	2.00	4	55	0.0480	1370	53	263