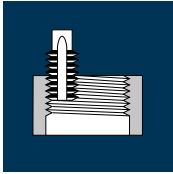


Application



Material

Steel
< 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Steel
1300 - 1500 N/mm²



Wrought aluminium alloys
Si < 6%
hardened



Cast iron
(lamellar / spheroidal)



Unalloyed copper



Stainless steel
[Cr-Ni/1.4301]



MF	D ₁ [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M8	6.40	1.00	3	90	0.0280	4475	75	376
M10	7.95	1.00	3	90	0.0400	3605	89	433
M10	7.95	1.25	3	90	0.0400	3605	89	433
M12	9.95	1.50	4	90	0.0480	2880	94	553
M14	11.20	1.50	4	90	0.0480	2560	98	492
M16	12.80	1.50	4	90	0.0480	2240	86	430
M20	14.95	1.50	4	90	0.0520	1915	101	398
M8	6.40	1.00	3	80	0.0280	3980	67	334
M10	7.95	1.00	3	80	0.0400	3205	79	385
M10	7.95	1.25	3	80	0.0400	3205	79	385
M12	9.95	1.50	4	80	0.0480	2560	84	492
M14	11.20	1.50	4	80	0.0480	2275	87	437
M16	12.80	1.50	4	80	0.0480	1990	76	382
M20	14.95	1.50	4	80	0.0520	1705	90	355
M8	6.40	1.00	3	60	0.0240	2985	43	215
M10	7.95	1.00	3	60	0.0320	2400	47	230
M10	7.95	1.25	3	60	0.0320	2400	47	230
M12	9.95	1.50	4	60	0.0440	1920	58	338
M14	11.20	1.50	4	60	0.0440	1705	60	300
M16	12.80	1.50	4	60	0.0480	1490	57	286
M20	14.95	1.50	4	60	0.0480	1275	62	245
M8	6.40	1.00	3	45	0.0240	2240	32	161
M10	7.95	1.00	3	45	0.0320	1800	35	173
M10	7.95	1.25	3	45	0.0320	1800	35	173
M12	9.95	1.50	4	45	0.0440	1440	43	253
M14	11.20	1.50	4	45	0.0440	1280	45	225
M16	12.80	1.50	4	45	0.0480	1120	43	215
M20	14.95	1.50	4	45	0.0480	960	47	184
M8	6.40	1.00	3	150	0.0400	7460	179	895
M10	7.95	1.00	3	150	0.0480	6005	177	865
M10	7.95	1.25	3	150	0.0480	6005	177	865
M12	9.95	1.50	4	150	0.0560	4800	184	1075
M14	11.20	1.50	4	150	0.0560	4265	191	955
M16	12.80	1.50	4	150	0.0640	3730	191	955
M20	14.95	1.50	4	150	0.0680	3195	219	869
M8	6.40	1.00	3	120	0.0320	5970	115	573
M10	7.95	1.00	3	120	0.0400	4805	118	577
M10	7.95	1.25	3	120	0.0400	4805	118	577
M12	9.95	1.50	4	120	0.0520	3840	136	799
M14	11.20	1.50	4	120	0.0520	3410	142	709
M16	12.80	1.50	4	120	0.0560	2985	134	669
M20	14.95	1.50	4	120	0.0640	2555	165	654
M8	6.40	1.00	3	130	0.0320	6465	124	621
M10	7.95	1.00	3	130	0.0400	5205	128	625
M10	7.95	1.25	3	130	0.0400	5205	128	625
M12	9.95	1.50	4	130	0.0520	4160	148	865
M14	11.20	1.50	4	130	0.0520	3695	154	769
M16	12.80	1.50	4	130	0.0560	3235	145	725
M20	14.95	1.50	4	130	0.0640	2770	179	709
M8	6.40	1.00	3	55	0.0240	2735	39	197
M10	7.95	1.00	3	55	0.0320	2200	43	211
M10	7.95	1.25	3	55	0.0320	2200	43	211
M12	9.95	1.50	4	55	0.0440	1760	53	310
M14	11.20	1.50	4	55	0.0440	1565	55	275
M16	12.80	1.50	4	55	0.0480	1370	53	263
M20	14.95	1.50	4	55	0.0520	1170	61	243