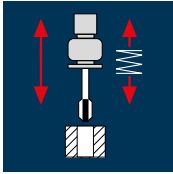


Application



Material

Stainless steel
ferritic/martensitic



Stainless steel
[Cr-Ni/1.4301]



Stainless steel
[Cr-Ni-Mo-.../1.4571]



Heat resistant steel
[17-4 PH]



G	d [mm]	P [mm]	v_c 1.5 x d			v_c 2.0 x d			v_c 3.0 x d		
			n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	v_c [min ⁻¹]	n [min ⁻¹]	v_f [100%]	
G 1/8	9.728	0.907	12	395	358	10	325	295	8	260	236
G 1/4	13.157	1.337	12	290	388	10	240	321	8	195	261
G 3/8	16.662	1.337	12	230	308	10	190	254	8	155	207
G 1/2	20.955	1.814	12	180	327	10	150	272	8	120	218
G 5/8	22.911	1.814	12	165	299	10	140	254	8	110	200
G 1/8	9.728	0.907	7	230	209	5	165	150	4	130	118
G 1/4	13.157	1.337	7	170	227	5	120	160	4	95	127
G 3/8	16.662	1.337	7	135	181	5	95	127	4	75	100
G 1/2	20.955	1.814	7	105	191	5	75	136	4	60	109
G 5/8	22.911	1.814	7	95	172	5	70	127	4	55	100
G 1/8	9.728	0.907	8	260	236	6	195	177	5	165	150
G 1/4	13.157	1.337	8	195	261	6	145	194	5	120	160
G 3/8	16.662	1.337	8	155	207	6	115	154	5	95	127
G 1/2	20.955	1.814	8	120	218	6	90	163	5	75	136
G 5/8	22.911	1.814	8	110	200	6	85	154	5	70	127
G 1/8	9.728	0.907	5	165	150	4	130	118	3	100	91
G 1/4	13.157	1.337	5	120	160	4	95	127	3	75	100
G 3/8	16.662	1.337	5	95	127	4	75	100	3	55	74
G 1/2	20.955	1.814	5	75	136	4	60	109	3	45	82
G 5/8	22.911	1.814	5	70	127	4	55	100	3	40	73