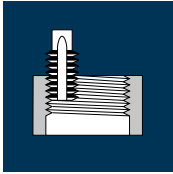


Application



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]



NPTF	D ₁ [mm]	P(TPI)	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
1/16	5.90	27.0	3	90	0.0240	4855	98	350
1/8	7.30	27.0	3	90	0.0360	3925	133	424
1/4	9.95	18.0	4	90	0.0440	2880	150	507
3/8	12.50	18.0	4	90	0.0480	2290	127	440
≥1/2	14.50	14.0	5	90	0.0520	1975	174	514
≥1	18.50	11.5	5	90	0.0560	1550	199	434
1/16	5.90	27.0	3	80	0.0240	4315	87	311
1/8	7.30	27.0	3	80	0.0360	3490	118	377
1/4	9.95	18.0	4	80	0.0440	2560	134	451
3/8	12.50	18.0	4	80	0.0480	2035	113	391
≥1/2	14.50	14.0	5	80	0.0520	1755	154	456
≥1	18.50	11.5	5	80	0.0560	1375	177	385
1/16	5.90	27.0	3	60	0.0240	3235	65	233
1/8	7.30	27.0	3	60	0.0280	2615	69	220
1/4	9.95	18.0	4	60	0.0400	1920	91	307
3/8	12.50	18.0	4	60	0.0480	1530	85	294
≥1/2	14.50	14.0	5	60	0.0520	1315	116	342
≥1	18.50	11.5	5	60	0.0560	1030	132	288
1/16	5.90	27.0	3	45	0.0240	2430	49	175
1/8	7.30	27.0	3	45	0.0280	1960	51	165
1/4	9.95	18.0	4	45	0.0400	1440	68	230
3/8	12.50	18.0	4	45	0.0480	1145	63	220
≥1/2	14.50	14.0	5	45	0.0520	990	87	257
≥1	18.50	11.5	5	45	0.0560	775	100	217
1/16	5.90	27.0	3	150	0.0360	8095	244	874
1/8	7.30	27.0	3	150	0.0440	6540	270	863
1/4	9.95	18.0	4	150	0.0520	4800	296	998
3/8	12.50	18.0	4	150	0.0640	3820	282	978
≥1/2	14.50	14.0	5	150	0.0680	3295	379	1120
≥1	18.50	11.5	5	150	0.0800	2580	473	1032
1/16	5.90	27.0	3	120	0.0280	6475	152	544
1/8	7.30	27.0	3	120	0.0360	5230	177	565
1/4	9.95	18.0	4	120	0.0480	3840	218	737
3/8	12.50	18.0	4	120	0.0560	3055	197	684
≥1/2	14.50	14.0	5	120	0.0640	2635	285	843
≥1	18.50	11.5	5	120	0.0800	2065	379	826
1/16	5.90	27.0	3	130	0.0280	7015	165	589
1/8	7.30	27.0	3	130	0.0360	5670	191	612
1/4	9.95	18.0	4	130	0.0480	4160	237	799
3/8	12.50	18.0	4	130	0.0560	3310	214	741
≥1/2	14.50	14.0	5	130	0.0640	2855	309	914
≥1	18.50	11.5	5	130	0.0800	2235	410	894
1/16	5.90	27.0	3	55	0.0240	2965	60	214
1/8	7.30	27.0	3	55	0.0280	2400	63	202
1/4	9.95	18.0	4	55	0.0400	1760	83	282
3/8	12.50	18.0	4	55	0.0480	1400	78	269
≥1/2	14.50	14.0	5	55	0.0520	1205	106	313
≥1	18.50	11.5	5	55	0.0560	945	121	265