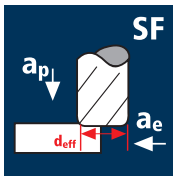


Application



Material

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

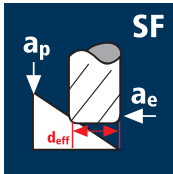
Hardened tool steel
> 60 HRC

d1 [mm]	z	v _c [m/min]	f _c [mm]	a _s [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	r [mm]
4.00	2	317	0.020	0.020	0.040	2.40	42045	1680	1.00
5.00	2	397	0.025	0.026	0.050	3.01	41985	2100	1.25
6.00	2	475	0.030	0.030	0.060	3.60	42000	2520	1.50
8.00	2	633	0.040	0.040	0.080	4.80	41975	3360	2.00
10.00	2	650	0.050	0.030	0.100	5.77	35860	3585	2.50
12.00	2	650	0.060	0.036	0.120	6.93	29855	3585	3.00

4.00	2	317	0.020	0.020	0.040	2.40	42045	1680	1.00
5.00	2	397	0.025	0.026	0.050	3.01	41985	2100	1.25
6.00	2	475	0.030	0.030	0.060	3.60	42000	2520	1.50
8.00	2	620	0.040	0.040	0.080	4.80	41115	3290	2.00
10.00	2	620	0.050	0.030	0.100	5.77	34205	3420	2.50
12.00	2	620	0.060	0.036	0.120	6.93	28480	3415	3.00

4.00	2	317	0.020	0.020	0.040	2.40	42045	1680	1.00
5.00	2	397	0.025	0.026	0.050	3.01	41985	2100	1.25
6.00	2	475	0.030	0.030	0.060	3.60	42000	2520	1.50
8.00	2	580	0.040	0.040	0.080	4.80	38460	3075	2.00
10.00	2	580	0.050	0.030	0.100	5.77	31995	3200	2.50
12.00	2	580	0.060	0.036	0.120	6.93	26640	3195	3.00

Application



Material

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

Hardened tool steel
> 60 HRC

d1 [mm]	z	v _c [m/min]	f _c [mm]	a _s [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
4.00	2	480	0.020	0.016	0.016	3.64	41975	1680	45°
5.00	2	600	0.025	0.020	0.020	4.55	41975	2100	45°
6.00	2	700	0.030	0.022	0.022	5.45	40885	2455	45°
8.00	2	700	0.040	0.024	0.024	7.23	30820	2465	45°
10.00	2	700	0.050	0.026	0.026	9.01	24730	2475	45°
12.00	2	700	0.060	0.032	0.032	10.82	20595	2470	45°

4.00	2	480	0.020	0.016	0.016	3.64	41975	1680	45°
5.00	2	600	0.025	0.020	0.020	4.55	41975	2100	45°
6.00	2	650	0.030	0.022	0.022	5.45	37965	2280	45°
8.00	2	650	0.040	0.024	0.024	7.23	28615	2290	45°
10.00	2	650	0.050	0.026	0.026	9.01	22965	2295	45°
12.00	2	650	0.060	0.032	0.032	10.82	19120	2295	45°

4.00	2	480	0.020	0.016	0.016	3.64	41975	1680	45°
5.00	2	600	0.025	0.020	0.020	4.55	41975	2100	45°
6.00	2	600	0.030	0.022	0.022	5.45	35045	2105	45°
8.00	2	600	0.040	0.024	0.024	7.23	26415	2115	45°
10.00	2	600	0.050	0.026	0.026	9.01	21195	2120	45°
12.00	2	600	0.060	0.032	0.032	10.82	17650	2120	45°