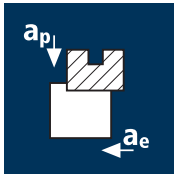


Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _r [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
32.00	6	65	0.060	6.400	24.000	645	235	35.8
40.00	8	65	0.080	8.000	30.000	515	330	79.5
50.00	8	65	0.100	10.000	37.500	415	330	124.1
63.00	10	65	0.120	12.600	47.250	330	395	234.6
80.00	10	65	0.120	16.000	60.000	260	310	297.9

Steel
850 - 1100 N/mm²



32.00	6	48	0.060	6.400	24.000	475	170	26.4
40.00	8	48	0.080	8.000	30.000	380	245	58.7
50.00	8	48	0.100	10.000	37.500	305	245	91.7
63.00	10	48	0.120	12.600	47.250	245	290	173.3
80.00	10	48	0.120	16.000	60.000	190	230	220.0

Steel
1100 - 1300 N/mm²

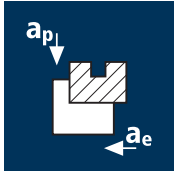


32.00	6	35	0.060	6.400	24.000	350	125	19.3
40.00	8	35	0.080	8.000	30.000	280	180	42.8
50.00	8	35	0.100	10.000	37.500	225	180	66.8
63.00	10	35	0.120	12.600	47.250	175	210	126.3
80.00	10	35	0.120	16.000	60.000	140	165	160.4

Stainless steel
[Cr-Ni/1.4301]



32.00	6	26	0.060	6.400	24.000	260	95	14.3
40.00	8	26	0.080	8.000	30.000	205	130	31.8
50.00	8	26	0.100	10.000	37.500	165	130	49.7
63.00	10	26	0.120	12.600	47.250	130	160	93.9
80.00	10	26	0.120	16.000	60.000	105	125	119.2



Steel
< 850 N/mm²



32.00	6	68	0.070	6.400	9.600	675	285	17.5
40.00	8	68	0.090	8.000	12.000	540	390	37.4
50.00	8	68	0.110	10.000	15.000	435	380	57.1
63.00	10	68	0.125	12.600	18.900	345	430	102.3
80.00	10	68	0.145	16.000	24.000	270	390	150.6

Steel
850 - 1100 N/mm²



32.00	6	55	0.070	6.400	9.600	545	230	14.1
40.00	8	55	0.090	8.000	12.000	440	315	30.3
50.00	8	55	0.110	10.000	15.000	350	310	46.2
63.00	10	55	0.125	12.600	18.900	280	345	82.7
80.00	10	55	0.145	16.000	24.000	220	315	121.8

Steel
1100 - 1300 N/mm²



32.00	6	40	0.070	6.400	9.600	400	165	10.3
40.00	8	40	0.090	8.000	12.000	320	230	22.0
50.00	8	40	0.110	10.000	15.000	255	225	33.6
63.00	10	40	0.125	12.600	18.900	200	255	60.2
80.00	10	40	0.145	16.000	24.000	160	230	88.6

Stainless steel
[Cr-Ni/1.4301]



32.00	6	29	0.070	6.400	9.600	290	120	7.4
40.00	8	29	0.090	8.000	12.000	230	165	16.0
50.00	8	29	0.110	10.000	15.000	185	160	24.4
63.00	10	29	0.125	12.600	18.900	145	185	43.6
80.00	10	29	0.145	16.000	24.000	115	165	64.2