

Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
P40 PVSR	roughing	▽ 100 200 300	-	-	-	-	-
	pre finishing	▽ 100 200 300	-	-	-	-	-
	finishing	-	-	-	-	-	-
K10 PVTi	roughing	-	-	▽ 150 175 200	-	-	-
	pre finishing	-	-	▽ 150 175 200	-	-	-
	finishing	-	-	▽ 150 200 250	-	-	-
M40 PVST	roughing	-	▽ 80 130 180	-	-	▽ 30 55 80	-
	pre finishing	-	▽ 100 155 210	-	-	▽ 40 65 90	-
	finishing	-	▽ 120 185 250	-	-	▽ 60 90 120	-

Extended operation data

Plunging	
Cutter diam. d1	X _{max}
40-125	4
160-250	-

Ramping		
Cutter diam. d1	α°	y
40	<11	29.5
50	<8	39.5
63	<6,5	52.5
80	<4	69.5
100	<3,5	89.5
125	<2,5	114.5
160	-	-
200	-	-
250	-	-

Helix		
Cutter diam. d1	D _{min}	D _{max}
40	89.5	93.5
50	109.5	113.5
63	135.5	139.5
80	169.5	173.5
100	209.5	213.5
125	259.5	263.5
160	-	-
200	-	-
250	-	-