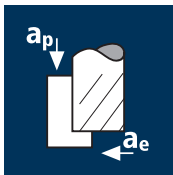


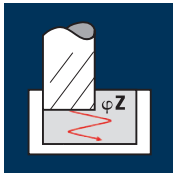
Application



Material

Steel
< 850 N/mm²

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	5	140	0.034	6.000	1.200	11140	1895	13.6	1°
5.00	5	140	0.042	7.500	1.500	8915	1870	21.1	1°
6.00	5	140	0.045	9.000	1.800	7425	1670	27.1	1°
8.00	5	140	0.060	12.000	2.400	5570	1670	48.1	1°
10.00	5	140	0.075	15.000	3.000	4455	1670	75.2	1°
12.00	5	140	0.084	18.000	3.600	3715	1560	101.1	1°
16.00	5	140	0.102	24.000	4.800	2785	1420	163.6	1°
20.00	5	140	0.115	30.000	6.000	2230	1280	230.6	1°



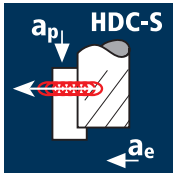
Steel
850 - 1100 N/mm²

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	5	130	0.032	6.000	1.200	10345	1655	11.9	1.5°
5.00	5	130	0.038	7.500	1.500	8275	1570	17.7	1.5°
6.00	5	130	0.038	9.000	1.800	6895	1310	21.2	1.5°
8.00	5	130	0.051	12.000	2.400	5175	1320	38.0	1.5°
10.00	5	130	0.064	15.000	3.000	4140	1325	59.6	1.5°
12.00	5	130	0.076	18.000	3.600	3450	1310	84.9	1.5°
16.00	5	130	0.093	24.000	4.800	2585	1205	138.5	1.5°
20.00	5	130	0.104	30.000	6.000	2070	1075	193.7	1.5°

Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	5	80	0.022	6.000	1.200	6365	700	5.0	1°
5.00	5	80	0.027	7.500	1.500	5095	690	7.7	1°
6.00	5	80	0.027	9.000	1.800	4245	575	9.3	1°
8.00	5	80	0.035	12.000	2.400	3185	555	16.0	1°
10.00	5	80	0.043	15.000	3.000	2545	545	24.6	1°
12.00	5	80	0.053	18.000	3.600	2120	560	36.4	1°
16.00	5	80	0.058	24.000	4.800	1590	460	53.2	1°
20.00	5	80	0.073	30.000	6.000	1275	465	83.7	1°

Application



Material

Steel
< 850 N/mm²

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
4.00	5	230	0.036	13.000	0.400	18305	3255	16.9
5.00	5	230	0.044	16.000	0.500	14640	3240	25.9
6.00	5	230	0.054	21.000	0.600	12200	3285	41.4
8.00	5	230	0.072	31.000	0.800	9150	3300	81.8
10.00	5	230	0.089	37.000	1.000	7320	3275	121.1
12.00	5	230	0.107	44.000	1.200	6100	3255	171.9
16.00	5	230	0.117	53.000	1.600	4575	2685	227.6
20.00	5	230	0.148	62.000	2.000	3660	2710	336.1

Steel
850 - 1100 N/mm²

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
4.00	5	185	0.036	13.000	0.400	14720	2620	13.6
5.00	5	185	0.044	16.000	0.500	11775	2605	20.8
6.00	5	185	0.054	21.000	0.600	9815	2645	33.3
8.00	5	185	0.072	31.000	0.800	7360	2655	65.8
10.00	5	185	0.089	37.000	1.000	5890	2635	97.4
12.00	5	185	0.107	44.000	1.200	4905	2620	138.3
16.00	5	185	0.117	53.000	1.600	3680	2160	183.1
20.00	5	185	0.148	62.000	2.000	2945	2180	270.3

Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
4.00	5	142	0.034	13.000	0.200	11300	1930	5.0
5.00	5	142	0.042	16.000	0.250	9040	1895	7.6
6.00	5	142	0.050	21.000	0.300	7535	1875	11.8
8.00	5	142	0.067	31.000	0.400	5650	1890	23.4
10.00	5	142	0.084	37.000	0.500	4520	1895	35.1
12.00	5	142	0.101	44.000	0.600	3765	1905	50.2
16.00	5	142	0.110	53.000	0.800	2825	1560	66.1
20.00	5	142	0.141	62.000	1.000	2260	1600	99.1

Suitable cutting data for other applications and materials can be found in the cutting data software **ToolExpert E-Cut**

