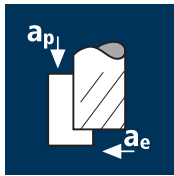


Application



Material

Steel
850 - 1100 N/mm²

X

d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [mm ² /min]
0.20	2	26	0.001	0.100	0.020	41380	116	0.3
0.30	2	40	0.002	0.150	0.030	42440	178	0.8
0.40	2	53	0.003	0.200	0.040	42175	236	1.9
0.50	2	66	0.004	0.350	0.100	42015	294	10.3
0.60	2	79	0.004	0.420	0.120	41910	352	17.8
0.80	2	106	0.006	0.560	0.160	42175	472	42.4
1.00	2	130	0.007	0.700	0.200	41380	579	81.1
1.50	2	130	0.011	1.500	0.450	27585	579	391.1
2.00	2	130	0.014	2.000	0.600	20690	579	695.2

Steel
1100 - 1300 N/mm²

X

0.20	2	26	0.001	0.100	0.020	41380	99	0.2
0.30	2	40	0.002	0.150	0.030	42440	153	0.7
0.40	2	53	0.002	0.200	0.040	42175	202	1.6
0.50	2	66	0.003	0.350	0.100	42015	252	8.8
0.60	2	79	0.004	0.420	0.120	41910	302	15.2
0.80	2	100	0.005	0.560	0.160	39790	382	34.3
1.00	2	100	0.006	0.700	0.200	31830	382	53.5
1.50	2	100	0.009	1.500	0.450	21220	382	257.9
2.00	2	100	0.012	2.000	0.600	15915	382	458.4

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

X

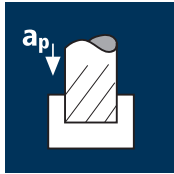
0.20	2	26	0.001	0.100	0.020	41380	83	0.2
0.30	2	40	0.002	0.150	0.030	42440	127	0.6
0.40	2	53	0.002	0.200	0.040	42175	169	1.4
0.50	2	66	0.003	0.350	0.100	42015	210	7.4
0.60	2	79	0.003	0.420	0.120	41910	252	12.7
0.80	2	80	0.004	0.560	0.160	31830	255	22.8
1.00	2	80	0.005	0.700	0.200	25465	255	35.7
1.50	2	80	0.008	1.500	0.450	16975	255	171.9
2.00	2	80	0.010	2.000	0.600	12730	255	305.5

Titanium alloys
> 300 HB
[Ti6Al4V]

X

0.20	2	26	0.001	0.100	0.020	41380	83	0.2
0.30	2	40	0.002	0.150	0.030	42440	127	0.6
0.40	2	50	0.002	0.200	0.040	39790	159	1.3
0.50	2	50	0.003	0.350	0.100	31830	159	5.6
0.60	2	50	0.003	0.420	0.120	26525	159	8.0
0.80	2	50	0.004	0.560	0.160	19895	159	14.3
1.00	2	50	0.005	0.700	0.200	15915	159	22.3
1.50	2	50	0.008	1.500	0.450	10610	159	107.5
2.00	2	50	0.010	2.000	0.600	7960	159	191.1

Application



Material

Steel
850 - 1100 N/mm²

X

d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [mm ² /min]
0.20	2	26	0.001	0.050	0.200	41380	93	1.0
0.30	2	40	0.002	0.075	0.300	42440	143	3.2
0.40	2	53	0.002	0.100	0.400	42175	186	7.4
0.50	2	66	0.003	0.250	0.500	42015	235	29.4
0.60	2	79	0.003	0.300	0.600	41910	282	50.7
0.80	2	106	0.004	0.400	0.800	42175	378	121.0
1.00	2	117	0.006	0.500	1.000	37240	417	208.6
1.50	2	117	0.008	0.750	1.500	24830	417	469.3
2.00	2	117	0.011	1.000	2.000	18620	417	834.2

Steel
1100 - 1300 N/mm²

X

0.20	2	26	0.001	0.050	0.200	41380	79	0.8
0.30	2	40	0.001	0.075	0.300	42440	122	2.8
0.40	2	53	0.002	0.100	0.400	42175	160	6.4
0.50	2	66	0.002	0.250	0.500	42015	202	25.2
0.60	2	79	0.003	0.300	0.600	41910	241	43.5
0.80	2	90	0.004	0.400	0.800	35810	275	88.0
1.00	2	90	0.005	0.500	1.000	28650	275	137.5
1.50	2	90	0.007	0.750	1.500	19100	275	309.4
2.00	2	90	0.010	1.000	2.000	14325	275	550.0

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

X

0.20	2	26	0.001	0.050	0.200	41380	66	0.7
0.30	2	40	0.001	0.075	0.300	42440	102	2.3
0.40	2	53	0.002	0.100	0.400	42175	135	5.4
0.50	2	66	0.002	0.250	0.500	42015	168	21.0
0.60	2	72	0.002	0.300	0.600	38195	183	33.0
0.80	2	72	0.003	0.400	0.800	28650	183	58.7
1.00	2	72	0.004	0.500	1.000	22920	183	91.7
1.50	2	72	0.006	0.750	1.500	15280	183	206.4
2.00	2	72	0.008	1.000	2.000	11460	183	366.8

Titanium alloys
> 300 HB
[Ti6Al4V]

X

0.20	2	26	0.001	0.050	0.200	41380	66	0.7
0.30	2	40	0.001	0.075	0.300	42440	102	2.3
0.40	2	45	0.002	0.100	0.400	35810	115	4.6
0.50	2	45	0.002	0.250	0.500	28650	115	14.4
0.60	2	45	0.002	0.300	0.600	23875	115	20.7
0.80	2	45	0.003	0.400	0.800	17905	115	36.7
1.00	2	45	0.004	0.500	1.000	14325	115	57.3
1.50	2	45	0.006	0.750	1.500	9550	115	129.0
2.00	2	45	0.008	1.000	2.000	7160	115	229.2