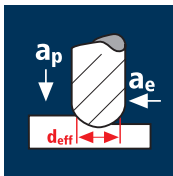




## Application



## Material

Hardened tool steel  
52 - 56 HRC

**Y**

Hardened tool steel  
56 - 60 HRC

**Y**

Hardened tool steel  
> 60 HRC

**Y**

High speed steel,  
hardened  
64 - 70 HRC

**Y**

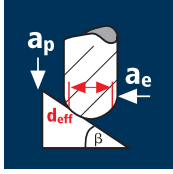
d1 [mm]	z	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$d_{eff}$ [mm]	n [min <sup>-1</sup> ]	$v_t$ [mm/min]	Q [mm <sup>3</sup> /min]
0.40	2	26	0.010	0.026	0.080	0.20	41380	830	1.7
0.50	2	32	0.013	0.032	0.100	0.24	42440	1105	3.5
0.60	2	40	0.015	0.039	0.120	0.30	42440	1275	6.0
0.80	2	51	0.020	0.052	0.160	0.39	41625	1665	13.9
1.00	2	65	0.025	0.064	0.200	0.49	42225	2110	27.0

0.40	2	26	0.009	0.026	0.080	0.20	41380	745	1.5
0.50	2	32	0.012	0.032	0.100	0.24	42440	995	3.2
0.60	2	40	0.014	0.039	0.120	0.30	42440	1145	5.4
0.80	2	51	0.018	0.052	0.160	0.39	41625	1500	12.5
1.00	2	60	0.023	0.064	0.200	0.49	38975	1755	22.5

0.40	2	24	0.007	0.021	0.080	0.18	42440	610	1.0
0.50	2	29	0.009	0.026	0.100	0.22	41960	785	2.0
0.60	2	36	0.011	0.031	0.120	0.27	42440	915	3.4
0.80	2	48	0.014	0.042	0.160	0.36	42440	1220	8.1
1.00	2	50	0.018	0.051	0.200	0.44	36170	1300	13.3

0.40	2	21	0.006	0.017	0.080	0.16	41780	480	0.6
0.50	2	26	0.007	0.020	0.100	0.20	41380	620	1.3
0.60	2	32	0.009	0.025	0.120	0.24	42440	735	2.2
0.80	2	40	0.012	0.033	0.160	0.32	39790	915	4.9
1.00	2	40	0.014	0.041	0.200	0.40	31830	915	7.5

## Application



## Material

Hardened tool steel  
52 - 56 HRC

**Y**

Hardened tool steel  
56 - 60 HRC

**Y**

Hardened tool steel  
> 60 HRC

**Y**

High speed steel,  
hardened  
64 - 70 HRC

**Y**

d1 [mm]	z	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$d_{eff}$ [mm]	n [min <sup>-1</sup> ]	$v_t$ [mm/min]	$\beta$ [°]
0.40	2	49	0.012	0.016	0.016	0.37	42155	1010	45°
0.50	2	62	0.018	0.022	0.022	0.47	41990	1510	45°
0.60	2	74	0.018	0.026	0.026	0.56	42060	1515	45°
0.80	2	99	0.020	0.034	0.034	0.75	42015	1680	45°
1.00	2	123	0.026	0.042	0.042	0.93	42100	2190	45°

0.40	2	49	0.012	0.016	0.016	0.37	42155	1010	45°
0.50	2	62	0.016	0.022	0.022	0.47	41990	1345	45°
0.60	2	74	0.016	0.026	0.026	0.56	42060	1345	45°
0.80	2	99	0.018	0.034	0.034	0.75	42015	1515	45°
1.00	2	123	0.022	0.042	0.042	0.93	42100	1850	45°

0.40	2	48	0.010	0.010	0.010	0.36	42440	850	45°
0.50	2	61	0.015	0.020	0.020	0.46	42210	1265	45°
0.60	2	73	0.015	0.020	0.020	0.55	42250	1265	45°
0.80	2	98	0.015	0.030	0.030	0.74	42155	1265	45°
1.00	2	120	0.020	0.040	0.040	0.93	41070	1645	45°

0.40	2	48	0.010	0.010	0.010	0.36	42440	850	45°
0.50	2	61	0.010	0.020	0.020	0.46	42210	845	45°
0.60	2	73	0.010	0.020	0.020	0.55	42250	845	45°
0.80	2	85	0.010	0.020	0.030	0.71	38110	760	45°
1.00	2	85	0.015	0.030	0.040	0.91	29730	890	45°