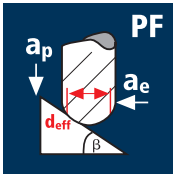


Application



Material

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



| d1 [mm] | z | v _c [m/min] | f _t [mm] | a _s [mm] | a _e [mm] | d _{eff} [mm] | n [min ⁻¹] | v _r [mm/min] | β [°] |
|---------|---|------------------------|---------------------|---------------------|---------------------|-----------------------|------------------------|-------------------------|-------|
| 1.00 | 2 | 100 | 0.030 | 0.110 | 0.110 | 0.99 | 32155 | 1930 | 45° |
| 2.00 | 2 | 100 | 0.055 | 0.220 | 0.220 | 1.99 | 15995 | 1760 | 45° |
| 3.00 | 2 | 100 | 0.060 | 0.330 | 0.330 | 2.98 | 10680 | 1280 | 45° |
| 4.00 | 2 | 100 | 0.070 | 0.440 | 0.440 | 3.98 | 8000 | 1120 | 45° |
| 5.00 | 2 | 100 | 0.080 | 0.550 | 0.550 | 4.97 | 6405 | 1025 | 45° |
| 6.00 | 2 | 100 | 0.085 | 0.660 | 0.660 | 5.96 | 5340 | 910 | 45° |
| 8.00 | 2 | 100 | 0.100 | 0.880 | 0.880 | 7.95 | 4005 | 800 | 45° |
| 10.00 | 2 | 100 | 0.115 | 1.100 | 1.100 | 9.94 | 3200 | 735 | 45° |
| 12.00 | 2 | 100 | 0.120 | 1.320 | 1.320 | 11.93 | 2670 | 640 | 45° |

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex steel
[17-4 PH]



| | | | | | | | | | |
|-------|---|----|-------|-------|-------|-------|-------|------|-----|
| 1.00 | 2 | 90 | 0.028 | 0.110 | 0.110 | 0.99 | 28935 | 1620 | 45° |
| 2.00 | 2 | 90 | 0.050 | 0.220 | 0.220 | 1.99 | 14395 | 1440 | 45° |
| 3.00 | 2 | 90 | 0.054 | 0.330 | 0.330 | 2.98 | 9615 | 1040 | 45° |
| 4.00 | 2 | 90 | 0.064 | 0.440 | 0.440 | 3.98 | 7200 | 920 | 45° |
| 5.00 | 2 | 90 | 0.072 | 0.550 | 0.550 | 4.97 | 5765 | 830 | 45° |
| 6.00 | 2 | 90 | 0.076 | 0.660 | 0.660 | 5.96 | 4805 | 730 | 45° |
| 8.00 | 2 | 90 | 0.090 | 0.880 | 0.880 | 7.95 | 3605 | 650 | 45° |
| 10.00 | 2 | 90 | 0.104 | 1.100 | 1.100 | 9.94 | 2880 | 600 | 45° |
| 12.00 | 2 | 90 | 0.108 | 1.320 | 1.320 | 11.93 | 2400 | 520 | 45° |

Inox difficile
[Cr-Ni-Mo+/1.4529]
Heat resistant steel
[1.4841]

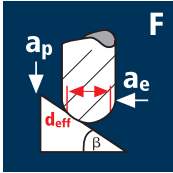


| | | | | | | | | | |
|-------|---|----|-------|-------|-------|-------|-------|-----|-----|
| 1.00 | 2 | 60 | 0.025 | 0.110 | 0.110 | 0.99 | 19290 | 965 | 45° |
| 2.00 | 2 | 60 | 0.045 | 0.220 | 0.220 | 1.99 | 9595 | 865 | 45° |
| 3.00 | 2 | 60 | 0.050 | 0.330 | 0.330 | 2.98 | 6410 | 640 | 45° |
| 4.00 | 2 | 60 | 0.060 | 0.440 | 0.440 | 3.98 | 4800 | 575 | 45° |
| 5.00 | 2 | 60 | 0.070 | 0.550 | 0.550 | 4.97 | 3845 | 540 | 45° |
| 6.00 | 2 | 60 | 0.070 | 0.660 | 0.660 | 5.96 | 3205 | 450 | 45° |
| 8.00 | 2 | 60 | 0.085 | 0.880 | 0.880 | 7.95 | 2400 | 410 | 45° |
| 10.00 | 2 | 60 | 0.100 | 1.100 | 1.100 | 9.94 | 1920 | 385 | 45° |
| 12.00 | 2 | 60 | 0.100 | 1.320 | 1.320 | 11.93 | 1600 | 320 | 45° |

Steel
< 850 N/mm²



| | | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|-----|
| 1.00 | 2 | 132 | 0.040 | 0.120 | 0.120 | 1.00 | 42015 | 3360 | 45° |
| 2.00 | 2 | 240 | 0.070 | 0.240 | 0.240 | 1.99 | 38390 | 5375 | 45° |
| 3.00 | 2 | 240 | 0.075 | 0.360 | 0.360 | 2.99 | 25550 | 3830 | 45° |
| 4.00 | 2 | 240 | 0.090 | 0.480 | 0.480 | 3.99 | 19145 | 3445 | 45° |
| 5.00 | 2 | 240 | 0.100 | 0.600 | 0.600 | 4.98 | 15340 | 3070 | 45° |
| 6.00 | 2 | 240 | 0.105 | 0.720 | 0.720 | 5.98 | 12775 | 2685 | 45° |
| 8.00 | 2 | 240 | 0.125 | 0.960 | 0.960 | 7.98 | 9575 | 2395 | 45° |
| 10.00 | 2 | 240 | 0.145 | 1.200 | 1.200 | 9.97 | 7660 | 2220 | 45° |
| 12.00 | 2 | 240 | 0.150 | 1.440 | 1.440 | 11.96 | 6385 | 1915 | 45° |



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



| | | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|-----|
| 1.00 | 2 | 124 | 0.025 | 0.050 | 0.050 | 0.94 | 41990 | 2100 | 45° |
| 2.00 | 2 | 140 | 0.030 | 0.070 | 0.070 | 1.84 | 24220 | 1455 | 45° |
| 3.00 | 2 | 140 | 0.035 | 0.090 | 0.090 | 2.72 | 16385 | 1145 | 45° |
| 4.00 | 2 | 140 | 0.055 | 0.110 | 0.110 | 3.60 | 12380 | 1360 | 45° |
| 5.00 | 2 | 140 | 0.060 | 0.130 | 0.130 | 4.48 | 9945 | 1195 | 45° |
| 6.00 | 2 | 140 | 0.065 | 0.150 | 0.150 | 5.36 | 8315 | 1080 | 45° |
| 8.00 | 2 | 140 | 0.075 | 0.170 | 0.170 | 7.05 | 6320 | 950 | 45° |
| 10.00 | 2 | 140 | 0.080 | 0.200 | 0.200 | 8.77 | 5080 | 815 | 45° |
| 12.00 | 2 | 140 | 0.085 | 0.250 | 0.250 | 10.56 | 4220 | 715 | 45° |

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex steel
[17-4 PH]



| | | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|-----|
| 1.00 | 2 | 124 | 0.022 | 0.050 | 0.050 | 0.94 | 41990 | 1850 | 45° |
| 2.00 | 2 | 125 | 0.028 | 0.070 | 0.070 | 1.84 | 21625 | 1210 | 45° |
| 3.00 | 2 | 125 | 0.032 | 0.090 | 0.090 | 2.72 | 14630 | 935 | 45° |
| 4.00 | 2 | 125 | 0.050 | 0.110 | 0.110 | 3.60 | 11050 | 1105 | 45° |
| 5.00 | 2 | 125 | 0.054 | 0.130 | 0.130 | 4.48 | 8880 | 960 | 45° |
| 6.00 | 2 | 125 | 0.058 | 0.150 | 0.150 | 5.36 | 7425 | 860 | 45° |
| 8.00 | 2 | 125 | 0.068 | 0.170 | 0.170 | 7.05 | 5645 | 770 | 45° |
| 10.00 | 2 | 125 | 0.072 | 0.200 | 0.200 | 8.77 | 4535 | 655 | 45° |
| 12.00 | 2 | 125 | 0.076 | 0.250 | 0.250 | 10.56 | 3770 | 575 | 45° |

Inox difficile
[Cr-Ni-Mo+/1.4529]
Heat resistant steel
[1.4841]



| | | | | | | | | | |
|-------|---|----|-------|-------|-------|-------|-------|------|-----|
| 1.00 | 2 | 70 | 0.025 | 0.050 | 0.050 | 0.94 | 23705 | 1185 | 45° |
| 2.00 | 2 | 70 | 0.025 | 0.070 | 0.070 | 1.84 | 12110 | 605 | 45° |
| 3.00 | 2 | 70 | 0.030 | 0.090 | 0.090 | 2.72 | 8190 | 490 | 45° |
| 4.00 | 2 | 70 | 0.050 | 0.110 | 0.110 | 3.60 | 6190 | 620 | 45° |
| 5.00 | 2 | 70 | 0.055 | 0.130 | 0.130 | 4.48 | 4975 | 545 | 45° |
| 6.00 | 2 | 70 | 0.060 | 0.150 | 0.150 | 5.36 | 4155 | 500 | 45° |
| 8.00 | 2 | 70 | 0.070 | 0.170 | 0.170 | 7.05 | 3160 | 440 | 45° |
| 10.00 | 2 | 70 | 0.070 | 0.200 | 0.200 | 8.77 | 2540 | 355 | 45° |
| 12.00 | 2 | 70 | 0.075 | 0.250 | 0.250 | 10.56 | 2110 | 315 | 45° |

Steel
< 850 N/mm²



| | | | | | | | | | |
|-------|---|-----|-------|-------|-------|-------|-------|------|-----|
| 1.00 | 2 | 124 | 0.030 | 0.050 | 0.050 | 0.94 | 41990 | 2520 | 45° |
| 2.00 | 2 | 243 | 0.035 | 0.070 | 0.070 | 1.84 | 42040 | 2945 | 45° |
| 3.00 | 2 | 359 | 0.040 | 0.090 | 0.090 | 2.72 | 42010 | 3360 | 45° |
| 4.00 | 2 | 360 | 0.065 | 0.110 | 0.110 | 3.60 | 31830 | 4140 | 45° |
| 5.00 | 2 | 360 | 0.070 | 0.130 | 0.130 | 4.48 | 25580 | 3580 | 45° |
| 6.00 | 2 | 360 | 0.080 | 0.150 | 0.150 | 5.36 | 21380 | 3420 | 45° |
| 8.00 | 2 | 360 | 0.090 | 0.170 | 0.170 | 7.05 | 16255 | 2925 | 45° |
| 10.00 | 2 | 360 | 0.095 | 0.200 | 0.200 | 8.77 | 13065 | 2485 | 45° |
| 12.00 | 2 | 360 | 0.100 | 0.250 | 0.250 | 10.56 | 10850 | 2170 | 45° |