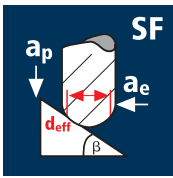




## Application



## Material

Hardened tool steel  
52 - 56 HRC



Hardened tool steel  
56 - 60 HRC



Hardened tool steel  
> 60 HRC



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>t</sub> [mm]	a <sub>s</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>t</sub> [mm/min]	β [°]
4.00	2	488	0.020	0.018	0.018	3.70	41980	1680	60°
5.00	2	608	0.025	0.020	0.020	4.61	41980	2100	60°
6.00	2	700	0.030	0.022	0.022	5.52	40365	2420	60°
8.00	2	700	0.040	0.026	0.026	7.34	30355	2430	60°
10.00	2	700	0.040	0.028	0.028	9.14	24380	1950	60°
12.00	2	700	0.050	0.032	0.032	10.96	20330	2035	60°
4.00	2	488	0.020	0.018	0.018	3.70	41980	1680	60°
5.00	2	608	0.025	0.020	0.020	4.61	41980	2100	60°
6.00	2	650	0.025	0.022	0.022	5.52	37480	1875	60°
8.00	2	650	0.035	0.026	0.026	7.34	28190	1975	60°
10.00	2	650	0.035	0.028	0.028	9.14	22635	1585	60°
12.00	2	650	0.045	0.032	0.032	10.96	18880	1700	60°
4.00	2	488	0.015	0.018	0.018	3.70	41980	1260	60°
5.00	2	600	0.020	0.020	0.020	4.61	41430	1655	60°
6.00	2	600	0.025	0.022	0.022	5.52	34600	1730	60°
8.00	2	600	0.030	0.026	0.026	7.34	26020	1560	60°
10.00	2	600	0.030	0.028	0.028	9.14	20895	1255	60°
12.00	2	600	0.040	0.032	0.032	10.96	17425	1395	60°