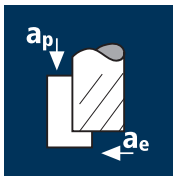


Application

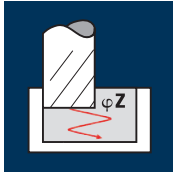


Material

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]	φZ [°]
6.00	5	135	0.034	12.000	1.500	7160	1220	21.9	10°
8.00	5	135	0.043	16.000	2.000	5370	1155	37.0	12°
10.00	5	135	0.055	20.000	2.500	4295	1180	59.1	12°
12.00	5	135	0.064	24.000	3.000	3580	1145	82.5	12°
16.00	5	135	0.072	25.600	4.000	2685	965	99.0	12°
20.00	5	135	0.085	32.000	5.000	2150	915	146.1	12°



Steel
1100 - 1300 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]	φZ [°]
6.00	5	105	0.030	12.000	1.500	5570	835	15.0	10°
8.00	5	105	0.038	16.000	2.000	4180	795	25.4	12°
10.00	5	105	0.047	20.000	2.500	3340	785	39.3	12°
12.00	5	105	0.055	24.000	3.000	2785	765	55.1	12°
16.00	5	105	0.064	25.600	4.000	2090	670	68.4	12°
20.00	5	105	0.077	32.000	5.000	1670	645	102.9	12°

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]	φZ [°]
6.00	5	80	0.026	12.000	1.500	4245	550	9.9	8°
8.00	5	80	0.030	16.000	2.000	3185	475	15.3	8°
10.00	5	80	0.038	20.000	2.500	2545	485	24.2	8°
12.00	5	80	0.047	24.000	3.000	2120	500	35.9	8°
16.00	5	80	0.055	25.600	4.000	1590	440	44.8	8°
20.00	5	80	0.068	32.000	5.000	1275	435	69.3	8°

Application

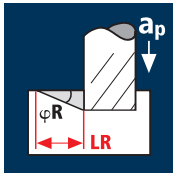


Material

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]	φR [°]	LR [mm]
6.00	5	110	0.020	6.000	6.000	5835	585	21.0	10°	34.0
8.00	5	110	0.026	8.000	8.000	4375	570	36.4	10°	45.4
10.00	5	110	0.033	10.000	10.000	3500	580	57.8	10°	56.7
12.00	5	110	0.038	12.000	12.000	2920	555	79.8	10°	68.1
16.00	5	110	0.043	16.000	16.000	2190	470	120.4	10°	90.7
20.00	5	110	0.051	20.000	20.000	1750	445	178.6	10°	113.4



Steel
1100 - 1300 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]	φR [°]	LR [mm]
6.00	5	85	0.018	6.000	6.000	4510	405	14.6	10°	34.0
8.00	5	85	0.023	8.000	8.000	3380	390	24.9	10°	45.4
10.00	5	85	0.028	10.000	10.000	2705	380	37.9	10°	56.7
12.00	5	85	0.033	12.000	12.000	2255	370	53.6	10°	68.1
16.00	5	85	0.038	16.000	16.000	1690	320	82.3	10°	90.7
20.00	5	85	0.046	20.000	20.000	1355	310	124.5	10°	113.4

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]	φR [°]	LR [mm]
6.00	5	65	0.016	6.000	6.000	3450	275	9.9	10°	34.0
8.00	5	65	0.018	8.000	8.000	2585	235	14.9	10°	45.4
10.00	5	65	0.023	10.000	10.000	2070	240	23.8	10°	56.7
12.00	5	65	0.028	12.000	12.000	1725	240	34.8	10°	68.1
16.00	5	65	0.033	16.000	16.000	1295	215	54.6	10°	90.7
20.00	5	65	0.041	20.000	20.000	1035	210	84.8	10°	113.4

This way to the cutting data software
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