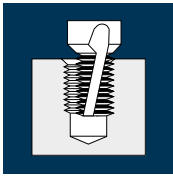




## Application



## Material

Steel  
850 - 1100 N/mm<sup>2</sup>



Steel  
850 - 1100 N/mm<sup>2</sup>



Steel  
1300 - 1500 N/mm<sup>2</sup>



Steel  
1300 - 1500 N/mm<sup>2</sup>



Wrought aluminium alloys  
Si < 6%  
hardened



Wrought aluminium alloys  
Si < 6%  
hardened



Cast iron  
(lamellar / spheroidal)



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MF	D <sub>1</sub> [mm]	P [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	L <sub>K</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>fc</sub> [mm/min]	v <sub>f</sub> [mm/min]
M4	3.00	0.50	3	80	0.0075	7.9	8490	48	191
M5	4.00	0.50	3	80	0.0100	9.4	6365	38	191
M6	4.80	0.50	3	80	0.0120	10.6	5305	38	191
M6	4.80	0.75	3	80	0.0120	10.8	5305	38	191
M8	6.40	0.75	3	80	0.0160	14.1	3980	38	191
M8	6.40	1.00	3	80	0.0160	14.5	3980	38	191
M10	7.95	1.00	4	80	0.0200	17.8	3205	53	256
M10	7.95	1.25	4	80	0.0200	18.2	3205	53	256
M12	9.95	1.00	4	80	0.0250	20.8	2560	44	256
M12	9.95	1.50	4	80	0.0250	21.6	2560	44	256
M14	11.20	1.50	4	80	0.0280	25.1	2275	51	255
M16	12.80	1.50	4	80	0.0320	28.3	1990	51	255
M4	3.00	0.50	3	50	0.0065	7.9	5305	26	103
M5	4.00	0.50	3	50	0.0090	9.4	3980	22	108
M6	4.80	0.50	3	50	0.0105	10.6	3315	21	104
M6	4.80	0.75	3	50	0.0105	10.8	3315	21	104
M8	6.40	0.75	3	50	0.0140	14.1	2485	21	104
M8	6.40	1.00	3	50	0.0140	14.5	2485	21	104
M10	7.95	1.00	4	50	0.0175	17.8	2000	29	140
M10	7.95	1.25	4	50	0.0175	18.2	2000	29	140
M12	9.95	1.00	4	50	0.0220	20.8	1600	24	141
M12	9.95	1.50	4	50	0.0220	21.6	1600	24	141
M14	11.20	1.50	4	50	0.0250	25.1	1420	28	142
M16	12.80	1.50	4	50	0.0285	28.3	1245	28	142
M4	3.00	0.50	3	150	0.0105	7.9	15915	125	501
M5	4.00	0.50	3	150	0.0140	9.4	11935	100	501
M6	4.80	0.50	3	150	0.0170	10.6	9945	101	507
M6	4.80	0.75	3	150	0.0170	10.8	9945	101	507
M8	6.40	0.75	3	150	0.0225	14.1	7460	101	504
M8	6.40	1.00	3	150	0.0225	14.5	7460	101	504
M10	7.95	1.00	4	150	0.0280	17.8	6005	138	673
M10	7.95	1.25	4	150	0.0280	18.2	6005	138	673
M12	9.95	1.00	4	150	0.0350	20.8	4800	115	672
M12	9.95	1.50	4	150	0.0350	21.6	4800	115	672
M14	11.20	1.50	4	150	0.0395	25.1	4265	135	674
M16	12.80	1.50	4	150	0.0450	28.3	3730	134	671
M4	3.00	0.50	3	120	0.0075	7.9	12730	72	286
M5	4.00	0.50	3	120	0.0100	9.4	9550	57	287
M6	4.80	0.50	3	120	0.0120	10.6	7960	57	287
M6	4.80	0.75	3	120	0.0120	10.8	7960	57	287
M8	6.40	0.75	3	120	0.0160	14.1	5970	57	287
M8	6.40	1.00	3	120	0.0160	14.5	5970	57	287
M10	7.95	1.00	4	120	0.0200	17.8	4805	79	384
M10	7.95	1.25	4	120	0.0200	18.2	4805	79	384
M12	9.95	1.00	4	120	0.0250	20.8	3840	66	384
M12	9.95	1.50	4	120	0.0250	21.6	3840	66	384
M14	11.20	1.50	4	120	0.0280	25.1	3410	76	382
M16	12.80	1.50	4	120	0.0320	28.3	2985	76	382