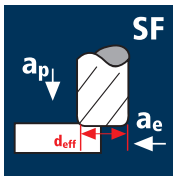


Application



Material

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

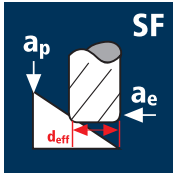
Hardened tool steel
> 60 HRC

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _s [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	r [mm]
4.00	2	433	0.020	0.020	0.040	3.28	42020	1680	0.50
5.00	2	570	0.025	0.026	0.050	4.32	42000	2100	0.50
6.00	2	650	0.030	0.030	0.060	5.34	38745	2325	0.50
8.00	2	650	0.040	0.040	0.080	7.39	27955	2240	0.50
10.00	2	650	0.050	0.030	0.100	9.34	22150	2215	0.50
12.00	2	650	0.060	0.036	0.120	11.37	18195	2185	0.50

4.00	2	433	0.020	0.020	0.040	3.28	42020	1680	0.50
5.00	2	570	0.025	0.026	0.050	4.32	42000	2100	0.50
6.00	2	620	0.030	0.030	0.060	5.34	36955	2215	0.50
8.00	2	620	0.040	0.040	0.080	7.39	26705	2135	0.50
10.00	2	620	0.050	0.030	0.100	9.34	21130	2115	0.50
12.00	2	620	0.060	0.036	0.120	11.37	17355	2085	0.50

4.00	2	433	0.020	0.020	0.040	3.28	42020	1680	0.50
5.00	2	570	0.025	0.026	0.050	4.32	42000	2100	0.50
6.00	2	580	0.030	0.030	0.060	5.34	34575	2075	0.50
8.00	2	580	0.040	0.040	0.080	7.39	24980	2000	0.50
10.00	2	580	0.050	0.030	0.100	9.34	19765	1975	0.50
12.00	2	580	0.060	0.036	0.120	11.37	16235	1950	0.50

Application



Material

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

Hardened tool steel
> 60 HRC

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _s [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
4.00	2	509	0.020	0.016	0.016	3.86	41975	1680	45°
5.00	2	644	0.025	0.020	0.020	4.88	42005	2100	45°
6.00	2	700	0.030	0.022	0.022	5.88	37895	2275	45°
8.00	2	700	0.040	0.024	0.024	7.89	28240	2260	45°
10.00	2	700	0.050	0.026	0.026	9.90	22505	2250	45°
12.00	2	700	0.060	0.032	0.032	11.91	18710	2245	45°

4.00	2	509	0.020	0.016	0.016	3.86	41975	1680	45°
5.00	2	644	0.025	0.020	0.020	4.88	42005	2100	45°
6.00	2	650	0.030	0.022	0.022	5.88	35185	2110	45°
8.00	2	650	0.040	0.024	0.024	7.89	26225	2100	45°
10.00	2	650	0.050	0.026	0.026	9.90	20900	2090	45°
12.00	2	650	0.060	0.032	0.032	11.91	17370	2085	45°

4.00	2	509	0.020	0.016	0.016	3.86	41975	1680	45°
5.00	2	600	0.025	0.020	0.020	4.88	39135	1955	45°
6.00	2	600	0.030	0.022	0.022	5.88	32480	1950	45°
8.00	2	600	0.040	0.024	0.024	7.89	24205	1935	45°
10.00	2	600	0.050	0.026	0.026	9.90	19290	1930	45°
12.00	2	600	0.060	0.032	0.032	11.91	16035	1925	45°