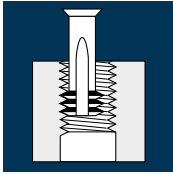


Application



Material

Steel
850 - 1100 N/mm²



M	D ₁ [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M1	0.70	0.25	3	120	0.0020	54565	98	327
M2	1.50	0.40	3	120	0.0040	25465	76	306
M3	2.20	0.50	3	120	0.0055	17360	76	286
M4	3.10	0.70	3	120	0.0080	12320	67	296
M5	3.80	0.80	3	120	0.0095	10050	69	286
M6	4.70	1.00	3	120	0.0120	8125	63	293
M8	5.90	1.25	5	120	0.0150	6475	127	486
M10	7.90	1.50	5	120	0.0200	4835	102	484

Steel
1300 - 1500 N/mm²



M1	0.70	0.25	3	100	0.0010	45475	41	136
M2	1.50	0.40	3	100	0.0025	21220	40	159
M3	2.20	0.50	3	100	0.0035	14470	41	152
M4	3.10	0.70	3	100	0.0050	10270	35	154
M5	3.80	0.80	3	100	0.0065	8375	39	163
M6	4.70	1.00	3	100	0.0080	6775	35	163
M8	5.90	1.25	5	100	0.0100	5395	71	270
M10	7.90	1.50	5	100	0.0130	4030	55	262

Stainless steel
[Cr-Ni/1.4301]



M1	0.70	0.25	3	80	0.0010	36380	33	109
M2	1.50	0.40	3	80	0.0025	16975	32	127
M3	2.20	0.50	3	80	0.0035	11575	32	122
M4	3.10	0.70	3	80	0.0050	8215	28	123
M5	3.80	0.80	3	80	0.0060	6700	29	121
M6	4.70	1.00	3	80	0.0070	5420	25	114
M8	5.90	1.25	5	80	0.0090	4315	51	194
M10	7.90	1.50	5	80	0.0120	3225	41	194

Nickel base alloys



M1	0.70	0.25	3	60	0.0010	27285	25	82
M2	1.50	0.40	3	60	0.0025	12730	24	96
M3	2.20	0.50	3	60	0.0035	8680	24	91
M4	3.10	0.70	3	60	0.0050	6160	21	92
M5	3.80	0.80	3	60	0.0060	5025	22	91
M6	4.70	1.00	3	60	0.0070	4065	19	85
M8	5.90	1.25	5	60	0.0090	3235	38	146
M10	7.90	1.50	5	60	0.0120	2420	30	145

Wrought aluminium
alloys Si < 6%



M1	0.70	0.25	3	150	0.0015	68210	92	307
M2	1.50	0.40	3	150	0.0035	31830	84	334
M3	2.20	0.50	3	150	0.0050	21705	87	326
M4	3.10	0.70	3	150	0.0070	15400	73	323
M5	3.80	0.80	3	150	0.0085	12565	77	320
M6	4.70	1.00	3	150	0.0105	10160	69	320
M8	5.90	1.25	5	150	0.0130	8095	138	526
M10	7.90	1.50	5	150	0.0175	6045	111	529

Cast aluminium



M1	0.70	0.25	3	180	0.0020	81850	147	491
M2	1.50	0.40	3	180	0.0040	38195	115	458
M3	2.20	0.50	3	180	0.0055	26045	115	430
M4	3.10	0.70	3	180	0.0080	18485	100	444
M5	3.80	0.80	3	180	0.0095	15080	103	430
M6	4.70	1.00	3	180	0.0120	12190	95	439
M8	5.90	1.25	5	180	0.0150	9710	191	728
M10	7.90	1.50	5	180	0.0200	7255	152	726

Unalloyed copper



M1	0.70	0.25	3	100	0.0015	45475	61	205
M2	1.50	0.40	3	100	0.0030	21220	48	191
M3	2.20	0.50	3	100	0.0045	14470	52	195
M4	3.10	0.70	3	100	0.0060	10270	42	185
M5	3.80	0.80	3	100	0.0075	8375	45	188
M6	4.70	1.00	3	100	0.0095	6775	42	193
M8	5.90	1.25	5	100	0.0120	5395	85	324
M10	7.90	1.50	5	100	0.0160	4030	68	322

Titanium alloys
> 300 HB
[Ti6Al4V]



M1	0.70	0.25	3	70	0.0010	31830	29	96
M2	1.50	0.40	3	70	0.0025	14855	28	111
M3	2.20	0.50	3	70	0.0035	10130	28	106
M4	3.10	0.70	3	70	0.0050	7190	24	108
M5	3.80	0.80	3	70	0.0060	5865	25	106
M6	4.70	1.00	3	70	0.0070	4740	22	100
M8	5.90	1.25	5	70	0.0090	3775	45	170
M10	7.90	1.50	5	70	0.0120	2820	36	169