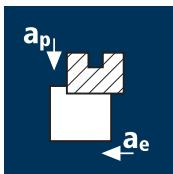


Application

Material



Steel
850 - 1100 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
40.00	8	45	0.065	2.000	30.000	360	185	11.2
50.00	8	45	0.080	2.500	37.500	285	185	17.2
63.00	10	45	0.080	3.150	47.250	225	180	27.1
80.00	12	45	0.100	4.000	60.000	180	215	51.6

Steel
1100 - 1300 N/mm²



40.00	8	30	0.065	2.000	30.000	240	125	7.4
50.00	8	30	0.080	2.500	37.500	190	120	11.5
63.00	10	30	0.080	3.150	47.250	150	120	18.0
80.00	12	30	0.100	4.000	60.000	120	145	34.4

Cold work tool steel
(12% Cr),
high alloyed
[1.2379]

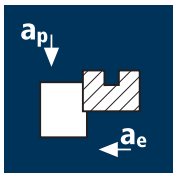


40.00	8	20	0.065	2.000	30.000	160	85	5.0
50.00	8	20	0.080	2.500	37.500	125	80	7.6
63.00	10	20	0.080	3.150	47.250	100	80	12.0
80.00	12	20	0.100	4.000	60.000	80	95	22.9

Cast iron
(lamellar / spheroidal)



40.00	8	42	0.065	2.000	30.000	335	175	10.4
50.00	8	42	0.080	2.500	37.500	265	170	16.0
63.00	10	42	0.080	3.150	47.250	210	170	25.3
80.00	12	42	0.100	4.000	60.000	165	200	48.1



Steel
850 - 1100 N/mm²



40.00	8	50	0.065	20.000	1.000	400	205	4.1
50.00	8	50	0.080	25.000	1.250	320	205	6.4
63.00	10	50	0.080	31.500	1.575	255	200	10.0
80.00	12	50	0.100	40.000	2.000	200	240	19.1

Steel
1100 - 1300 N/mm²



40.00	8	35	0.065	20.000	1.000	280	145	2.9
50.00	8	35	0.080	25.000	1.250	225	145	4.5
63.00	10	35	0.080	31.500	1.575	175	140	7.0
80.00	12	35	0.100	40.000	2.000	140	165	13.4

Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



40.00	8	25	0.065	20.000	1.000	200	105	2.1
50.00	8	25	0.080	25.000	1.250	160	100	3.2
63.00	10	25	0.080	31.500	1.575	125	100	5.0
80.00	12	25	0.100	40.000	2.000	100	120	9.5

Cast iron
(lamellar / spheroidal)



40.00	8	45	0.065	20.000	1.000	360	185	3.7
50.00	8	45	0.080	25.000	1.250	285	185	5.7
63.00	10	45	0.080	31.500	1.575	225	180	9.0
80.00	12	45	0.100	40.000	2.000	180	215	17.2