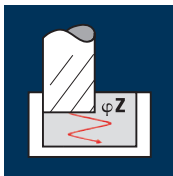




## Application



## Material

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

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	φZ [°]
3.00	3	85	0.012	16.000	2.700	9020	325	2°
4.00	3	85	0.018	21.000	3.600	6765	365	2°
5.00	3	85	0.027	26.000	4.500	5410	440	2°
6.00	3	85	0.033	32.000	5.400	4510	445	2°
8.00	3	85	0.035	42.000	7.200	3380	355	2°
10.00	3	85	0.047	53.000	9.000	2705	380	2°
12.00	3	85	0.059	63.000	10.800	2255	400	2°
16.00	3	85	0.065	84.000	14.400	1690	330	2°
20.00	3	85	0.079	105.000	18.000	1355	320	2°

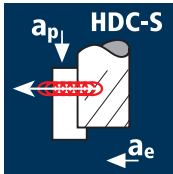
Steel  
850 - 1100 N/mm<sup>2</sup>

3.00	3	75	0.011	16.000	2.700	7960	265	3°
4.00	3	75	0.017	21.000	3.600	5970	305	3°
5.00	3	75	0.025	26.000	4.500	4775	360	3°
6.00	3	75	0.032	32.000	5.400	3980	380	3°
8.00	3	75	0.030	42.000	7.200	2985	270	3°
10.00	3	75	0.040	53.000	9.000	2385	285	3°
12.00	3	75	0.050	63.000	10.800	1990	300	3°
16.00	3	75	0.059	84.000	14.400	1490	265	3°
20.00	3	75	0.072	105.000	18.000	1195	260	3°

Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]

3.00	3	50	0.008	16.000	2.700	5305	125	2°
4.00	3	50	0.013	21.000	3.600	3980	155	2°
5.00	3	50	0.019	26.000	4.500	3185	180	2°
6.00	3	50	0.024	32.000	5.400	2655	190	2°
8.00	3	50	0.023	42.000	7.200	1990	135	2°
10.00	3	50	0.030	53.000	9.000	1590	145	2°
12.00	3	50	0.038	63.000	10.800	1325	150	2°
16.00	3	50	0.046	84.000	14.400	995	135	2°
20.00	3	50	0.050	105.000	18.000	795	120	2°

## Application



## Material

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

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]
3.00	3	211	0.041	16.000	0.150	22390	2775	6.7
4.00	3	211	0.055	21.000	0.200	16790	2795	11.7
5.00	3	211	0.070	26.000	0.250	13435	2810	18.3
6.00	3	211	0.085	32.000	0.300	11195	2860	27.5
8.00	3	211	0.114	42.000	0.400	8395	2860	48.0
10.00	3	211	0.141	53.000	0.500	6715	2835	75.1
12.00	3	211	0.169	63.000	0.600	5595	2840	107.3
16.00	3	211	0.186	84.000	0.800	4200	2340	157.2
20.00	3	211	0.234	105.000	1.000	3360	2355	247.0

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

3.00	3	216	0.050	16.000	0.150	22920	3420	8.2
4.00	3	216	0.067	21.000	0.200	17190	3445	14.5
5.00	3	216	0.084	26.000	0.250	13750	3465	22.5
6.00	3	216	0.103	32.000	0.300	11460	3525	33.9
8.00	3	216	0.137	42.000	0.400	8595	3525	59.3
10.00	3	216	0.169	53.000	0.500	6875	3495	92.6
12.00	3	216	0.204	63.000	0.600	5730	3500	132.3
16.00	3	216	0.224	84.000	0.800	4295	2885	193.9
20.00	3	216	0.281	105.000	1.000	3440	2900	304.7

Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]

3.00	3	149	0.028	16.000	0.150	15810	1325	3.2
4.00	3	149	0.040	21.000	0.200	11855	1440	6.0
5.00	3	149	0.050	26.000	0.250	9485	1415	9.2
6.00	3	149	0.059	32.000	0.300	7905	1400	13.4
8.00	3	149	0.079	42.000	0.400	5930	1410	23.7
10.00	3	149	0.099	53.000	0.500	4745	1415	37.5
12.00	3	149	0.120	63.000	0.600	3950	1420	53.6
16.00	3	149	0.129	84.000	0.800	2965	1145	77.1
20.00	3	149	0.166	105.000	1.000	2370	1185	124.3

Suitable cutting data for other applications and materials can be found in the cutting data software **ToolExpert E-Cut**

