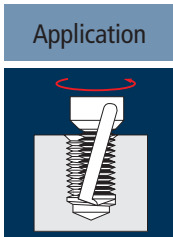


Material
Cast iron GG(G)
Cast aluminium
Wrought aluminium alloys Si < 6%
Recommendation: uncoated
Short-chipping brass CuZn

M	d2 [mm]	v _c [m/min]	f [mm]	L _K [mm]	n [min ⁻¹]	v _f [mm/min]
M 4	3.30	100	0.050	7.4	9645	480
M 5	4.20	100	0.065	9.4	7580	495
M 6	5.00	100	0.075	11.7	6365	475
M 8	6.80	100	0.100	14.7	4680	470
M10	8.50	100	0.125	19.3	3745	470
M12	10.20	100	0.150	22.2	3120	470
M16	14.00	100	0.210	27.8	2275	480
M 4	3.30	250	0.060	7.4	24115	1445
M 5	4.20	250	0.075	9.4	18950	1420
M 6	5.00	250	0.090	11.7	15915	1430
M 8	6.80	250	0.120	14.7	11705	1405
M10	8.50	250	0.150	19.3	9360	1405
M12	10.20	250	0.180	22.2	7800	1405
M16	14.00	250	0.250	27.8	5685	1420
M 4	3.30	200	0.060	7.4	19290	1155
M 5	4.20	200	0.075	9.4	15160	1135
M 6	5.00	200	0.090	11.7	12735	1145
M 8	6.80	200	0.120	14.7	9360	1125
M10	8.50	200	0.150	19.3	7490	1125
M12	10.20	200	0.180	22.2	6240	1125
M16	14.00	200	0.250	27.8	4545	1135
M 4	3.30	250	0.060	7.4	24115	1445
M 5	4.20	250	0.075	9.4	18950	1420
M 6	5.00	250	0.090	11.7	15915	1430
M 8	6.80	250	0.120	14.7	11705	1405
M10	8.50	250	0.150	19.3	9360	1405
M12	10.20	250	0.180	22.2	7800	1405
M16	14.00	250	0.250	27.8	5685	1420

Cutting data for TiCN-coated tools



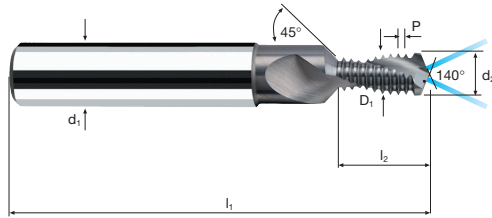
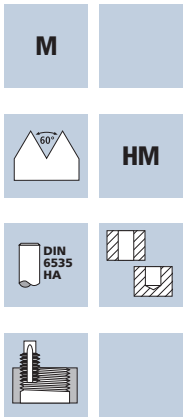
Material
Cast iron GG(G)
Cast aluminium
Wrought aluminium alloys Si < 6%
Recommendation: uncoated
Short-chipping brass CuZn

M	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [mm ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M 4	3.20	0.70	2	100	0.025	9945	99	495
M 5	4.00	0.80	2	100	0.030	7960	96	480
M 6	4.75	1.00	2	100	0.035	6700	98	470
M 8	6.35	1.25	2	100	0.050	5015	103	500
M10	7.95	1.50	2	100	0.060	4005	98	480
M12	9.95	1.75	2	100	0.075	3200	82	480
M16	13.20	2.00	2	100	0.100	2410	84	480
M 4	3.20	0.70	2	250	0.030	24870	298	1490
M 5	4.00	0.80	2	250	0.035	19895	279	1395
M 6	4.75	1.00	2	250	0.045	16755	315	1510
M 8	6.35	1.25	2	250	0.060	12530	310	1505
M10	7.95	1.50	2	250	0.070	10010	287	1400
M12	9.95	1.75	2	250	0.090	8000	246	1440
M16	13.20	2.00	2	250	0.120	6030	253	1445
M 4	3.20	0.70	2	200	0.030	19895	239	1195
M 5	4.00	0.80	2	200	0.035	15915	223	1115
M 6	4.75	1.00	2	200	0.045	13405	251	1205
M 8	6.35	1.25	2	200	0.060	10025	249	1205
M10	7.95	1.50	2	200	0.070	8010	230	1120
M12	9.95	1.75	2	200	0.090	6400	196	1150
M16	13.20	2.00	2	200	0.120	4825	203	1160
M 4	3.20	0.70	2	250	0.030	24870	298	1490
M 5	4.00	0.80	2	250	0.035	19895	279	1395
M 6	4.75	1.00	2	250	0.045	16755	315	1510
M 8	6.35	1.25	2	250	0.060	12530	310	1505
M10	7.95	1.50	2	250	0.070	10010	287	1400
M12	9.95	1.75	2	250	0.090	8000	246	1440
M16	13.20	2.00	2	250	0.120	6030	253	1445

Cutting data for TiCN-coated tools

Drill/thread milling cutters

1.5xd, chamfer 45°, Incool



			Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	GG(G) CuZn Brass
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Example: Order-N°.										TiCN	
Article-N°										E22200	EH22200
ø-Code											
ø-Code	d	P	l ₁	l ₂	d ₁ h ₆	d ₂	D ₁	Rk 6H			
.058	M 4	0.70	48	6.9	6	3.3	3.20	1.560	2	•	•
.084	M 5	0.80	54	8.8	6	4.2	4.00	1.950	2	•	•
.088	M 6	1.00	62	10.9	8	5.0	4.75	2.315	2	•	•
.160	M 8	1.25	74	13.7	10	6.8	6.35	3.095	2	•	•
.174	M10	1.50	80	18.0	12	8.5	7.95	3.875	2	•	•
.240	M12	1.75	90	20.9	14	10.2	9.95	4.855	2	•	•
.246	M16	2.00	102	26.0	18	14.0	13.20	6.440	2	•	•

