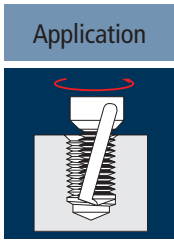


Material
Cast iron GG(G)
Cast aluminium
Wrought aluminium alloys Si < 6%
Recommendation: uncoated
Short-chipping brass CuZn

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	9.5	9645	480
M 5	4.20	100	0.065	11.8	7580	495
M 6	5.00	100	0.075	14.7	6365	475
M 8	6.80	100	0.100	19.7	4680	470
M 10	8.50	100	0.125	23.8	3745	470
M 12	10.20	100	0.150	27.4	3120	470
M 16	14.00	100	0.210	37.8	2275	480
M 4	3.30	250	0.060	9.5	24115	1445
M 5	4.20	250	0.075	11.8	18950	1420
M 6	5.00	250	0.090	14.7	15915	1430
M 8	6.80	250	0.120	19.7	11705	1405
M10	8.50	250	0.150	23.8	9360	1405
M12	10.20	250	0.180	27.4	7800	1405
M16	14.00	250	0.250	37.8	5685	1420
M 4	3.30	200	0.060	9.5	19290	1155
M 5	4.20	200	0.075	11.8	15160	1135
M 6	5.00	200	0.090	14.7	12735	1145
M 8	6.80	200	0.120	19.7	9360	1125
M10	8.50	200	0.150	23.8	7490	1125
M12	10.20	200	0.180	27.4	6240	1125
M16	14.00	200	0.250	37.8	4545	1135
M 4	3.30	250	0.060	9.5	24115	1445
M 5	4.20	250	0.075	11.8	18950	1420
M 6	5.00	250	0.090	14.7	15915	1430
M 8	6.80	250	0.120	19.7	11705	1405
M10	8.50	250	0.150	23.8	9360	1405
M12	10.20	250	0.180	27.4	7800	1405
M16	14.00	250	0.250	37.8	5685	1420

Cutting data for TiCN-coated tools



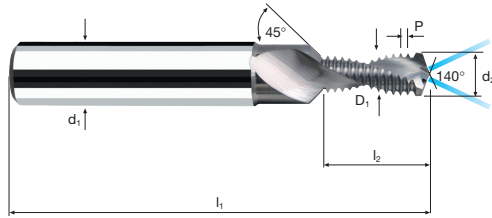
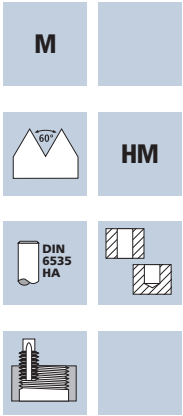
Material
Cast iron GG(G)
Cast aluminium
Wrought aluminium alloys Si < 6%
Recommendation: uncoated
Short-chipping brass CuZn

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	0.020	9945	80	400
M 5	4.00	0.80	2	100	0.025	7960	80	400
M 6	4.75	1.00	2	100	0.030	6700	83	400
M 8	6.35	1.25	2	100	0.040	5015	83	400
M10	7.95	1.50	2	100	0.055	4005	90	440
M12	9.95	1.75	2	100	0.065	3200	71	415
M16	13.20	2.00	2	100	0.090	2410	76	435
M 4	3.20	0.70	2	250	0.025	24870	249	1245
M 5	4.00	0.80	2	250	0.030	19895	239	1195
M 6	4.75	1.00	2	250	0.035	16755	245	1175
M 8	6.35	1.25	2	250	0.050	12530	259	1255
M10	7.95	1.50	2	250	0.060	10010	246	1200
M12	9.95	1.75	2	250	0.075	8000	205	1200
M16	13.20	2.00	2	250	0.100	6030	211	1205
M 4	3.20	0.70	2	200	0.025	19895	199	995
M 5	4.00	0.80	2	200	0.030	15915	191	955
M 6	4.75	1.00	2	200	0.035	13405	196	940
M 8	6.35	1.25	2	200	0.050	10025	207	1005
M10	7.95	1.50	2	200	0.060	8010	197	960
M12	9.95	1.75	2	200	0.075	6400	164	960
M16	13.20	2.00	2	200	0.100	4825	169	965
M 4	3.20	0.70	2	250	0.025	24870	249	1245
M 5	4.00	0.80	2	250	0.030	19895	239	1195
M 6	4.75	1.00	2	250	0.035	16755	245	1175
M 8	6.35	1.25	2	250	0.050	12530	259	1255
M10	7.95	1.50	2	250	0.060	10010	246	1200
M12	9.95	1.75	2	250	0.075	8000	205	1200
M16	13.20	2.00	2	250	0.100	6030	211	1205

Cutting data for TiCN-coated tools

Drill/thread milling cutters

2.0xd, chamfer 45°, Incool



				Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	GG(G) CuZn Brass
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		Example: Order-N°.		Article-N°.		ø-Code				TiCN	
				EH22300		.058				E22300	EH22300
ø Code	d	P	l ₁	l ₂	d ₁ h ₆	d ₂	D ₁	R _k 6H			
.058	M 4	0.70	48	9.0	6	3.3	3.20	1.560	2	•	•
.084	M 5	0.80	54	11.2	6	4.2	4.00	1.950	2	•	•
.088	M 6	1.00	62	13.9	8	5.0	4.75	2.315	2	•	•
.160	M 8	1.25	74	18.7	10	6.8	6.35	3.095	2	•	•
.174	M10	1.50	80	22.5	12	8.5	7.95	3.875	2	•	•
.240	M12	1.75	90	26.1	14	10.2	9.95	4.855	2	•	•
.246	M16	2.00	102	36.0	18	14.0	13.20	6.440	2	•	•

TM