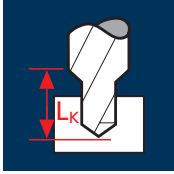


Application



Material

Steel
< 500 N/mm²

d1 [mm]	for	v _c [m/min]	f [mm]	L _K [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
2.50	M3	110	0.045	9.6	11670	525	3.5
3.30	M4	110	0.055	12.5	8755	480	6.0
4.20	M5	110	0.070	14.9	7005	490	9.5
5.00	M6	110	0.085	18.1	5835	495	14.0
6.80	M8	110	0.115	23.0	4375	505	25.5
8.50	M10	110	0.145	28.0	3500	505	39.5
10.20	M12	110	0.170	33.1	2920	495	56.0
14.00	M16	110	0.230	42.4	2190	505	101.5

Steel
500 - 850 N/mm²

2.50	M3	80	0.045	9.6	8490	380	2.5
3.30	M4	80	0.055	12.5	6365	350	4.5
4.20	M5	80	0.070	14.9	5095	355	7.0
5.00	M6	80	0.085	18.1	4245	360	10.0
6.80	M8	80	0.115	23.0	3185	365	18.5
8.50	M10	80	0.145	28.0	2545	370	29.0
10.20	M12	80	0.170	33.1	2120	360	40.5
14.00	M16	80	0.230	42.4	1590	365	73.5

Steel
850 - 1100 N/mm²

2.50	M3	55	0.040	9.6	5835	235	1.5
3.30	M4	55	0.050	12.5	4375	220	3.0
4.20	M5	55	0.065	14.9	3500	230	4.5
5.00	M6	55	0.075	18.1	2920	220	6.0
6.80	M8	55	0.100	23.0	2190	220	11.0
8.50	M10	55	0.125	28.0	1750	220	17.5
10.20	M12	55	0.150	33.1	1460	220	25.0
14.00	M16	55	0.200	42.4	1095	220	44.0

Cast iron
(lamellar / spheroidal)

2.50	M3	160	0.080	9.6	16975	1360	9.5
3.30	M4	160	0.105	12.5	12730	1335	17.0
4.20	M5	160	0.130	14.9	10185	1325	26.0
5.00	M6	160	0.160	18.1	8490	1360	38.5
6.80	M8	160	0.210	23.0	6365	1335	67.0
8.50	M10	160	0.265	28.0	5095	1350	106.0
10.20	M12	160	0.315	33.1	4245	1335	151.0
14.00	M16	160	0.420	42.4	3185	1340	269.5

Material

Wrought aluminium
alloys Si < 6%

d1 [mm]	for	v _c [m/min]	f [mm]	L _K [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
2.50	M3	200	0.080	9.6	21220	1700	12.0
3.30	M4	200	0.105	12.5	15915	1670	21.0
4.20	M5	200	0.130	14.9	12730	1655	32.5
5.00	M6	200	0.160	18.1	10610	1700	48.0
6.80	M8	200	0.210	23.0	7960	1670	84.0
8.50	M10	200	0.265	28.0	6365	1685	132.5
10.20	M12	200	0.315	33.1	5305	1670	189.0
14.00	M16	200	0.420	42.4	3980	1670	336.0

