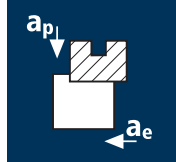
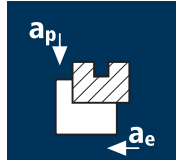


Application	Material	d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _t [mm/min]	Q [cm³/min]	
	Steel < 850 N/mm²  	32.00	6	65	0.060	6.400	24.000	645	235	35.8	
		40.00	8	65	0.080	8.000	30.000	515	330	79.5	
		50.00	8	65	0.100	10.000	37.500	415	330	124.1	
		63.00	10	65	0.120	12.600	47.250	330	395	234.6	
		80.00	10	65	0.120	16.000	60.000	260	310	297.9	
	Steel 850 - 1100 N/mm²  	32.00	6	48	0.060	6.400	24.000	475	170	26.4	
		40.00	8	48	0.080	8.000	30.000	380	245	58.7	
		50.00	8	48	0.100	10.000	37.500	305	245	91.7	
		63.00	10	48	0.120	12.600	47.250	245	290	173.3	
		80.00	10	48	0.120	16.000	60.000	190	230	220.0	
	Steel 1100 - 1300 N/mm²  	32.00	6	35	0.060	6.400	24.000	350	125	19.3	
		40.00	8	35	0.080	8.000	30.000	280	180	42.8	
		50.00	8	35	0.100	10.000	37.500	225	180	66.8	
		63.00	10	35	0.120	12.600	47.250	175	210	126.3	
		80.00	10	35	0.120	16.000	60.000	140	165	160.4	
	Stainless steel [Cr-Ni/1.4301]  	32.00	6	26	0.060	6.400	24.000	260	95	14.3	
		40.00	8	26	0.080	8.000	30.000	205	130	31.8	
		50.00	8	26	0.100	10.000	37.500	165	130	49.7	
		63.00	10	26	0.120	12.600	47.250	130	160	93.9	
		80.00	10	26	0.120	16.000	60.000	105	125	119.2	
	Steel < 850 N/mm²  	32.00	6	68	0.070	6.400	9.600	675	285	17.5	
		40.00	8	68	0.090	8.000	12.000	540	390	37.4	
		50.00	8	68	0.110	10.000	15.000	435	380	57.1	
		63.00	10	68	0.125	12.600	18.900	345	430	102.3	
		80.00	10	68	0.145	16.000	24.000	270	390	150.6	
	Steel 850 - 1100 N/mm²  	32.00	6	55	0.070	6.400	9.600	545	230	14.1	
		40.00	8	55	0.090	8.000	12.000	440	315	30.3	
		50.00	8	55	0.110	10.000	15.000	350	310	46.2	
		63.00	10	55	0.125	12.600	18.900	280	345	82.7	
		80.00	10	55	0.145	16.000	24.000	220	315	121.8	
	Steel 1100 - 1300 N/mm²  	32.00	6	40	0.070	6.400	9.600	400	165	10.3	
		40.00	8	40	0.090	8.000	12.000	320	230	22.0	
		50.00	8	40	0.110	10.000	15.000	255	225	33.6	
		63.00	10	40	0.125	12.600	18.900	200	255	60.2	
		80.00	10	40	0.145	16.000	24.000	160	230	88.6	
	Stainless steel [Cr-Ni/1.4301]  	32.00	6	29	0.070	6.400	9.600	290	120	7.4	
		40.00	8	29	0.090	8.000	12.000	230	165	16.0	
		50.00	8	29	0.110	10.000	15.000	185	160	24.4	
		63.00	10	29	0.125	12.600	18.900	145	185	43.6	
		80.00	10	29	0.145	16.000	24.000	115	165	64.2	