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Dimension	Ø8	Ø10	Ø12	Ø16	Ø20						
Infeed in mm	ae= 0.05xD	ae= 0.05xD	ae= 0.05xD	ae= 0.05xD	ae= 0.05xD						
Application	ap= Lmax	ap= Lmax	ap= Lmax	ap= Lmax	ap= Lmax						

Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	
P			Vc (m/min)					
1.1	Steel, unalloyed	<500	310	0.085	0.1	0.12	0.15 0.18	
1.2-1.5	Steel, unalloyed	<1100	250	0.08	0.09	0.11	0.14 0.16	
2.1-2.2	Steel, low-alloyed	<950	210	0.08	0.09	0.11	0.14 0.16	
2.3-2.4	Steel, low-alloyed	<1300	160	0.075	0.085	0.1	0.13 0.14	
3.1-3.2	Steel, high-alloyed	<1100	180	0.075	0.085	0.1	0.13 0.14	
3.3	Steel, high-alloyed	<1400	150	0.07	0.08	0.09	0.12 0.13	
K			Vc (m/min)					
1.1-1.2	Grey cast iron	<1000	235	0.08	0.09	0.11	0.14 0.16	
2.1-2.2	Modular cast iron	<850	190	0.075	0.085	0.1	0.13 0.14	
3.1-3.2	Malleable cast iron	<800	170	0.07	0.08	0.09	0.12 0.13	
M			Vc (m/min)					
1.1	Inox, ferritic/martensitic	<850	160	0.065	0.08	0.09	0.12 0.15	
2.1	Inox, austenitic	<650	140	0.06	0.07	0.08	0.11 0.14	
2.2	Inox, austenitic	<750	120	0.055	0.065	0.07	0.1 0.13	
3.1	Duplex steel	<1100						

NOTE | The values marked in turquoise are side applications! We recommend the use of HB shank and side lock arbor. (EXPK1-M03-0134) Values for ETC-milling; please reduce Vc and fz by 20% using trimming.