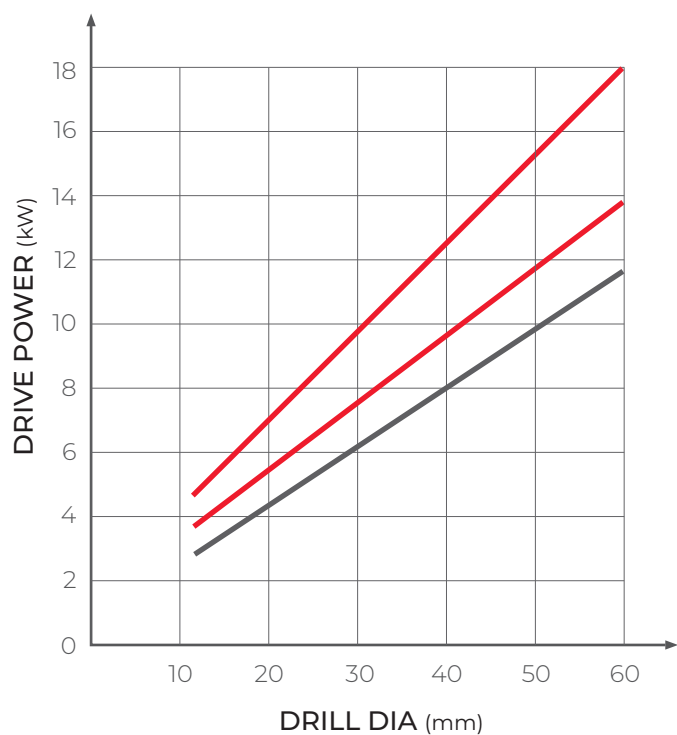


ISO	Material Group	Vc (m/min)	fn (mm/rev)				
			Ø14-Ø16	Ø16,5-Ø23,5	Ø24-Ø29,5	Ø30-Ø42	Ø43-Ø50
P	Unalloyed steel (-0,25%)	160-250	0,04-0,08	0,04-0,08	0,04-0,10	0,05-0,12	0,05-0,14
	Low-alloy steel (0,25%-)	140-220	0,04-0,10	0,04-0,12	0,05-0,015	0,08-0,18	0,10-0,20
	Low-alloy steel	120-220	0,04-0,10	0,05-0,10	0,05-0,12	0,06-0,18	0,06-0,20
	High-alloy steel	120-180	0,04-0,12	0,05-0,12	0,07-0,16	0,08-0,18	0,08-0,20
M	Stainless steel	130-220	0,04-0,10	0,04-0,12	0,05-0,14	0,06-0,16	0,06-0,18
K	Grey cast iron	150-250	0,04-0,10	0,05-0,14	0,05-0,17	0,08-0,20	0,08-0,25
	Cast iron with nodular cast	100-200	0,04-0,12	0,04-0,12	0,05-0,14	0,06-0,15	0,06-0,18
S	Super-alloys and titanium	30-90	0,04-0,08	0,04-0,08	0,04-0,11	0,07-0,12	0,08-0,15

### NOTES

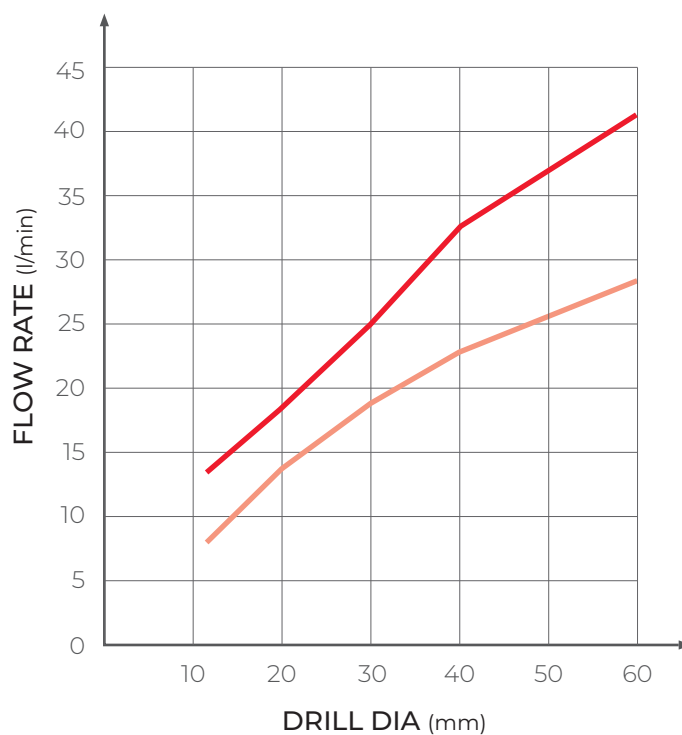
When working on irregular surfaces, please reduce the feed rate by 30%-50%. To ensure the best performance, make sure to use the proper oil pressure (over 5kg/cm<sup>2</sup>) and follow the cutting data parameters.

### Power requirements



- F = 0,13 mm/r
- F = 0,10 mm/r
- F = 0,07 mm/r

### Cutting oil quantity



- Recommended cutting oil quantity
- Min. cutting oil quantity

### NOTES

Minimum pressure coolant: 5bar