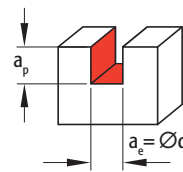
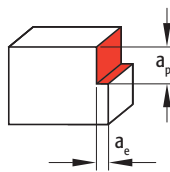


Material group	TSR (N/mm <sup>2</sup> )	Hardness HB	Cutting speed	Coolant
			Vc m/min	
P1.1	< 750	< 250	<b>140 - 220</b>	emulsion
P1.2	< 1000	< 300	<b>100 - 180</b>	emulsion
P1.3	< 1400	< 400	<b>70 - 160</b>	emulsion
H2.1		42-50 HRc	<b>80 - 140</b>	emulsion
M3.1	< 950		<b>80 - 130</b>	emulsion
M3.2	< 1250		<b>60 - 100</b>	emulsion
K4.1	< 800		<b>100 - 160</b>	emulsion
S6.1	< 1500		<b>40 - 60</b>	emulsion
S6.2	< 1600		<b>45 - 70</b>	emulsion
S6.3	< 1600		<b>30 - 50</b>	emulsion
S6.4	< 1250		<b>60 - 90</b>	emulsion

- Special designed geometry for machining materials P1.1, 1.2, 1.3, K4.1  
Spezieller Geometrie zur Zerspanung materialen P1.1, 1.2, 1.3, K4.1
- 5 flute for new machining strategies  
5 Schneiden zur Zerspanung mit neuen Strategien
- High metal removal rate!  
Maximales Zerspanungsvolumen!



**Shoulder milling / Stirnfräsen  
(1xD depth of cut)**

Ød (mm)	a <sub>p</sub> max. (mm)	a <sub>c</sub> max. (mm)	f <sub>z</sub> (mm/tooth)
3,0	< 3,00	< 1,4	0,010 - 0,020
4,0	< 4,00	< 1,8	0,015 - 0,030
5,0	< 5,00	< 2,3	0,020 - 0,040
6,0	< 6,00	< 2,7	0,025 - 0,050
8,0	< 8,00	< 3,6	0,030 - 0,060
10,0	< 10,00	< 4,5	0,040 - 0,070
12,0	< 12,00	< 5,4	0,050 - 0,080
14,0	< 14,00	< 6,3	0,055 - 0,090
16,0	< 16,00	< 7,2	0,060 - 0,100
20,0	< 20,00	< 9,0	0,080 - 0,120
25,0	< 25,00	< 11,3	0,100 - 0,150

**Shoulder milling / Stirnfräsen  
(2xD depth of cut)**

Ød (mm)	a <sub>p</sub> max. (mm)	a <sub>c</sub> max. (mm)	f <sub>z</sub> (mm/tooth)
3,0	< 6,00	< 0,750	0,010 - 0,030
4,0	< 8,00	< 1,000	0,020 - 0,040
5,0	< 10,00	< 1,250	0,025 - 0,055
6,0	< 12,00	< 1,500	0,035 - 0,065
8,0	< 16,00	< 2,000	0,045 - 0,075
10,0	< 20,00	< 2,500	0,055 - 0,085
12,0	< 24,00	< 3,000	0,070 - 0,100
14,0	< 28,00	< 3,500	0,080 - 0,120
16,0	< 32,00	< 4,000	0,090 - 0,130
20,0	< 40,00	< 5,000	0,110 - 0,150
25,0	< 50,00	< 6,250	0,135 - 0,185