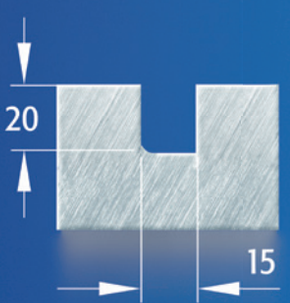
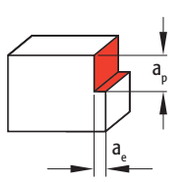
Material group	TSR (N/mm²)	Hardness HB	Cutting speed Vc m/min	Coolant
P1.1	< 750	< 250	**240 - 300**	emulsion
P1.2	< 1000	< 300	**160 - 240**	emulsion
P1.3	< 1400	< 400	**130 - 200**	emulsion
H2.1		< 50 HRc	**100 - 150**	emulsion
M3.1	< 950		**100 - 150**	emulsion
M3.2	< 1250		**90 - 120**	emulsion
K4.1	< 800		**125 - 225**	emulsion
S6.1	< 1500		**45 - 65**	emulsion
S6.2	< 1600		**50 - 80**	emulsion
S6.3	< 1600		**35 - 55**	emulsion
S6.4	< 1250		**70 - 105**	emulsion

Workpiece Material: St.37

	VHTS 5 100 072 06 03	Competitor
a_p max	20 mm	10 mm
a_e	1 mm (programmed)	10 mm / 5 mm
v_c	250 mtr/min	180 mtr/min
n	7957 rpm	5730 rpm
F_z	0,12 mm/t	0,04 mm/t
v_f	4774 mm/min	912 mm/min
Productiontime	24 s	37 s





Shoulder milling / Eckfräsen

Ød (mm)	a_p max. (mm)	a_e max. (mm)	f_z (mm/tooth)
3,0	< 9,00	< 0,600	0,015 - 0,035
4,0	< 12,00	< 0,800	0,025 - 0,050
5,0	< 15,00	< 1,000	0,030 - 0,060
6,0	< 18,00	< 1,200	0,040 - 0,070
8,0	< 24,00	< 1,600	0,050 - 0,085
10,0	< 30,00	< 2,000	0,060 - 0,100
12,0	< 36,00	< 2,400	0,085 - 0,120
16,0	< 40,00	<3 ,200	0,100 - 0,145
20,0	< 50,00	< 4,000	0,125 - 0,175