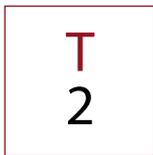


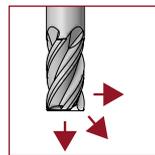
Material Groups

<p>Gen. structural/ case hard. steels Tool/ tempering steels Alloyed/ cold work steels Cast steel</p>		<p>1.0037 1.0570 1.0503 1.7131 1.2367 1.2379 1.7225 1.2312 1.2767 1.3505 1.7707 1.0619 1.0446</p>
<p>Stainless steels Stainless steels</p>		<p>1.4301 1.4305 1.4034 1.4435 1.4571</p>
<p>Cast iron Spherical cast iron</p>		<p>GG25 GG40 GGG40 GGG50 GGG60 GGG70</p>
<p>Aluminum Si content 0,5–9% Aluminum Si content 10–15% Copper/ brass/ bronze Medium hard/ soft plastics</p>		<p>3.1645 3.2163 3.2523 2.0321 2.1030 –</p>
<p>Titanium alloys Nickel alloys</p>		<p>3.7164 3.7165 Inconel 713</p>
<p>Hardened steel Hardened steel Hardened steel</p>		<p>HRC 45–50 HRC 51–58 HRC 59–65</p>

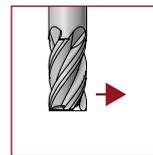
Pictographs



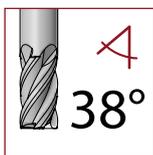
Number of teeth



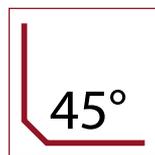
Spatial



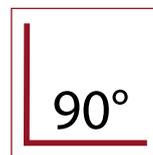
Lateral



Angle of twist



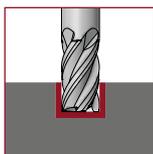
Corner chamfer



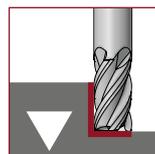
Sharp edged



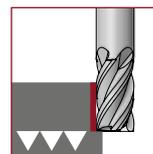
Hardness



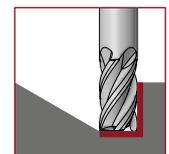
Slotting



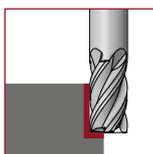
Rough milling



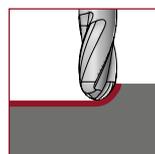
Finishing milling



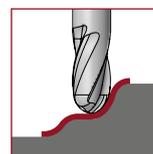
Ramping



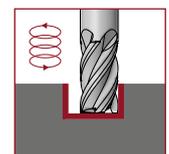
Trimming



Ball track milling



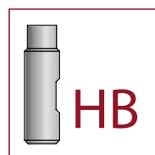
Copy milling



Helix



Smooth shank



Weldon (please inquire)

Cutting data v_c | f_z | a_p | a_e

Shoulder/slot/ball track/copy milling cutting. The cutting data listed for the individual tool types are recommended values. It is impossible to take into account all conditions. As a consequence, we do not assume any liability for this data. Please contact our headquarters or your regular service consultant directly if you require process and workpiece specific information.