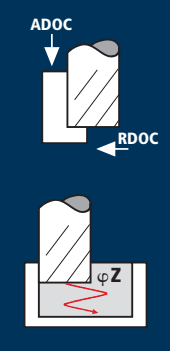

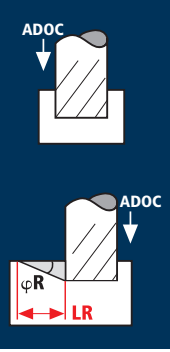



Application	Material	d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM [min ⁻¹]	Feed/FeedZ [mm/min]	MRR [cm ³ /min]	φZ [°]	φA [°]
	Steel 24 - 34 HRC 	4	4	150	0.030	6.0	1.6	11935	1430	13.5	20°	see ToolExpert HelixRamp (www.fraisa.com)
		5	4	150	0.035	7.5	2.0	9550	1335	20.0	20°	
		6	4	150	0.040	9.0	2.4	7960	1275	27.5	20°	
		8	4	150	0.050	12.0	3.2	5970	1195	46.0	20°	
		10	4	150	0.065	15.0	4.0	4775	1240	74.5	20°	
		12	4	150	0.075	18.0	4.8	3980	1195	103.0	20°	
		16	4	150	0.085	24.0	6.4	2985	1015	156.0	20°	
		20	4	150	0.100	30.0	8.0	2385	955	229.0	20°	
		4	4	115	0.030	6.0	1.6	9150	1100	10.5	17.5°	
		5	4	115	0.035	7.5	2.0	7320	1025	15.5	17.5°	
		6	4	115	0.040	9.0	2.4	6100	975	21.0	17.5°	
		8	4	115	0.050	12.0	3.2	4575	915	35.0	17.5°	
		10	4	115	0.065	15.0	4.0	3660	950	57.0	17.5°	
		12	4	115	0.075	18.0	4.8	3050	915	79.0	17.5°	
		16	4	115	0.085	24.0	6.4	2290	780	120.0	17.5°	
		20	4	115	0.100	30.0	8.0	1830	730	175.0	17.5°	
		4	4	50	0.015	6.0	1.6	3980	240	2.5	15°	
		5	4	50	0.020	7.5	2.0	3185	255	4.0	15°	
		6	4	50	0.025	9.0	2.4	2655	265	5.5	15°	
		8	4	50	0.030	12.0	3.2	1990	240	9.0	15°	
10	4	50	0.035	15.0	4.0	1590	225	13.5	15°			
12	4	50	0.045	18.0	4.8	1325	240	20.5	15°			
16	4	50	0.055	24.0	6.4	995	220	34.0	15°			
20	4	50	0.070	30.0	8.0	795	225	54.0	15°			
4	4	60	0.020	6.0	1.6	4775	380	3.5	12°			
5	4	60	0.025	7.5	2.0	3820	380	5.5	12°			
6	4	60	0.030	9.0	2.4	3185	380	8.0	12°			
8	4	60	0.040	12.0	3.2	2385	380	14.5	12°			
10	4	60	0.045	15.0	4.0	1910	345	20.5	12°			
12	4	60	0.055	18.0	4.8	1590	350	30.0	12°			
16	4	60	0.065	24.0	6.4	1195	310	47.5	12°			
20	4	60	0.080	30.0	8.0	955	305	73.0	12°			

Application	Material	d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	RPM [min ⁻¹]	Feed/FeedR [mm/min]	MRR [cm ³ /min]	φR [°]	LR [mm]
	Steel 24 - 34 HRC 	4	4	120	0.025	5.0	4	9550	955	19.0	32°	8.0
		5	4	120	0.025	6.3	5	7640	765	24.0	32°	10.4
		6	4	120	0.030	7.5	6	6365	765	34.5	32°	12.0
		8	4	120	0.040	10.0	8	4775	765	61.0	32°	16.0
		10	4	120	0.050	12.5	10	3820	765	95.5	32°	20.0
		12	4	120	0.055	15.0	12	3185	700	126.0	32°	24.0
		16	4	120	0.065	20.0	16	2385	620	198.5	32°	32.0
		20	4	120	0.075	25.0	20	1910	575	287.5	32°	40.0
		4	4	90	0.025	5.0	4	7160	715	14.5	28°	9.4
		5	4	90	0.025	6.3	5	5730	575	18.0	28°	12.2
		6	4	90	0.030	7.5	6	4775	575	26.0	28°	14.1
		8	4	90	0.040	10.0	8	3580	575	46.0	28°	18.8
		10	4	90	0.050	12.5	10	2865	575	72.0	28°	23.5
		12	4	90	0.055	15.0	12	2385	525	94.5	28°	28.2
		16	4	90	0.065	20.0	16	1790	465	149.0	28°	37.6
		20	4	90	0.075	25.0	20	1430	430	215.0	28°	47.0
		4	4	40	0.010	5.0	4	3185	125	2.5	24°	11.2
		5	4	40	0.015	6.3	5	2545	155	5.0	24°	14.6
		6	4	40	0.020	7.5	6	2120	170	7.5	24°	16.8
		8	4	40	0.025	10.0	8	1590	160	13.0	24°	22.5
10	4	40	0.025	12.5	10	1275	130	16.5	24°	28.1		
12	4	40	0.035	15.0	12	1060	150	27.0	24°	33.7		
16	4	40	0.040	20.0	16	795	125	40.0	24°	44.9		
20	4	40	0.055	25.0	20	635	140	70.0	24°	56.2		
4	4	50	0.015	5.0	4	3980	240	5.0	19°	14.5		
5	4	50	0.020	6.3	5	3185	255	8.0	19°	18.9		
6	4	50	0.025	7.5	6	2655	265	12.0	19°	21.8		
8	4	50	0.030	10.0	8	1990	240	19.0	19°	29.0		
10	4	50	0.035	12.5	10	1590	225	28.0	19°	36.3		
12	4	50	0.040	15.0	12	1325	210	38.0	19°	43.6		
16	4	50	0.050	20.0	16	995	200	64.0	19°	58.1		
20	4	50	0.060	25.0	20	795	190	95.0	19°	72.6		