



DIAMANT

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DIAMOND



DIAMANTE



GYÉMÁNT



352



358



364



365



366



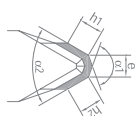
368



369



370



371



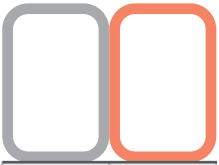
375



377

380

	Z			●	■	◆	▲	
DIXI 72420 Ø 2.00 - 20.00 	1 - 2	358	   	✓	✓		□	
DIXI 70520 PCD Ø 1.00 - 20.00 	1 - 2	359	   	✓	□		□	
DIXI 70600 PCD Ø 1.00 - 6.00 	1	360	   	✓				
DIXI 70600 DIA Ø 3.00 - 6.00 	1	360	   			✓		
DIXI 72310 DIA Ø 0.30 - 2.00 	1	361	   			✓		
DIXI 72421 DIA Ø 6.00 - 12.00 	1	362	   			✓		
DIXI 70320 PCD Ø 2.00 - 20.00 	1 - 2	363	   	✓	□		□	
DIXI 76230 DIA Ø 0.10 - 0.30 	1	364	   			✓		
DIXI 76230 	1	364	   	□	□		□	
DIXI 70170 DIA DIXI 70180 DIA Ø 0.05 - 0.10 	1	365	   			✓		
DIXI 70170 PCD DIXI 70180 PCD Ø 0.10 - 0.20 	1	365	   	✓				



⊙	○
⊙	○
⊙	○



⊙	⊙	⊙	○	○	○	⊙	○		
⊙	⊙	⊙	○	○	○	⊙	○		
⊙	⊙	⊙	○	○	○	⊙	○		
⊙	⊙	⊙	○			⊙			
⊙	⊙	⊙	○			⊙			
						⊙			
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⊙	⊙	⊙	○			⊙			

⊙	⊙	⊙	○			⊙			
⊙	⊙	⊙	○	○	○	⊙	○		



		Z			●	■	◆	▲	
DIXI 81000 Ø 40 - 100		2	368	 	✓		✓		
DIXI 80000 Ø 40 - 125		6 - 16	369	  	✓	□		□	
DIXI 11140		1	369		□				
DIXI 11180		2	369		□				
POLY 40010-2 Ø 8.00 - 22.10		4	370	 	□			□	
POLY 40010-3 Ø 8.00 - 22.10		4	370	 	□			□	
DIXI 25800		-	370		□	□	□	□	
DIXI 25810		-	370		□	□	□	□	
DIXI 20610		-	371		□	□	□	□	
DIXI 20770		-	371		□	□	□	□	
ARTDECO 26500 TR		-	372		✓	□	□	□	
ARTDECO 26500 FT		-	372		✓	□	□	□	



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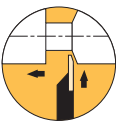


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	Z			●	■	◆	▲	
ARTDECO 26500 AV 	-	372		✓	□	□	□	
ARTDECO 26500 AR 	-	372		✓	□	□	□	
DIXI 264X0 	-	371		□	□	□	□	
DIXI 1973 	-	377						
DIXI 1978 	-	377		✓	✓			



⊙	○
⊙	○
⊙	○



⊙	⊙	⊙	○	○	○	⊙	○		
⊙	⊙	⊙	○	○	○	⊙	○		
⊙	⊙	⊙	○	○	○	⊙	○		



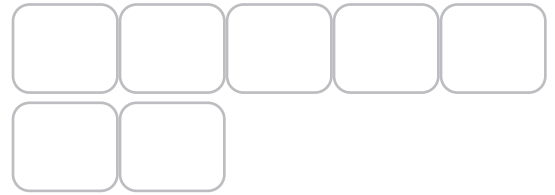
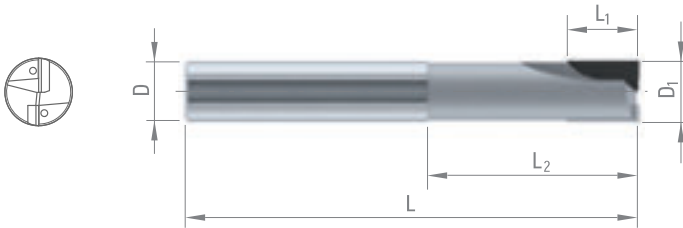
Z = 1-2



P. 380



$D_1 \geq \emptyset 6$



D_{1h10}	L_1	L_2	D_{h5}	L	Z		
1.00	2.0	-	6	42	1	979179	
1.50	3.0	-	6	42	1	977382	
2.00	3.0	6	6	42	1	66785	
2.00 >	3.0	20	6	75	1	970175	
3.00	4.0	6	6	42	1	67540	301958
3.00 >	4.0	6	6	42	2		305549
3.00 >	4.0	15	6	75	2	970176	
3.00 >	4.0	20	6	75	2	970177	
4.00	4.0	8	6	50	1	957593	
4.00 >	6.5	10	6	50	1	67541	301959
4.00 >	6.5	15	6	75	2	970178	
4.00 >	6.5	25	6	75	2	970179	
5.00	5.0	10	6	50	2	957595	
5.00 >	6.5	10	6	50	2	53153	
5.00 >	6.5	35	6	75	2	970166	301960
6.00	6.0	12	6	57	2	976391	301961
6.00 >	8.0	34	6	75	2	976392	
6.00 >	8.0	50	6	100	2	976393	
7.00	8.0	34	8	75	2	976394	301962
8.00	7.0	14	8	63	2	976395	301963
8.00 >	10.0	34	8	75	2	976396	
8.00 >	10.0	50	8	100	2	976397	
8.00 >	10.0	75	8	125	2	976398	
9.00	10.0	35	10	75	2	976399	
10.00	8.0	16	10	75	2	976410	301965
10.00 >	12.0	35	10	75	2	976411	
10.00 >	12.0	75	10	125	2	976412	
11.00	12.0	38	12	83	2	976413	
12.00	10.0	20	12	83	2	976414	301966
12.00 >	12.0	38	12	83	2	976415	
12.00 >	12.0	75	12	125	2	976416	
14.00	12.0	24	14	83	2	976417	
14.00 >	12.0	38	14	83	2	976418	
14.00 >	12.0	75	14	125	2	976419	
16.00	14.0	28	16	92	2	976420	
16.00 >	14.0	42	16	92	2	976421	
16.00 >	14.0	75	16	125	2	976422	
20.00	18.0	36	20	104	2	976423	
20.00 >	18.0	50	20	125	2	976424	

CBN ▲



DIXI 70520 PCD

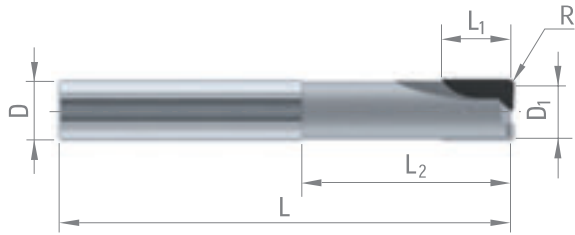
Z = 1-2



P. 380



$D_1 \geq \varnothing 6$



D_{1h10}	L_1	L_2	D_{h5}	L	R	Z	
1.00	2.0	-	6	42	0.1	1	984384
2.00	3.0	6	6	42	0.1	1	967923
2.00 >	3.0	6	6	42	0.2	1	973528
3.00	4.0	15	6	75	0.1	2	987438
3.00 >	4.0	15	6	75	0.3	2	305810
4.00	4.0	8	6	50	0.1	1	967925
4.00 >	6.5	10	6	50	0.5	2	971465
4.00 >	6.5	15	6	75	0.1	2	305811
4.00 >	6.5	15	6	75	0.5	2	302378
5.00	5.0	10	6	50	0.1	2	305812
5.00 >	5.0	10	6	50	0.5	2	975839
6.00	6.0	12	6	57	0.1	2	967926
6.00 >	6.0	12	6	57	0.5	2	968992
6.00 >	8.0	34	6	75	0.1	2	995208
6.00 >	8.0	34	6	75	0.5	2	974475
6.00 >	8.0	34	6	75	1.0	2	974476
8.00	7.0	14	8	63	0.1	2	967927
8.00 >	10.0	34	8	75	0.5	2	974477
8.00 >	10.0	34	8	75	1.0	2	974478
10.00	12.0	35	10	75	0.1	2	953153
10.00 >	12.0	35	10	75	0.5	2	974479
10.00 >	12.0	35	10	75	1.0	2	974480
10.00 >	12.0	75	10	125	0.5	2	974482
10.00 >	12.0	75	10	125	1.0	2	974481
12.00	10.0	20	12	83	0.1	2	984083
12.00 >	12.0	38	12	83	0.5	2	974483
12.00 >	12.0	38	12	83	1.0	2	974484
12.00 >	12.0	75	12	125	0.5	2	974485
12.00 >	12.0	75	12	125	1.0	2	974486
14.00	12.0	24	14	83	0.1	2	305814
14.00 >	12.0	24	14	83	0.5	2	305816
14.00 >	12.0	24	14	83	1.0	2	305817
16.00	14.0	28	16	92	0.1	2	993052
16.00 >	14.0	42	16	92	0.5	2	305818
16.00 >	14.0	42	16	92	1.0	2	305139
20.00	18.0	36	20	104	0.1	2	987718
20.00 >	18.0	36	20	104	0.5	2	305919
20.00 >	18.0	36	20	104	1.0	2	305820

CVD ■

CBN ▲

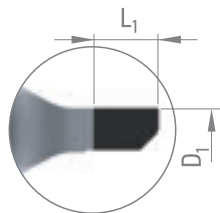
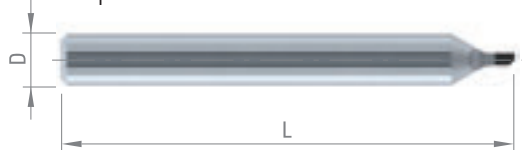
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DIXI 70600 PCD

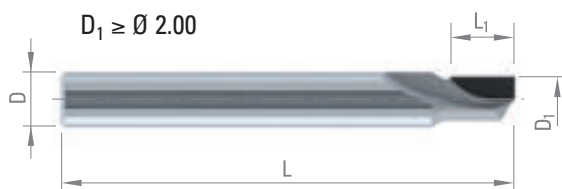


Z = 1

$D_1 < \emptyset 2.00$



$D_1 \geq \emptyset 2.00$



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D_{1h10}	L_1	D_{h5}	L	
1.00	2.0	6	35	302387
2.00	3.0	6	35	302388
3.00	4.0	6	42	302389
4.00	6.5	6	42	302390
5.00	6.5	6	50	302391
6.00	8.0	6	50	302393

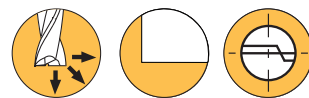
DIXI 70600 DIA



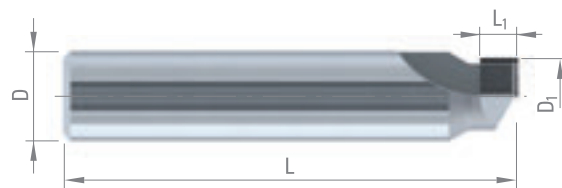
Z = 1



P. 380



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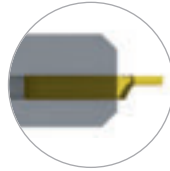
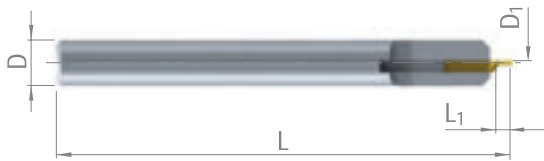
D_1	L_1	D_{h5}	L	DIA
3.00	2.5	6	30	302394
4.00	2.5	6	30	302395
5.00	2.5	6	30	302396
6.00	2.5	6	30	302397

DIXI 72310 DIA

Z = 1



P. 380



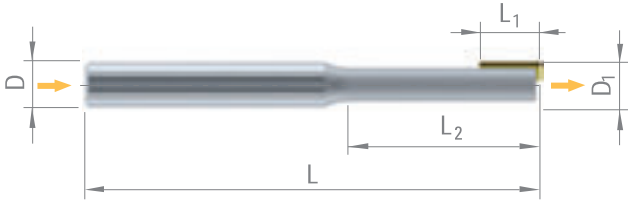
D ₁	L ₁	D _{h5}	L	DIA
0.30	0.6	3	30	953423
0.40	0.8	3	30	953424
0.50	1.0	3	30	953425
0.60	1.2	3	30	953426
0.70	1.4	3	30	953427
0.80	1.6	3	30	953428
0.90	1.8	3	30	953429
1.00	2.5	3	30	953430
1.10	2.5	3	30	953431
1.20	2.5	3	30	953432
1.30	2.5	3	30	953433
1.40	2.5	3	30	953434
1.50	2.5	3	30	953435
1.60	2.5	3	30	953436
1.70	2.5	3	30	953437
1.80	2.5	3	30	953438
1.90	2.5	3	30	953439
2.00	2.5	6	30	953440

DIXI 72421 DIA

Z = 1



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D ₁	L ₁	L ₂	D _{h5}	L	DIA
6.00	4	25	6	57	970120
6.00	6	25	6	57	970122
6.00	8	25	6	57	974360
8.00	4	25	8	63	970126
8.00	6	25	8	63	970128
8.00	8	25	8	63	970129
10.00	4	25	10	75	974317
10.00	6	25	10	75	974318
10.00	8	25	10	75	974319
12.00	4	25	12	83	974321
12.00	6	25	12	83	974322
12.00	8	25	12	83	974323



Z = 1-2

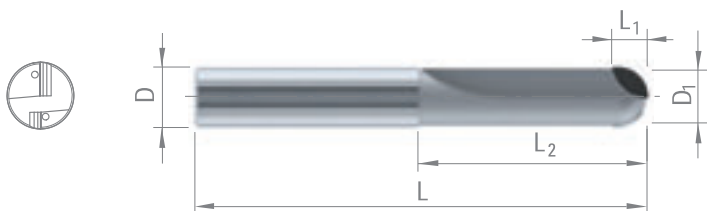


P. 380



> Ø 6





D ₁ h10	L ₁	L ₂	D	L	Z	
2.00	2.0	6.0	6	42	1	953442
2.00	2.0	25.0	6	75	1	970874
3.00	2.5	6.0	6	42	1	953443
3.00	2.5	25.0	6	75	1	970875
3.00	2.5	25.0	6	75	2	970876
4.00	3.0	8.0	6	50	1	959468
4.00	3.0	10.0	6	50	1	953444
4.00	3.0	10.0	6	50	2	970877
4.00	3.0	25.0	6	75	2	970878
4.00	3.0	35.0	6	75	2	981585
5.00	4.0	10.0	6	50	2	953445
5.00	4.0	25.0	6	75	2	970883
6.00	4.0	12.0	6	57	2	976433
6.00	4.0	34.0	6	75	2	976434
6.00	4.0	50.0	6	100	2	976435
8.00	5.0	14.0	8	63	2	976436
8.00	5.0	34.0	8	75	2	976437
8.00	5.0	75.0	8	125	2	976438
10.00	6.0	16.0	10	72	2	976439
10.00	6.0	35.0	10	75	2	976440
10.00	6.0	75.0	10	125	2	976441
12.00	7.0	20.0	12	83	2	976442
12.00	7.0	38.0	12	83	2	976443
12.00	7.0	75.0	12	125	2	976444
14.00	8.0	24.0	14	83	2	305821
16.00	9.0	28.0	16	92	2	300800
20.00	11.0	36.0	20	104	2	305822

CVD ■

CBN ▲

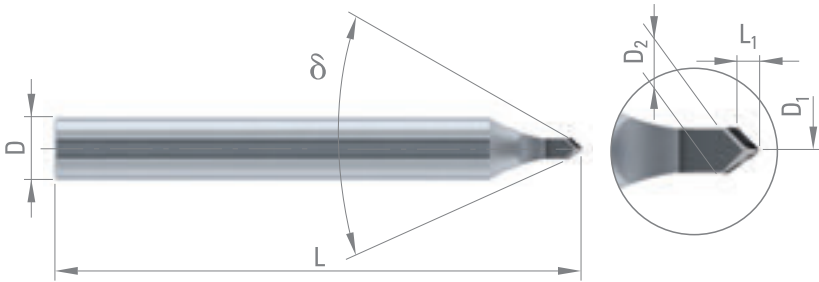
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DIXI 76230 DIA



Z = 1

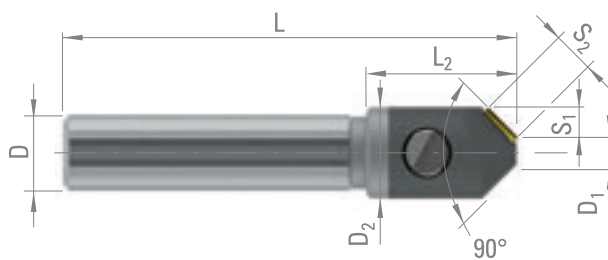


D_1	L_1	D_2	δ	D_{h5}	L	DIA
* 0.10	1.40	3	60°	6	50	302596
* 0.10	0.80	3	90°	6	50	302595
* 0.30	2.80	2	30°	6	50	978382
* 0.30	1.30	3	60°	6	50	978381
* 0.30	0.70	3	90°	6	50	977871

DIXI 76230



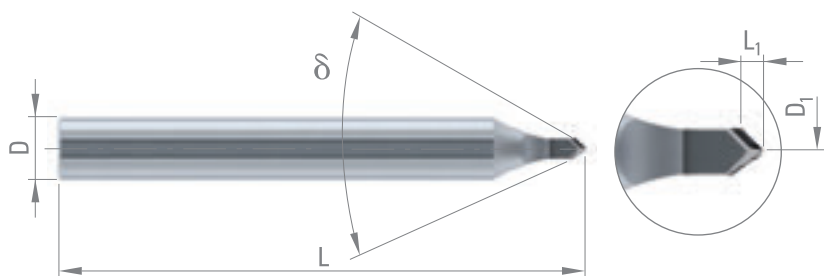
Z = 1



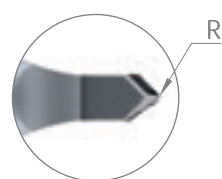
D_1	D_2	L_2	S_1	S_2	D_{h5}	L	DIA
4	10	-	3	4.10	10	60	◆
4	12	20	4	5.50	10	60	◆
4	14	20	5	7.00	10	60	◆
4	16	20	6	8.50	10	60	◆

DIXI 70170 DIA - 70180 DIA

Z = 1

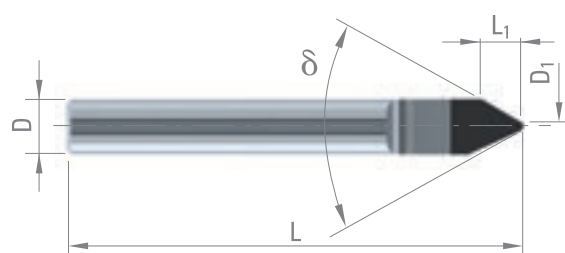


D_1	L_1	δ	D_{h5}	L	DIA
0.05	1.40	60°	6	50	302597
0.10	1.40	60°	6	50	302598
0.05	0.80	90°	6	50	302599
0.10	0.80	90°	6	50	302600



DIXI 70170 PCD - 70180 PCD

Z = 1



D_1	L_1	δ	D_{h5}	L	
0.10	5	60°	6	50	303081
0.20	5	60°	6	50	303082
0.10	3	90°	6	50	303083
0.20	3	90°	6	50	303084

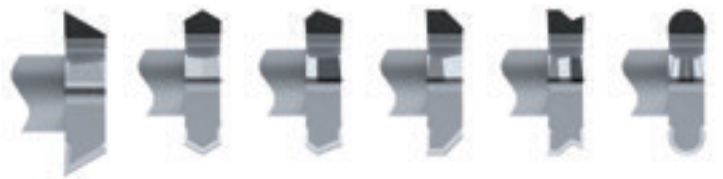
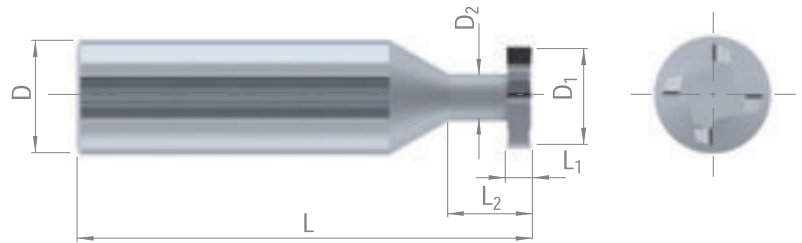




DIXI 15150



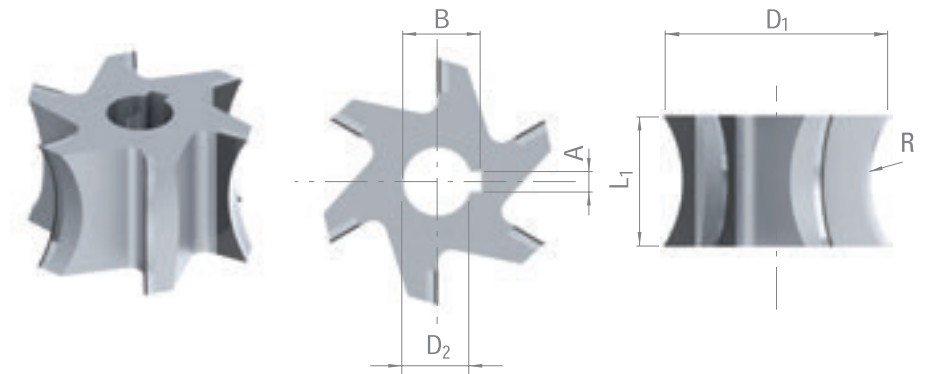
Z = _____
D = _____
D₁ = _____
D₂ = _____
L = _____
L₁ = _____
L₂ = _____
R = _____



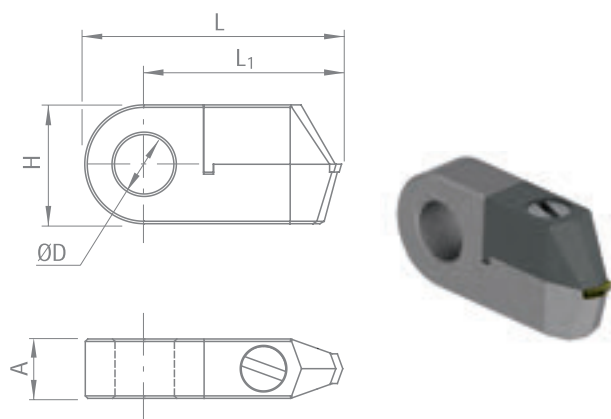
DIXI 16560



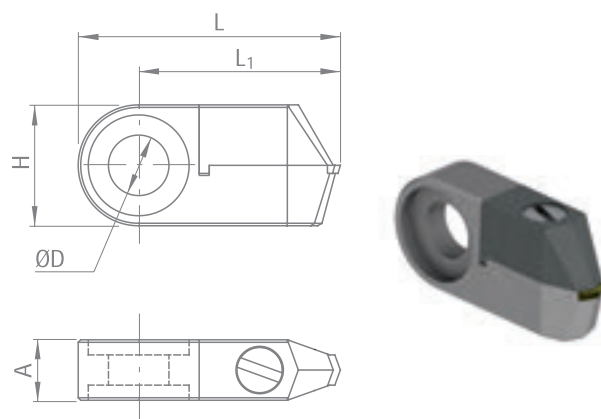
D₁ = _____
D₂ = _____
L₁ = _____
R = _____
A = _____
B = _____



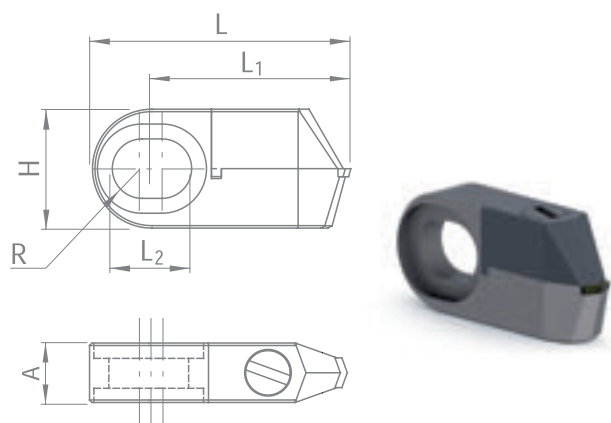
Ref. A



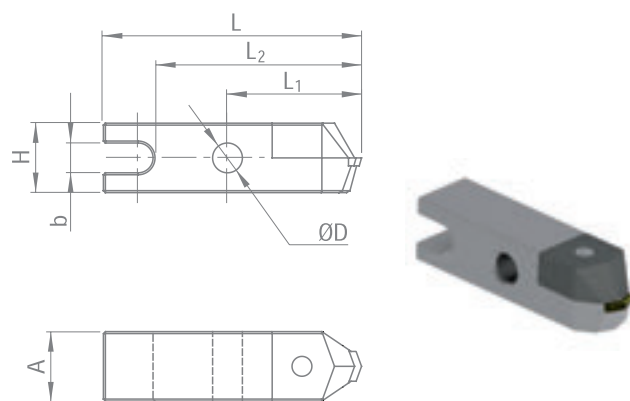
Ref. B



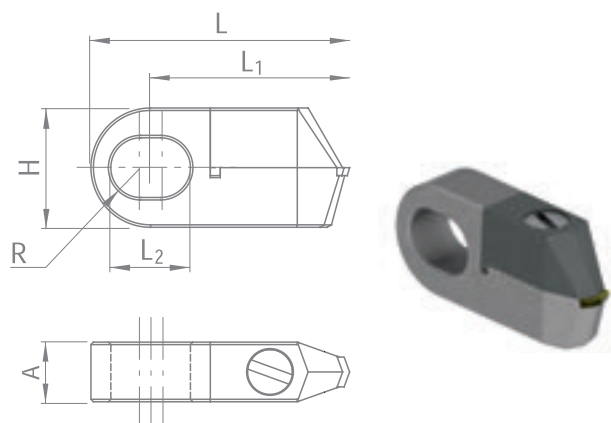
Ref. C



Ref. D



Ref. E



DIXI 81000



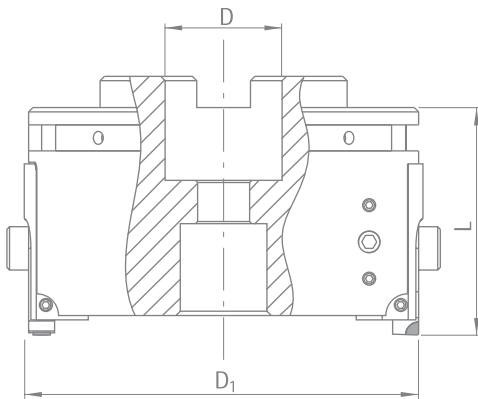
P. 382



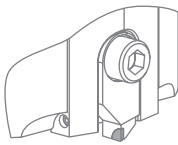
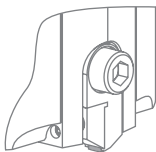
D ₁	D	L	Art.
60	22	50	996583
85	22	48	996583
100	27	55	964272

D ₁	D	L	Art.
40	16	55	970446
50	16	45	971872
60	22	40	962823

D ₁	D	L	Art.
40	12	55	996583



968117
969556
968526
969557



968117

DIXI 20370

Ref. 1



Ref. 2



Ref. 3



Ref. 4



968179
968181
974193
968178



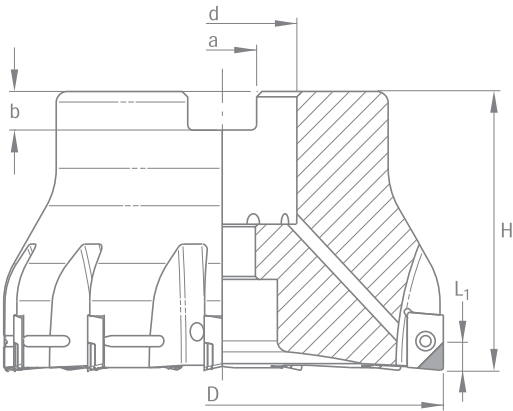
DIXI 80000



Z = 6-16



P. 382

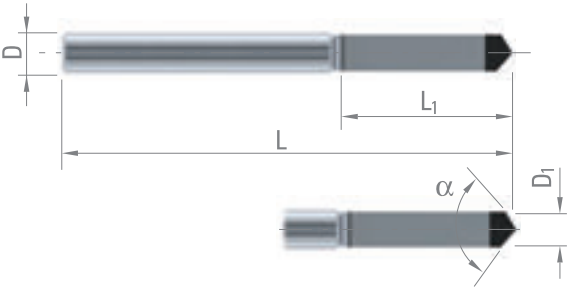


40.00	3.0	40	8.4	6.6	16	6	0.20
50.00	3.0	40	10.4	7.2	22	7	0.35
63.00	3.0	40	10.4	7.2	22	8	0.60
80.00	3.0	50	12.4	7.2	27	11	1.20
100.00	3.0	50	14.4	8.2	32	13	2.00
125.00	3.0	50	16.4	9.0	32	16	2.20

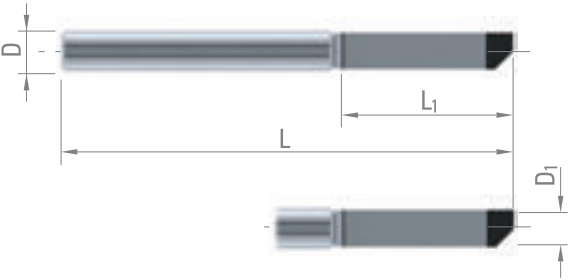
DIXI 11140 - 11180



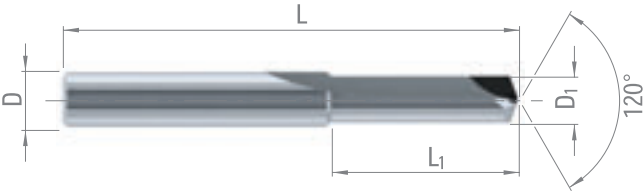
DIXI 11140 A - PCD



DIXI 11140 B - PCD



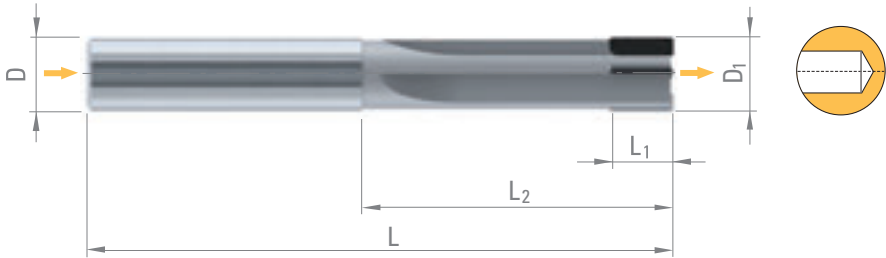
DIXI 11180 - PCD



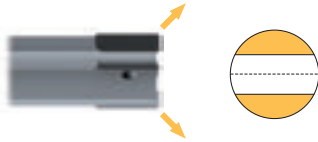
POLY 40010



POLY 40010-2



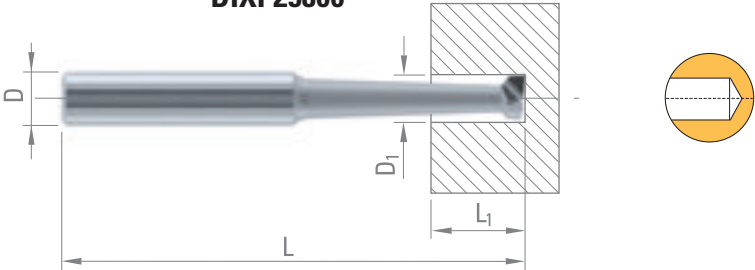
POLY 40010-3



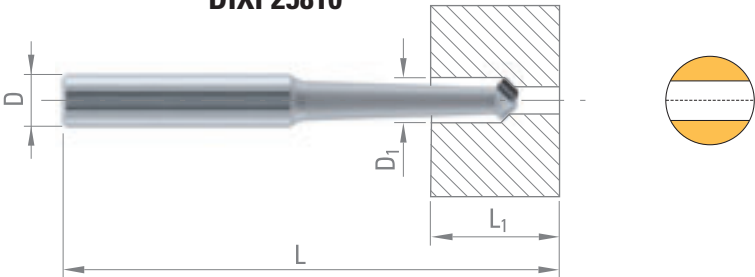
D ₁	L ₁	L ₂	D _{h5}	L	Z	CBN
8.000 - 9.100	7	34	8	64	4	● ▲
9.102 - 10.100	7	44	10	80	4	● ▲
10.101 - 11.100	7	44	10	80	4	● ▲
11.101 - 12.300	7	63	12	108	4	● ▲
12.300 - 13.100	7	63	12	108	4	● ▲
13.101 - 14.500	7	58	16	108	4	● ▲
14.501 - 16.100	7	58	16	108	4	● ▲
16.101 - 18.100	7	58	16	108	4	● ▲
18.101 - 20.500	7	58	20	108	4	● ▲
20.501 - 22.100	7	58	20	108	4	● ▲

DIXI 25800 - 25810

DIXI 25800



DIXI 25810

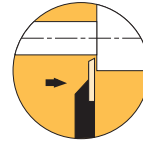


DIXI 20160-20770

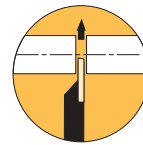
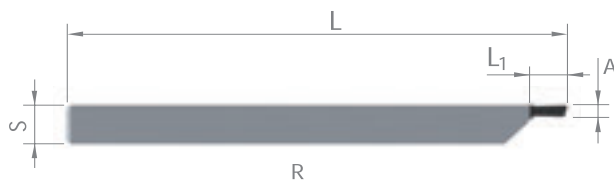


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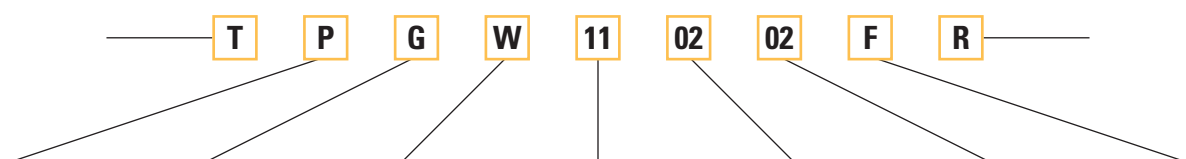
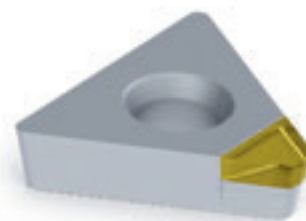
DIXI 20610



DIXI 20770



DIXI 264X0



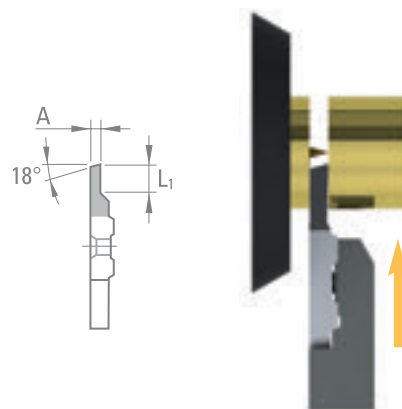
ARTDECO 26500 R



P. 384

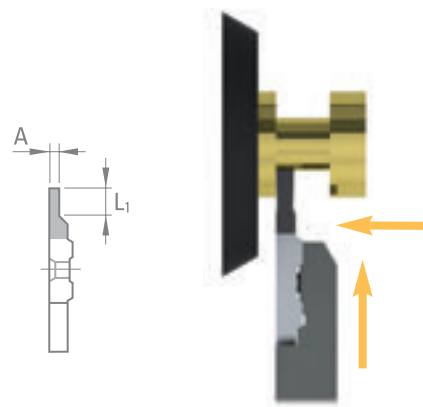
ARTDECO 26500 TR

R	A	L ₁		
TR06R-0.8	0.8	3.0	976284	303109
TR06R-1.0	1.0	4.0	976286	303111
TR06R-1.2	1.2	5.0	976288	303113
TR06R-1.5	1.5	5.0	976290	303115
TR06R-1.8	1.8	6.0	976292	303117
TR06R-2.0	2.0	6.0	976294	303119



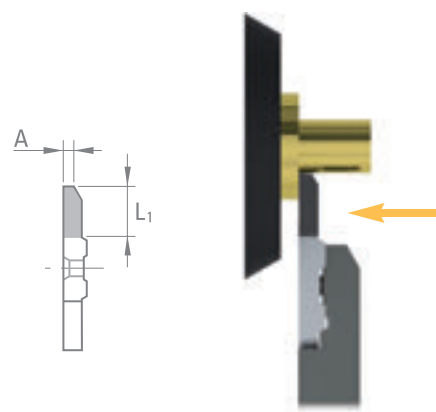
ARTDECO 26500 FT

R	A	L ₁		
FT06R-2.0	2.0	4.0	976278	303103



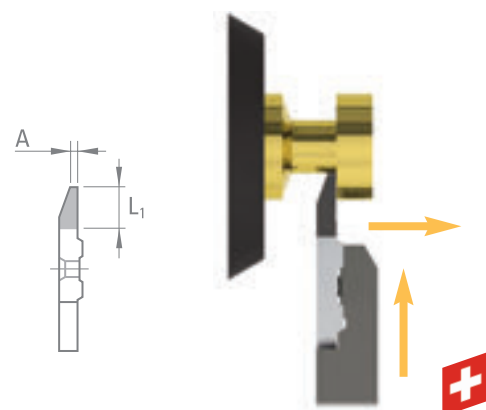
ARTDECO 26500 AV

R	A	L ₁		
AV06R-1.5	1.5	5.0	976280	303105



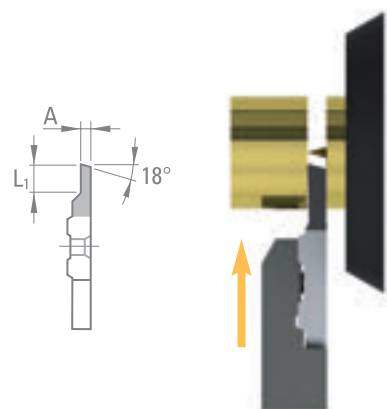
ARTDECO 26500 AR

R	A	L ₁		
AR06R-1.0	1.0	5.0	976282	303107

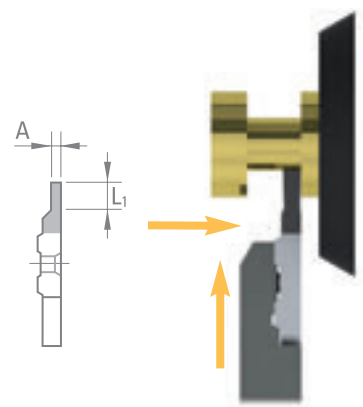



ARTDECO 26500 TR

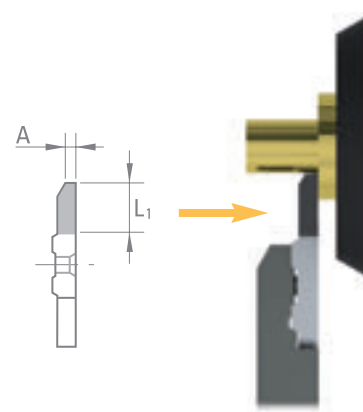
L	A	L ₁		
TR06L-0.8	0.8	3.0	976285	303110
TR06L-1.0	1.0	4.0	976287	303112
TR06L-1.2	1.2	5.0	976289	303114
TR06L-1.5	1.5	5.0	976291	303116
TR06L-1.8	1.8	6.0	976293	303118
TR06L-2.0	2.0	6.0	976295	303120


ARTDECO 26500 FT

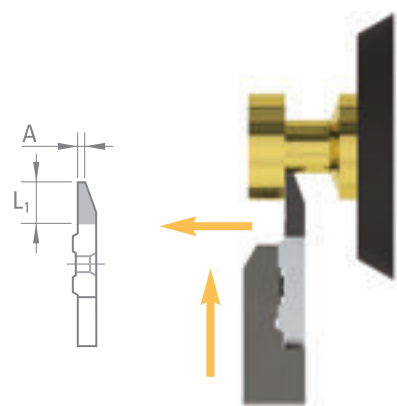
L	A	L ₁		
FT06L-2.0	2.0	4.0	976279	303104


ARTDECO 26500 AV

L	A	L ₁		
AV06L-1.5	1.5	5.0	976281	303106


ARTDECO 26500 AR

L	A	L ₁		
AR06L-1.0	1.0	5.0	976283	303108





0606R-130	6	06	64940
0706R-130	7	06	64942
0806R-130	8	06	64944
1006R-130	10	06	64946
1206R-130	12	06	64948
1606R-130	16	06	64950



0606L-130	6	06	64941
0706L-130	7	06	64943
0806L-130	8	06	64945
1006L-130	10	06	64947
1206L-130	12	06	64949
1606L-130	16	06	64959



Torx 8 Art. 65785





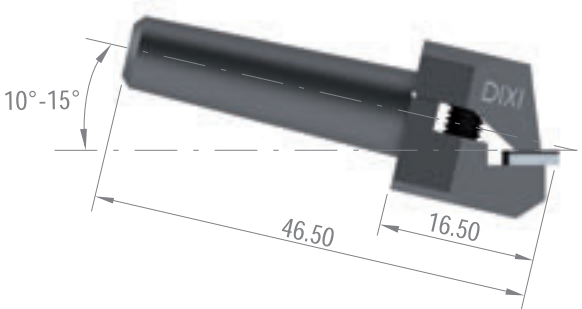
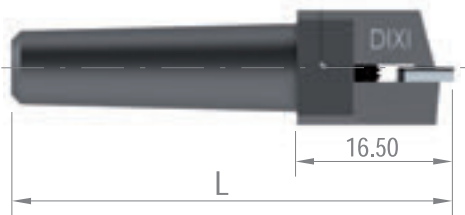
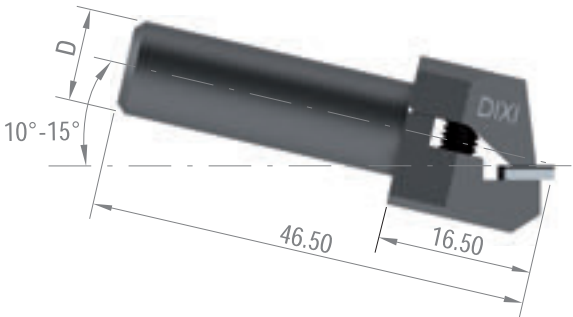
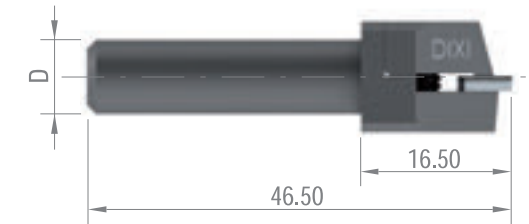
DIXI 1973

Ref.	D	Art.
DIXI 1973.0823	8	19459
DIXI 1973.1023	10	18512
DIXI 1973.1223	12	19979

Ref.	D	Art.
DIXI 1973.1013	10	23707

DIXI 1973.0023	CM0	46.5	18737
DIXI 1973.0123	CM1	59.5	18514

DIXI 1973.0013	CM0	23850
DIXI 1973.0113	CM1	23727



DIXI 1978



DIXI 1978.360°	23829
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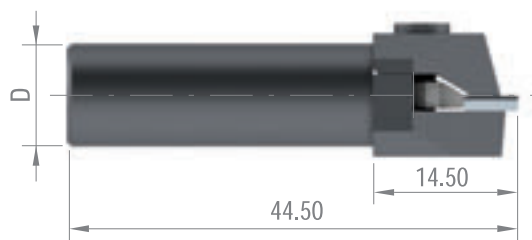
DIXI 1978.23	18814
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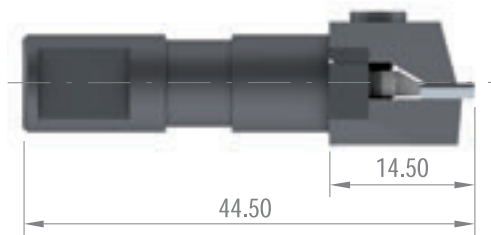
DIXI 1973



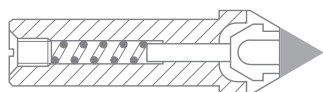
Ref.	D	Art.
DIXI 1973.1025	10	24550



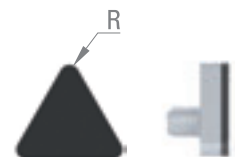
Ref.	Art.
DIXI 1973.0925-1	24549



DIXI 1973.0125	CM1	36.5	26549
DIXI 1973.0125	CM1	58.5	24551



DIXI 1978



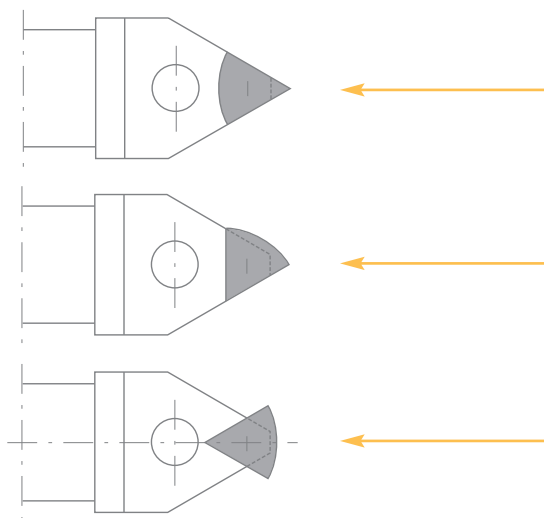
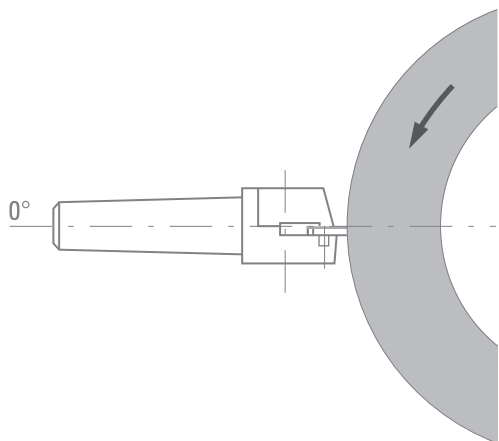
Ref.	PCD	CVD
DIXI 1978.2500	24623	973739

Ref.	R	PCD	CVD
DIXI 1978.2512	0.125	24624	973736
DIXI 1978.2520	0.200	24625	973732
DIXI 1978.2525	0.250	24626	973737
DIXI 1978.2550	0.500	24627	973738





I	1	J	1	K	1	L	1	M	1
I	2	J	2	K	2	L	2	M	2
I	3	J	3	K	3	L	3	M	3
I	4	J	4	K	4	L	4	M	4
I	5	J	5	K	5	L	5	M	5
I	6	J	6	K	6	L	6	M	6
I	7	J	7	K	7	L	7	M	7
I	8	J	8	K	8	L	8	M	8
I	9	J	9	K	9	L	9	M	9
I	10	J	10	K	10	L	10	M	10
	•	•	•	•	•	•	•	•	•
	•	•	•	•	•	•	•	•	•
	•	•	•	•	•	•	•	•	•



DIXI 72310 DIA

N		400	800	
N		300	700	
N		500	2000	
N		400	1800	
N		400	1500	
N		500	1500	
N		200	750	

DIXI 70600 - 70320 - 70520 - 72420 - 72421

H					160	280
K					160	280
N		200 1000	400 1200	400 800		
N		100 1500	200 1700	300 700		
N		700 3000	400 1200	500 2000		
N		300 3500	400 1200	400 1800		
N		100 3000	200 900	400 1200		
N		200 1000	400 1200			
N		200 1000	400 1200			
N		500 2000	400 1200	500 1500		
N		1000 3000	400 1200			
N		300 1000	400 1200	200 750		



$$n \text{ [tr/min]} = \frac{V_c \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

$f_z \text{ [mm]}$

0.0005 - 0.005	0.005 - 0.03	
0.0005 - 0.005	0.005 - 0.03	
0.0005 - 0.005	0.005 - 0.03	
0.0005 - 0.005	0.005 - 0.03	
0.0005 - 0.005	0.005 - 0.03	
0.0005 - 0.005	0.005 - 0.03	
0.0005 - 0.005	0.005 - 0.03	

0.10 - 0.15	≤ 0.5 x D	≤ 0.5 x D	0.10 - 0.30	0.10 - 0.30	max. = 0.05	
0.10 - 0.20	≤ 0.6 x D	≤ 0.6 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.25	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.20	≤ 0.6 x D	≤ 0.6 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.25	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.20	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.40		
0.05 - 0.20	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.20	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.025 - 0.125	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.30	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.30	≤ 1 x D	≤ 1 x D	0.10 - 0.30	0.10 - 0.30		
0.05 - 0.25	≤ 0.6 x D	≤ 0.6 x D	0.10 - 0.30	0.10 - 0.30		



DIXI 80000

H				350	700	
K				500	1600	
N		< 3000	< 3000			
N		< 3000	< 3000			
N		< 7000	< 7000			
N		< 6000	< 6000			
N		< 5000	< 5000			

DIXI 81000

N		400	800	
N		300	700	
N		500	2000	
N		400	1800	
N		400	1200	
N		500	1500	
N		200	750	



$$n \text{ [tr/min]} = \frac{V_c \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

ap [mm]	fz [mm]	
0.20 - 1.00	0.04 - 0.12	
0.20 - 1.50	0.08 - 0.15	
0.10 - 3.50	0.05 - 0.25	
0.10 - 3.50	0.05 - 0.25	
0.10 - 3.50	0.05 - 0.25	
0.10 - 3.50	0.05 - 0.25	
0.10 - 3.50	0.05 - 0.25	

ap [mm]	fz [mm]	
< 2	0.02 - 0.2	
< 2	0.02 - 0.2	
< 2	0.02 - 0.2	
< 2	0.02 - 0.2	
< 2	0.02 - 0.2	
< 2	0.02 - 0.2	



H					100	200	
K					200	600	
N		300	1000	300	1000	300	1000
N		250	800	250	800	250	800
N		300	1000	300	1000	300	1000
N		300	1000	300	1000	300	1000
N		250	800	250	800	250	800
N		80	1500	80	1500		
N		100	800	100	800		
N		100	600	100	600	100	600
N		100	600	100	600		
N		300	1000	300	1000	300	1000



$$n \text{ [tr/min]} = \frac{V_c \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

< 3	0.05 - 0.20			
< 3	0.05 - 0.70			
< 10	0.05 - 0.50	< 0.05	0.05 - 0.50	
< 6	0.05 - 0.50	< 0.05	0.05 - 0.50	
< 10	0.05 - 0.50	< 0.05	0.05 - 0.50	
< 10	0.05 - 0.50	< 0.05	0.05 - 0.50	
< 6	0.05 - 0.50	< 0.05	0.05 - 0.50	
< 10	0.05 - 0.50			
< 5	0.05 - 0.20			
< 10	0.10 - 0.60	< 0.05	0.10 - 0.60	
< 3	0.05 - 0.60			
< 6	0.05 - 0.50	< 0.05	0.05 - 0.50	

