

Workpiece material	Insert Grade	Tool D/Flutes Parameter	D 8/Z1	D 10/Z2	D 12/Z3	D 16/Z4	D 20/Z5	D 25/Z6	D 32/Z8
Hardened steel 45-55 HRC	PJP08M PJP15M	V <sub>c</sub> m/min	110	110	110	110	110	110	110
		n min <sup>-1</sup>	4,380	3,500	2,920	2,190	1,750	1,400	1,090
		f <sub>z</sub> mm/t	0.4	0.5	0.5	0.5	0.5	0.5	0.5
		V <sub>f</sub> mm/min	1,750	3,500	4,380	4,380	4,370	4,200	4,360
		a <sub>p</sub> mm	0.2	0.3	0.3	0.3	0.3	0.3	0.3
		a <sub>e</sub> mm	4.5	6	7	9.5	12	15	19
		Q cm <sup>3</sup> /min	1.6	6.3	9.2	12.5	15.7	18.9	24.9
Hardened steel 55-60 HRC	PJP08M	V <sub>c</sub> m/min	75	75	75	75	75	75	75
		n min <sup>-1</sup>	2,990	2,390	1,990	1,490	1,190	960	750
		f <sub>z</sub> mm/t	0.3	0.4	0.4	0.4	0.4	0.4	0.4
		V <sub>f</sub> mm/min	890	1,910	2,380	2,380	2,380	2,300	2,400
		a <sub>p</sub> mm	0.15	0.2	0.2	0.2	0.2	0.2	0.2
		a <sub>e</sub> mm	3	4	5	6.5	8	10	13
		Q cm <sup>3</sup> /min	0.4	1.5	2.4	3.1	3.8	4.6	6.2
Hardened steel 60-62 HRC	PJP08M	V <sub>c</sub> m/min	65	65	65	65	65	65	65
		n min <sup>-1</sup>	2,590	2,070	1,730	1,290	1,040	830	650
		f <sub>z</sub> mm/t	0.25	0.3	0.3	0.3	0.3	0.3	0.3
		V <sub>f</sub> mm/min	640	1,240	1,550	1,540	1,560	1,490	1,560
		a <sub>p</sub> mm	0.15	0.15	0.15	0.15	0.15	0.15	0.15
		a <sub>e</sub> mm	3	4	5	6.5	8	10	13
		Q cm <sup>3</sup> /min	0.3	0.7	1.2	1.5	1.9	2.2	3.0
Graphite	D08M	V <sub>c</sub> m/min	up to 1,000	up to 1,000	up to 1,000	up to 1,000	up to 1,000	up to 1,000	up to 1,000
		n min <sup>-1</sup>	up to 39,800	up to 31,800	up to 26,500	up to 19,900	up to 15,900	up to 12,700	up to 9,900
		f <sub>z</sub> mm/t	up to 0.4	up to 0.4	up to 0.4	up to 0.4	up to 0.4	up to 0.4	up to 0.4
		V <sub>f</sub> mm/min	up to 15,900	up to 25,400	up to 31,800	up to 31,800	up to 31,800	up to 30,000	up to 31,600
		a <sub>p</sub> mm	up to 1.0	up to 1.0	up to 1.0	up to 1.0	up to 1.0	up to 1.0	up to 1.0
		a <sub>e</sub> mm	up to 4	up to 5	up to 7	up to 11	up to 15	up to 20	up to 25
		Q cm <sup>3</sup> /min	up to 31.8	up to 63.5	up to 111.3	up to 174.9	up to 238.5	up to 300	up to 395

## Product Range

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