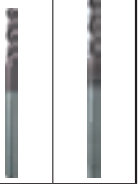
≤4×D ≤7×D

Tool material	Carbide	Carbide
Carbide grade	K/P	K/P
Type	N	N
Surface finish	A	A
Guh. no. straight DIN 1899 R		
Guh. no. straight DIN 1899 L		
G.S. R	6400	6401
Internal cooling	☒	☒



v_c m/min	Feed column no.	
90-120	64	62
90-110	64	62
90-120	64	62
80-100	63	61
80-110	64	62
80-110	64	62
80-100	63	61
80-100	63	61
60-80	62	60
90-110	63	61
70-100	63	61
60-80	62	60
60-80	62	60
50-70	62	60
40-60	62	60
40-60	62	60
40-60	57	57
40-60	57	57
30	57	57
15	56	56
30	57	57
10	56	56
<150	68	66
<140	68	66
<140	68	66
<130	67	65
15	56	56
15	56	56
60-80	68	68
60-80	68	68
120-150	59	59
120-150	59	59

≤8×D ≤15×D

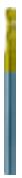
Tool material	Carbide	Carbide
Carbide grade	K/P	K/P
Type	N	N
Surface finish	A	A
Guh. no. straight DIN 1899 R		
Guh. no. straight DIN 1899 L		
G.S. R	6408	6412
Internal cooling	■	■

v_c m/min	Feed column no.	
90-120	58	58
90-110	58	58
90-120	59	59
80-100	59	59
80-110	58	58
80-110	58	58
80-100	58	58
80-100	58	58
60-80	58	58
90-110	57	57
70-100	58	58
60-80	58	58
60-80	57	57
50-70	57	57
40-60	58	58
40-60	58	58
40-60	57	57
40-60	57	57
60-80	57	57
60	56	56
60-80	57	57
25	56	56
<150	60	60
<140	60	60
<140	60	60
<130	60	60
35	56	56
35	56	56
60-80	68	68
60-80	68	68
120-150	59	59
120-150	59	59

Tool material	HSS-E-PM
Carbide grade	–
Type	N
Surface finish	○
Guh. no. straight DIN 1899 R	301
Guh. no. straight DIN 1899 L	303
G.S. R	
Internal cooling	

v_c m/min	Feed column no.
21	6
18	5
18	6
16	5
20	5
18	5
14	4
14	4
12	3
18	6
14	4
12	3
14	4
12	3
16	4
14	3
14	3
8	2
18	4
14	3
16	3
26	6
22	6
18	6
22	6
26	7
18	6
75	6
42	5
22	5
22	4
18	4
13	4
16	4
18	4

Tool material	HSS-E-PM
Carbide grade	–
Type	N
Surface finish	Ⓢ
Guh. no. straight DIN 1899 R	660
Guh. no. straight DIN 1899 L	
G.S. R	
Internal cooling	



v_c m/min	Feed column no.
27	6
23	5
23	6
21	5
26	5
23	5
18	4
18	4
16	3
23	6
18	4
16	3
18	4
16	3
20	4
18	3
18	3
10	2
20	4
16	3
18	3
33	6
28	6
23	6
28	6
80	6
53	5
28	5
28	4
23	4
16	4
14	4
20	4
23	4

Tool material	Carbide
Carbide grade	K10/K20
Type	N
Surface finish	○
Guh. no. straight DIN 1899 R	
Guh. no. straight DIN 1899 L	
G.S. R	701
Internal cooling	

v_c m/min	Feed column no.
50	5
35	4
50	5
45	4
45	4
35	4
30	3
30	3
50	3
40	3
25	3
25	3
20	2
25	3
25	2
25	2
15	4
15	3
80	5
60	5
60	5
50	5
45	4
25	4
160	7
150	6
100	6
60	6
150	5
50	5
67	6
44	4
68	3
49	3
53	3
36	3
50	3
36	3
60	4

Ⓐ AlTiN Ⓒ TiCN Ⓕ FIRE Ⓟ AlCrN Ⓢ TiN Ⓜ MolyGlide