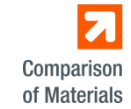


ZBGF-H-2xD-IKZ-HE-TiAlN-T3

solid carbide circular drill thread mills



| applications – material | | cutting speed vc in m/min | fz in mm |
|---|---------------------------|---------------------------------|-------------|
| N2.7 Special copper alloys | <= 600 N/mm ² | 40 - 60 | 0,02 - 0,04 |
| N2.8 Special copper alloys | <= 1400 N/mm ² | 40 - 60 | 0,02 - 0,04 |
| H1.1 High strength steels, hardened steels, hard castings | 44 – 50 HRC | 60 - 100 | 0,03 - 0,06 |
| H1.2 High strength steels, hardened steels, hard castings | 50 – 55 HRC | 60 - 100 | 0,03 - 0,06 |
| H1.3 High strength steels, hardened steels, hard castings | 55 – 60 HRC | 40 - 70 | 0,02 - 0,04 |
| H1.4 High strength steels, hardened steels, hard castings | 60 – 63 HRC | 30 - 60 | 0,02 - 0,04 |
| H1.5 High strength steels, hardened steels, hard castings | 63 – 66 HRC | 30 - 60 | 0,02 - 0,04 |