

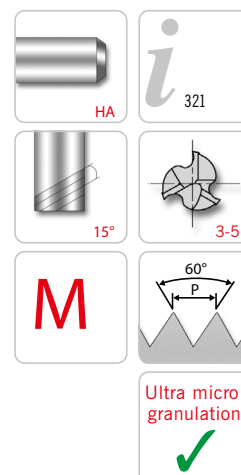
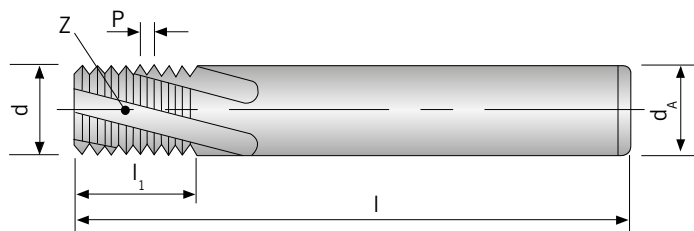
SOLID CARBIDE THREAD MILLS FOR STEEL, ALUMINIUM AND NON-FERROUS MATERIALS.

Fine grain solid carbide cutters with TiAlN coating,
some with through tool coolant and chamfering edge.



AFT525.1-ISO-...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l	z	HC
								TAIN
AFT52531-ISO-M3X0.5	M3	0.50	2.2	6	5.00	57	3	◆
AFT52531-ISO-M4X0.7	M4	0.70	2.9	6	7.00	57	3	◆
AFT52531-ISO-M5X0.8	M5	0.80	3.8	6	8.00	57	3	◆
AFT52531-ISO-M6X1.0	M6	1.00	4.5	6	13.00	57	3	◆
AFT52531-ISO-M8X1.25	M8	1.25	6.0	6	17.50	65	3	◆
AFT52541-ISO-M10X1.5	M10	1.50	7.5	8	21.00	72	4	◆
AFT52541-ISO-M12X1.75	M12	1.75	9.5	10	26.25	80	4	◆
AFT52541-ISO-M14X2.0	M14	2.00	10.0	10	30.00	83	4	◆
AFT52541-ISO-M16X2.0	M16	2.00	12.0	12	34.00	92	4	◆
AFT52551-ISO-M18X2.5	M18	2.50	14.0	14	37.50	92	5	◆
AFT52551-ISO-M20X2.5	M20	2.50	16.0	16	42.50	105	5	◆

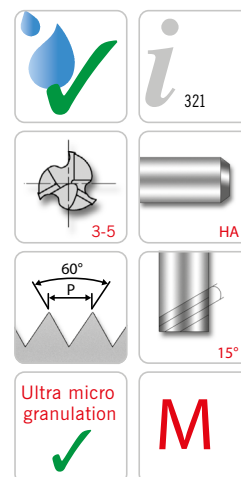
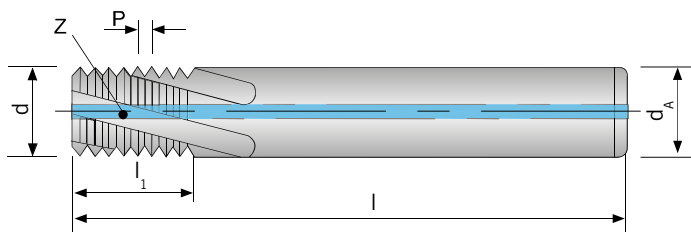
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-ISO-...IK ...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l	z	HC
								TAIN
AFT52531-ISO-M6X1.0IK	M6	1.00	4.5	6	13.00	57	3	◆
AFT52531-ISO-M8X1.25IK	M8	1.25	6.0	6	17.50	65	3	◆
AFT52541-ISO-M10X1.5IK	M10	1.50	7.5	8	21.00	72	4	◆
AFT52541-ISO-M12X1.75IK	M12	1.75	9.5	10	26.25	80	4	◆
AFT52541-ISO-M14X2.0IK	M14	2.00	10.0	10	30.00	83	4	◆
AFT52541-ISO-M16X2.0IK	M16	2.00	12.0	12	34.00	92	4	◆
AFT52551-ISO-M20X2.5IK	M20	2.50	16.0	16	42.50	105	5	◆

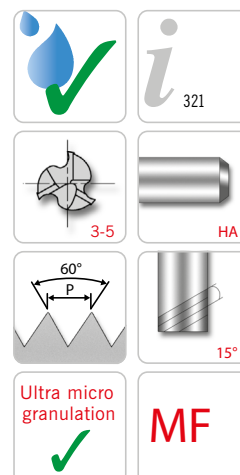
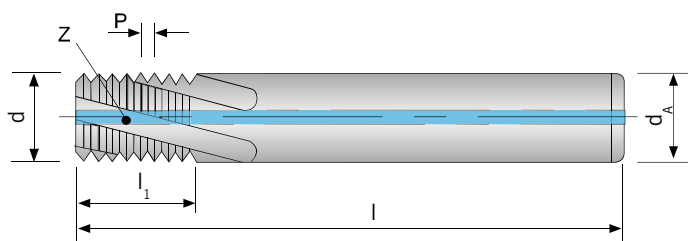
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-ISO-...IK- ...

3 - 5 flutes, 15 degree helix angle, short design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l	z	HC
								TAIN
AFT52530-ISO-M8X0.75IK	M8	0.75	6.0	6	12.75	57	3	◆
AFT52530-ISO-M8X1.0IK	M8	1.00	6.0	6	13.00	57	3	◆
AFT52540-ISO-M10X1.0IK	M10	1.00	8.0	8	16.00	63	4	◆
AFT52540-ISO-M12X1.0IK	M12	1.00	9.5	10	19.00	72	4	◆
AFT52540-ISO-M12X1.5IK	M12	1.50	9.5	10	19.50	72	4	◆
AFT52540-ISO-M12X1.25IK	M12	1.25	9.5	10	18.75	72	4	◆
AFT52540-ISO-M14X1.0IK	M14	1.00	10.0	10	22.00	83	4	◆
AFT52540-ISO-M14X1.5IK	M14	1.50	10.0	10	22.50	83	4	◆
AFT52540-ISO-M16X1.0IK	M16	1.00	12.0	12	25.00	83	4	◆
AFT52540-ISO-M16X1.5IK	M16	1.50	12.0	12	25.50	83	4	◆
AFT52550-ISO-M18X1.0IK	M18	1.00	14.0	14	28.00	92	5	◆
AFT52550-ISO-M18X1.5IK	M18	1.50	14.0	14	28.50	92	5	◆
AFT52550-ISO-M20X1.0IK	M20	1.00	16.0	16	31.00	92	5	◆
AFT52550-ISO-M20X1.5IK	M20	1.50	16.0	16	31.50	92	5	◆

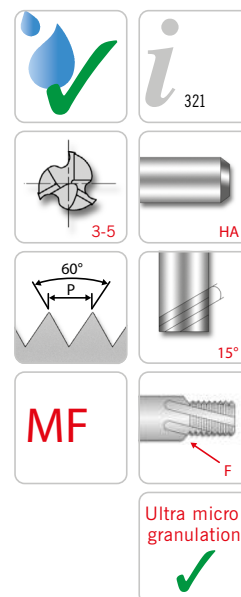
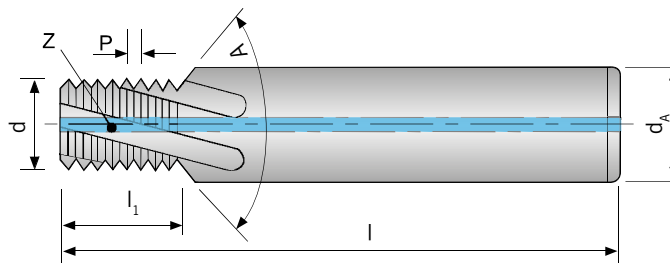
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.0-ISO-...IK-F ...

3 - 5 flutes, 15 degree helix angle, short design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l	A	z	HC	
									TAIN	Main application
AFT52530-ISO-M8X1.0IK-F	M8	1.00	6.7	10	12.40	74	90°	3		●
AFT52540-ISO-M10X1.0IK-F	M10	1.00	8.7	12	15.40	80	90°	4		●
AFT52540-ISO-M10X1.25IK-F	M10	1.25	8.3	12	15.90	80	90°	4		●
AFT52540-ISO-M12X1.0IK-F	M12	1.00	10.7	14	18.40	90	90°	4		●
AFT52540-ISO-M12X1.5IK-F	M12	1.50	10.0	14	18.65	90	90°	4		●
AFT52540-ISO-M12X1.25IK-F	M12	1.25	10.3	14	18.30	80	90°	4		●
AFT52540-ISO-M14X1.5IK-F	M14	1.50	12.0	16	21.65	100	90°	4		●
AFT52550-ISO-M16X1.5IK-F	M16	1.50	14.0	18	24.65	102	90°	5		●

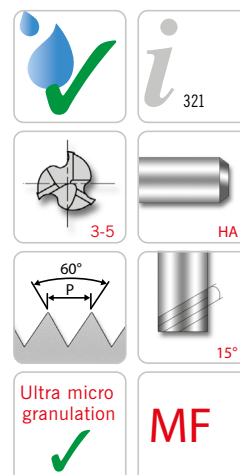
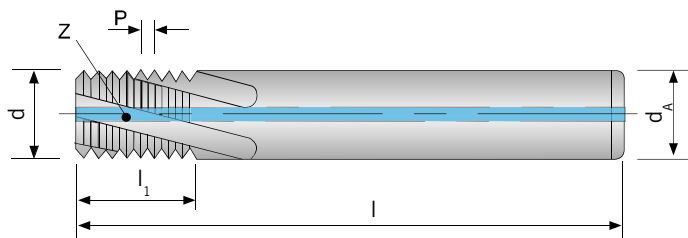
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.0-ISO-...IK ...

3 - 5 flutes, 15 degree helix angle, short design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l	z	HC
								TAIN
AFT52530-ISO-M8X0.75IK	M8	0.75	6.0	6	12.75	57	3	◆
AFT52530-ISO-M8X1.0IK	M8	1.00	6.0	6	13.00	57	3	◆
AFT52540-ISO-M10X1.0IK	M10	1.00	8.0	8	16.00	63	4	◆
AFT52540-ISO-M12X1.0IK	M12	1.00	9.5	10	19.00	72	4	◆
AFT52540-ISO-M12X1.5IK	M12	1.50	9.5	10	19.50	72	4	◆
AFT52540-ISO-M12X1.25IK	M12	1.25	9.5	10	18.75	72	4	◆
AFT52540-ISO-M14X1.0IK	M14	1.00	10.0	10	22.00	83	4	◆
AFT52540-ISO-M14X1.5IK	M14	1.50	10.0	10	22.50	83	4	◆
AFT52540-ISO-M16X1.0IK	M16	1.00	12.0	12	25.00	83	4	◆
AFT52540-ISO-M16X1.5IK	M16	1.50	12.0	12	25.50	83	4	◆
AFT52550-ISO-M18X1.0IK	M18	1.00	14.0	14	28.00	92	5	◆
AFT52550-ISO-M18X1.5IK	M18	1.50	14.0	14	28.50	92	5	◆
AFT52550-ISO-M20X1.0IK	M20	1.00	16.0	16	31.00	92	5	◆
AFT52550-ISO-M20X1.5IK	M20	1.50	16.0	16	31.50	92	5	◆

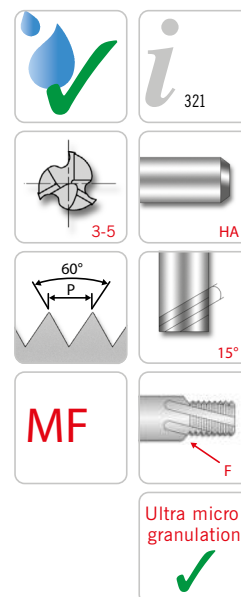
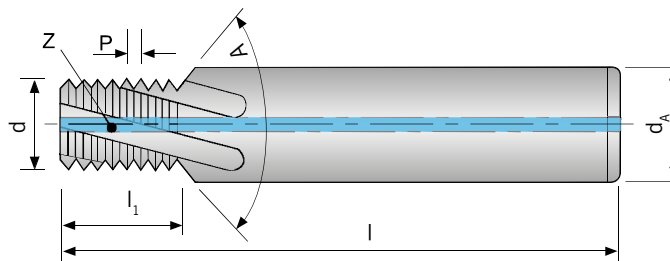
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.0-ISO-...IK-F ...

3 - 5 flutes, 15 degree helix angle, short design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l	A	z	HC
									TAIN
AFT52530-ISO-M8X1.0IK-F	M8	1.00	6.7	10	12.40	74	90°	3	◆
AFT52540-ISO-M10X1.0IK-F	M10	1.00	8.7	12	15.40	80	90°	4	◆
AFT52540-ISO-M10X1.25IK-F	M10	1.25	8.3	12	15.90	80	90°	4	◆
AFT52540-ISO-M12X1.0IK-F	M12	1.00	10.7	14	18.40	90	90°	4	◆
AFT52540-ISO-M12X1.5IK-F	M12	1.50	10.0	14	18.65	90	90°	4	◆
AFT52540-ISO-M12X1.25IK-F	M12	1.25	10.3	14	18.30	80	90°	4	◆
AFT52540-ISO-M14X1.5IK-F	M14	1.50	12.0	16	21.65	100	90°	4	◆
AFT52550-ISO-M16X1.5IK-F	M16	1.50	14.0	18	24.65	102	90°	5	◆

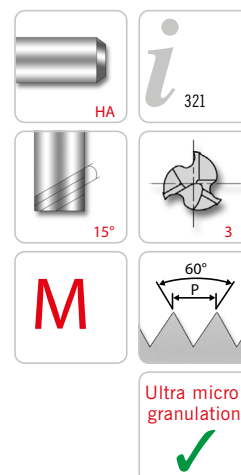
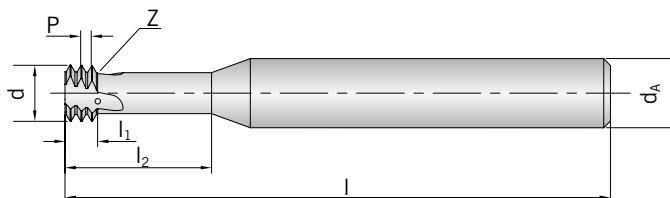
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT52534-ISO-....

3 flutes, 15 degree helix angle, mini design



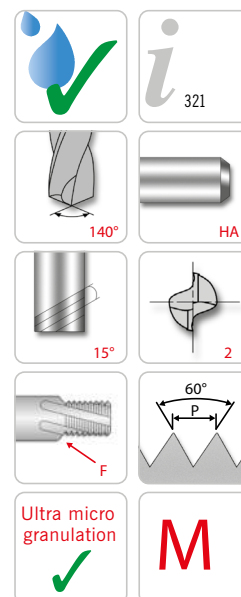
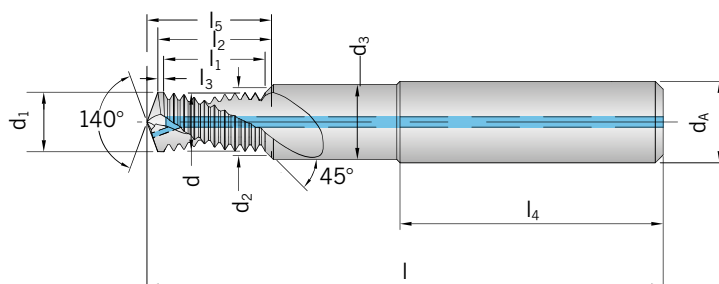
Shank DIN 6535HA	G Thread	P Pitch	d	d _A	l ₁	l ₂	l	z	HC
									TAIN
AFT52534-ISO-M1.6X0.35	M1,6	0.35	1.18	3	1.05	3.4	30	3	◆
AFT52534-ISO-M2.2X0.45	M2,2	0.45	1.66	6	1.35	4.6	57	3	◆
AFT52534-ISO-M2.5X0.45	M2,5	0.45	1.96	6	1.35	5.3	57	3	◆
AFT52534-ISO-M2X0.4	M2	0.40	1.52	6	1.20	4.2	57	3	◆
AFT52534-ISO-M3X0.5	M3	0.50	2.40	6	1.50	6.3	57	3	◆
AFT52534-ISO-M4X0.7	M4	0.70	3.16	6	2.10	8.4	57	3	◆
AFT52534-ISO-M5X0.8	M5	0.80	4.04	6	2.40	10.5	57	3	◆
AFT52534-ISO-M6X1.0	M6	1.00	4.80	6	3.00	12.6	57	3	◆
AFT52534-ISO-M8X1.25	M8	1.25	6.50	8	3.75	16.8	63	3	◆
AFT52534-ISO-M10X1.5	M10	1.50	8.20	10	4.50	21.0	73	3	◆
AFT52534-ISO-M12X1.75	M12	1.75	9.90	10	5.25	25.2	73	3	◆

HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

2 flutes, 15 degree helix angle, long design



Shank DIN 6535HA	G Thread	P Pitch	d	d _A	d ₁	d ₂	d ₃	l ₁	l ₂	l ₃	l ₄	l ₅	l	HC
														TAIN
AFT52621-ISO-M6X1.0IK-F	M6	1.00	4.75	8	5.00	6.3	6.6	13.00	13.77	1.00	36	14.68	62	◆
AFT52621-ISO-M8X1.25IK-F	M8	1.25	6.35	10	6.75	8.3	9.0	16.27	17.25	1.25	40	18.48	74	◆
AFT52621-ISO-M10X1.5IK-F	M10	1.50	7.95	12	8.50	10.3	11.0	21.05	22.22	1.50	45	23.77	79	◆
AFT52621-ISO-M12X1.75IK-F	M12	1.75	9.95	14	10.25	12.3	13.5	24.21	25.38	1.50	45	27.25	89	◆
AFT52621-ISO-M14X2.0IK-F	M14	2.00	11.20	16	12.00	14.3	15.5	29.58	31.13	1.50	48	33.32	102	◆

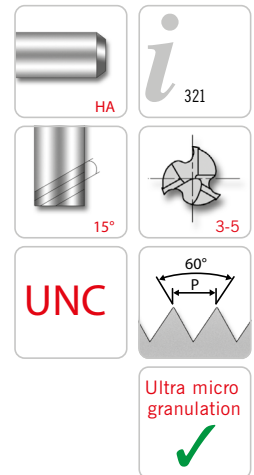
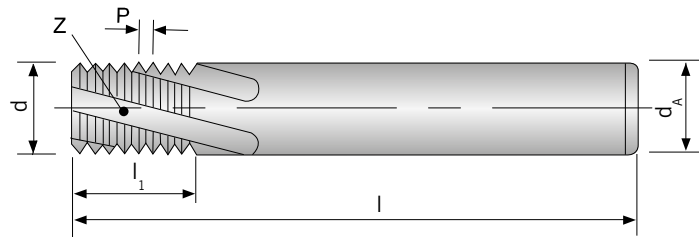
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

- Main application
- Secondary application

AFT525.1-UNC-...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l	z	HC
								TAIN
AFT52531-UNC-1/4X20	1/4"	20	4.5	6	14.0	57	3	◆
AFT52531-UNC-5/16X18	5/16"	18	5.8	6	16.9	65	3	◆
AFT52541-UNC-1/2X13	1/2"	13	9.5	10	27.4	80	4	◆
AFT52541-UNC-3/8X16	3/8"	16	7.0	8	20.6	72	4	◆
AFT52541-UNC-5/8X11	5/8"	11	12.0	12	34.6	92	4	◆
AFT52541-UNC-7/16X14	7/16"	14	8.0	8	23.6	72	4	◆
AFT52541-UNC-9/16X12	9/16"	12	10.0	10	31.8	83	4	◆
AFT52551-UNC-3/4X10	3/4"	10	14.0	14	40.6	104	5	◆

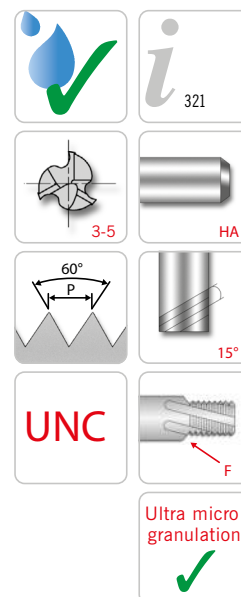
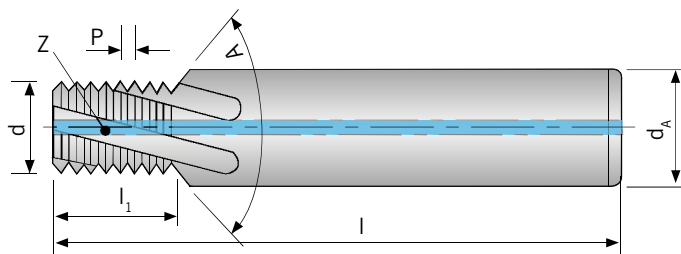
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-UNC-...IK-F ...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l	A	z	HC	
									TAIN	Main application
AFT52531-UNC-1/4X20IK-F	1/4"	20	4.8	8	13.30	62	90°	3	◆	●
AFT52531-UNC-5/16X18IK-F	5/16"	18	6.2	10	16.18	74	90°	3	◆	●
AFT52541-UNC-1/2X13IK-F	1/2"	13	10.3	14	26.32	90	90°	4	◆	●
AFT52541-UNC-3/8X16IK-F	3/8"	16	7.6	12	19.80	80	90°	4	◆	●
AFT52541-UNC-5/8X11IK-F	5/8"	11	13.1	18	33.41	102	90°	4	◆	●
AFT52541-UNC-7/16X14IK-F	7/16"	14	8.9	12	22.62	80	90°	4	◆	●
AFT52541-UNC-9/16X12IK-F	9/16"	12	11.7	16	30.63	100	90°	4	◆	●
AFT52551-UNC-3/4X10IK-F	3/4"	10	16.0	20	39.29	110	90°	5	◆	●

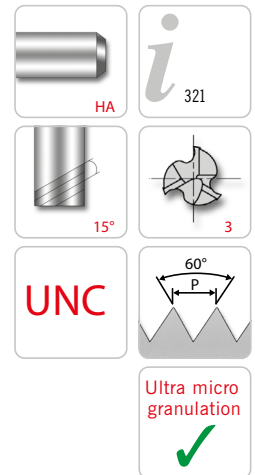
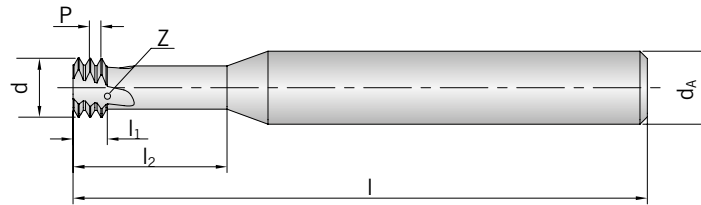
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	●

● Main application
○ Secondary application

AFT52534-UNC-...

3 flutes, 15 degree helix angle, mini design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l ₂	l	z	HC	
									TAIN	
AFT52534-UNC-1/4X20	1/4"	20	4.83	6	3.81	13.3	57	3	◆	
AFT52534-UNC-1X64	1	64	1.38	6	1.19	3.9	57	3	◆	
AFT52534-UNC-2X56	2	56	1.64	6	1.36	4.6	57	3	◆	
AFT52534-UNC-3/8X16	3/8"	16	7.62	8	4.76	20.0	63	3	◆	
AFT52534-UNC-4X40	4	40	2.08	6	1.91	6.0	57	3	◆	
AFT52534-UNC-5/16X18	5/16"	18	6.24	8	4.23	16.7	63	3	◆	
AFT52534-UNC-6X32	6	32	2.55	6	2.38	7.4	57	3	◆	
AFT52534-UNC-7/16X14	7/16"	14	8.94	10	5.44	23.3	73	3	◆	
AFT52534-UNC-8X32	8	32	3.21	6	2.38	8.7	57	3	◆	
AFT52534-UNC-10X24	10	24	3.56	6	3.18	10.1	57	3	◆	
AFT52534-UNC-12X24	12	24	4.22	6	3.18	11.5	57	3	◆	

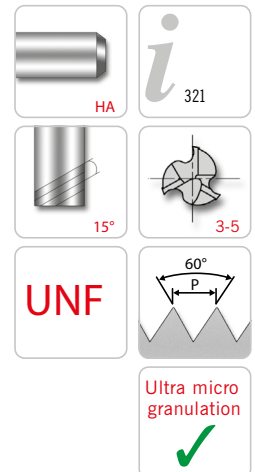
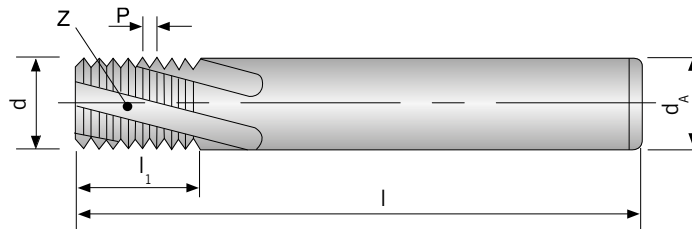
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-UNF-...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l	z	HC
								TAIN
AFT52531-UNF-1/4X28	1/4"	28	5	6	13.6	57	3	◆
AFT52531-UNF-5/16X24	5/16"	24	6	6	16.9	65	3	◆
AFT52541-UNF-1/2X20	1/2"	20	10	10	26.7	80	4	◆
AFT52541-UNF-3/8X24	3/8"	24	8	8	20.1	72	4	◆
AFT52541-UNF-5/8X18	5/8"	18	12	12	33.9	92	4	◆
AFT52541-UNF-7/16X20	7/16"	20	8	8	24.1	72	4	◆
AFT52541-UNF-9/16X18	9/16"	18	12	12	29.6	83	4	◆
AFT52551-UNF-3/4X16	3/4"	16	14	14	39.7	104	5	◆

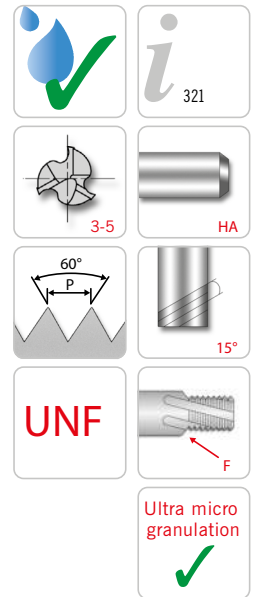
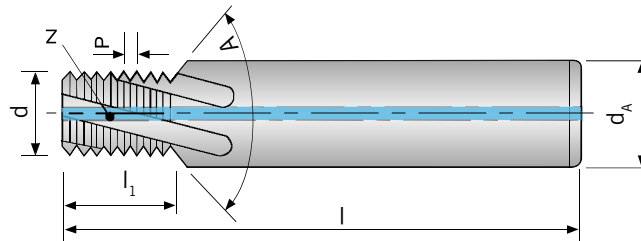
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-UNF-...IK-F ...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l	A	z	HC	
									TAIN	Main application
AFT52531-UNF-1/4X28IK-F	1/4"	28	5.1	8	13.21	62	90°	3		●
AFT52531-UNF-5/16X24IK-F	5/16"	24	6.5	10	16.37	74	90°	3		●
AFT52541-UNF-1/2X20IK-F	1/2"	20	11.0	14	26.00	90	90°	4		●
AFT52541-UNF-3/8X24IK-F	3/8"	24	8.1	12	19.54	80	90°	4		●
AFT52541-UNF-7/16X20IK-F	7/16"	20	9.4	12	22.19	80	90°	4		●
AFT52541-UNF-9/16X18IK-F	9/16"	18	12.4	16	28.88	100	90°	4		●
AFT52551-UNF-3/4X16IK-F	3/4"	16	17.0	20	38.86	110	90°	5		●
AFT52551-UNF-5/8X18IK-F	5/8"	18	14.0	18	33.12	102	90°	5		●

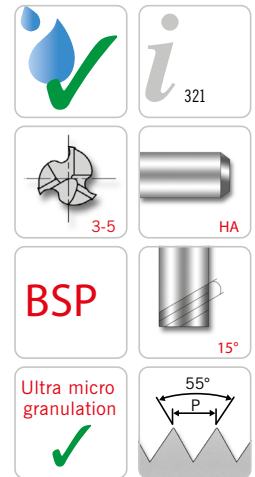
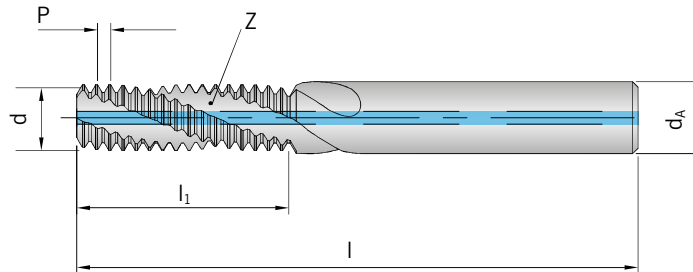
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-BSP-...IK ...

3 - 5 flutes, 15 degree helix angle, mid-length design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l	z	HC
								TAIN
AFT52531-BSP-1/16X28IK	1/16"	28	5.9	6	16.3	65	3	◆
AFT52541-BSP-1/4X19IK	1/4"	19	9.9	10	26.7	80	4	◆
AFT52541-BSP-1/8X28IK	1/8"	28	7.9	8	20.0	70	4	◆
AFT52541-BSP-3/8X19IK	3/8"	19	13.9	14	33.4	92	4	◆
AFT52551-BSP-1/2X14IK	1/2"	14	15.9	16	43.5	104	5	◆
AFT52551-BSP-1X11IK	1"	11	19.9	20	34.6	100	5	◆
AFT52551-BSP-3/4X14IK	3/4"	14	17.9	18	34.5	100	5	◆

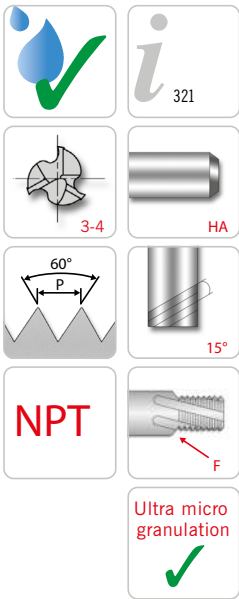
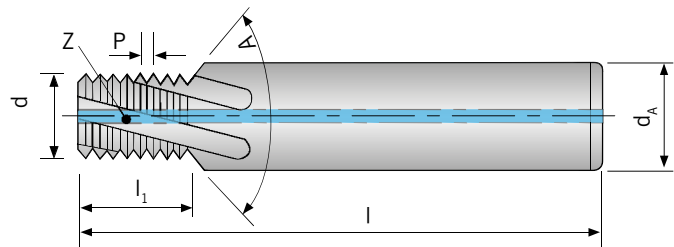
HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

AFT525.1-NPT-...IK-F ...

3 - 4 flutes, 15 degree helix angle, short design



Shank DIN 6535HA	G Thread	P Pitch [Inch]	d	d _A	l ₁	l	A	z	HC	
									TAIN	◆
AFT52531-NPT-1/16X27IK-F	1/16"	27	5.90	10	8.9	64	90°	3		
AFT52541-NPT-1/8X27IK-F	1/8"	27	7.80	12	8.9	70	90°	4		
AFT52541-NPT-1/4X18IK-F	1/4"	18	10.05	16	13.4	81	90°	4		
AFT52541-NPT-3/8X18IK-F	3/8"	18	13.45	18	13.4	81	90°	4		

HC = Carbide coated

P	●
M	●
K	●
N	●
S	●
H	

● Main application
○ Secondary application

Material group	Structure of the material groups and identification letters			Brinell hardness HB	Tensile strength Rm (N/mm²)	Chipping group	Cutting speed V _c (m/min)	Feed per tooth f _z (mm)	Feed per tooth f _z (mm)
							VHM TiAlN	Ø 3 - 10 mm	Ø 12 - 20 mm
P	Unalloyed steel	C ≤ 0.25 % annealed	125	428	P1	105 - 115 - 125	0,015 - 0,03 - 0,045	0,07 - 0,085 - 0,1	
		C > 0.25 ... ≤ 0.55 % annealed	190	639	P2	145 - 155 - 165	0,012 - 0,0285 - 0,045	0,07 - 0,085 - 0,1	
		C > 0.25 ... ≤ 0.55 % hardened and tempered	210	708	P3	120 - 130 - 140	0,02 - 0,0325 - 0,045	0,07 - 0,085 - 0,1	
		C > 0.55 % annealed	190	639	P4	120 - 130 - 140	0,02 - 0,0325 - 0,045	0,07 - 0,085 - 0,1	
		C > 0.55 % hardened and tempered	300	1013	P5	85 - 95 - 105	0,02 - 0,0325 - 0,045	0,07 - 0,085 - 0,1	
		Machining steel (short-chipping) tempered	220	745	P6	120 - 130 - 140	0,012 - 0,0285 - 0,045	0,07 - 0,085 - 0,1	
	Low alloyed steel	annealed	175	591	P7	120 - 130 - 140	0,012 - 0,0285 - 0,045	0,07 - 0,085 - 0,1	
		hardened and tempered	300	1013	P8	70 - 80 - 90	0,01 - 0,025 - 0,04	0,07 - 0,085 - 0,1	
		hardened and tempered	380	1282	P9	65 - 75 - 85	0,02 - 0,03 - 0,04	0,07 - 0,085 - 0,1	
		hardened and tempered	430	1477	P10	55 - 65 - 75	0,02 - 0,03 - 0,04	0,07 - 0,085 - 0,1	
	High alloyed steel and high alloyed tool steel	annealed	200	675	P11	140 - 150 - 160	0,025 - 0,045 - 0,065	0,07 - 0,085 - 0,1	
		hardened	300	1013	P12	100 - 110 - 120	0,03 - 0,0475 - 0,065	0,07 - 0,085 - 0,1	
		hardened	400	1361	P13	80 - 90 - 100	0,03 - 0,0475 - 0,065	0,07 - 0,085 - 0,1	
	Stainless steel	ferritic / martensitic, annealed	200	675	P14	45 - 55 - 65	0,02 - 0,0425 - 0,065	0,07 - 0,085 - 0,1	
		martensitic, hardened and tempered	330	1114	P15	35 - 45 - 55	0,03 - 0,0525 - 0,075	0,095 - 0,0975 - 0,1	
M	Stainless steel	austenitic, chilled	200	675	M1	45 - 55 - 65	0,015 - 0,0225 - 0,03	0,05 - 0,075 - 0,1	
		austenitic, precipitation-hardened (PH)	300	1013	M2	30 - 40 - 50	0,02 - 0,03 - 0,04	0,05 - 0,075 - 0,1	
		austenitic-ferritic, Duplex	230	778	M3	35 - 45 - 55	0,013 - 0,0215 - 0,03	0,05 - 0,075 - 0,1	
K	Malleable cast iron	ferritic	200	675	K1	80 - 105 - 130	0,02 - 0,035 - 0,05	0,075 - 0,0875 - 0,1	
		pearlitic	260	867	K2	75 - 100 - 125	0,025 - 0,0375 - 0,05	0,075 - 0,0875 - 0,1	
	Cast iron	low tensile strength	180	602	K3	105 - 130 - 155	0,02 - 0,035 - 0,05	0,075 - 0,0875 - 0,1	
		high tensile strength / austenitic	245	825	K4	85 - 110 - 135	0,025 - 0,0375 - 0,05	0,075 - 0,0875 - 0,1	
	Cast iron with nodular graphite	ferritic	155	518	K5	80 - 105 - 130	0,02 - 0,035 - 0,05	0,075 - 0,0875 - 0,1	
		pearlitic	265	885	K6	75 - 100 - 125	0,02 - 0,03 - 0,04	0,075 - 0,0875 - 0,1	
N	GGV (CGI)		200	675	K7	60 - 85 - 110	0,025 - 0,0375 - 0,05	0,075 - 0,0875 - 0,1	
	Aluminium alloys long chipping	not heat treatable	30	-	N1	-	-	-	
		heat treatable, heat treated	100	343	N2	-	-	-	
	Casted aluminium alloys	≤ 12 % Si, not heat treatable	75	260	N3	-	-	-	
		≤ 12 % Si, aushärtbar, ausgehärtet	90	314	N4	-	-	-	
		> 12 % Si, not heat treatable	130	447	N5	-	-	-	
	Magnesium alloys		70	250	N6	130 - 170 - 210	0,03 - 0,0525 - 0,075	0,08 - 0,1 - 0,12	
	Copper and copper alloys (Brass / Bronze)	Unalloyed, elektrolyte copper	100	343	N7	300 - 360 - 420	0,03 - 0,0525 - 0,075	0,08 - 0,1 - 0,12	
		Brass, Bronze	90	314	N8	300 - 360 - 420	0,03 - 0,0525 - 0,075	0,08 - 0,1 - 0,12	
		Cu-alloys, short-chipping	110	382	N9	300 - 360 - 420	0,03 - 0,0525 - 0,075	0,08 - 0,1 - 0,12	
		High-tensile, Ampco	300	1013	N10	35 - 50 - 65	0,03 - 0,0525 - 0,075	0,08 - 0,1 - 0,12	
	Non-ferrous materials	Lead alloys (without abrasive filling material)		-	-	N11	250 - 290 - 330	0,011 - 0,023 - 0,035	0,05 - 0,075 - 0,1
		Duroplastic (without abrasive filling material)		-	-	N12	100 - 145 - 190	0,011 - 0,023 - 0,035	0,05 - 0,075 - 0,1
		Plastic glas fibre reinforced GFRP		-	-	N13	50 - 65 - 80	0,011 - 0,023 - 0,035	0,05 - 0,075 - 0,1
		Plastic carbon fibre reinforced CFRP		-	-	N14	50 - 65 - 80	-	0,05 - 0,075 - 0,1
		Plastic aramid fibre reinforced AFRP		-	-	N15	50 - 65 - 80	-	0,05 - 0,075 - 0,1
		Graphite (tech.)		80 Shore	-	N16	-	-	-
S	High temperature resistant alloys	Fe-Basis	annealed	200	675	S1	25 - 35 - 45	0,015 - 0,0225 - 0,03	0,05 - 0,075 - 0,1
			heat treated	280	943	S2	15 - 25 - 35	0,015 - 0,0325 - 0,05	0,05 - 0,0675 - 0,085
		Ni- or Co-alloyed	annealed	250	839	S3	30 - 40 - 50	0,015 - 0,0325 - 0,05	0,05 - 0,07 - 0,09
			heat treated	350	1177	S4	15 - 25 - 35	0,02 - 0,035 - 0,05	0,05 - 0,075 - 0,1
			casting	320	1076	S5	15 - 25 - 35	0,013 - 0,0315 - 0,05	0,05 - 0,075 - 0,1
	Titanium alloys	Pure titan	200	675	S6	30 - 40 - 50	0,011 - 0,023 - 0,035	0,05 - 0,075 - 0,1	
		α- and β-alloys, heat treated	375	1262	S7	30 - 40 - 50	0,015 - 0,025 - 0,035	0,05 - 0,075 - 0,1	
		β-alloys	410	1396	S8	10 - 20 - 30	0,015 - 0,025 - 0,035	0,05 - 0,075 - 0,1	
	Wolfram alloys		300	1013	S9	40 - 50 - 60	0,015 - 0,0225 - 0,03	0,05 - 0,07 - 0,09	
Molybdän alloys		300	1013	S10	50 - 60 - 70	0,015 - 0,0325 - 0,05	0,05 - 0,07 - 0,09		
H	Hardened steel	hardened	50 HRC	-	H1	-	-	-	
		hardened	55 HRC	-	H2	-	-	-	
		hardened	60 HRC	-	H3	-	-	-	
	Hardened cast iron	hardened	55 HRC	-	H4	-	-	-	

The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.