

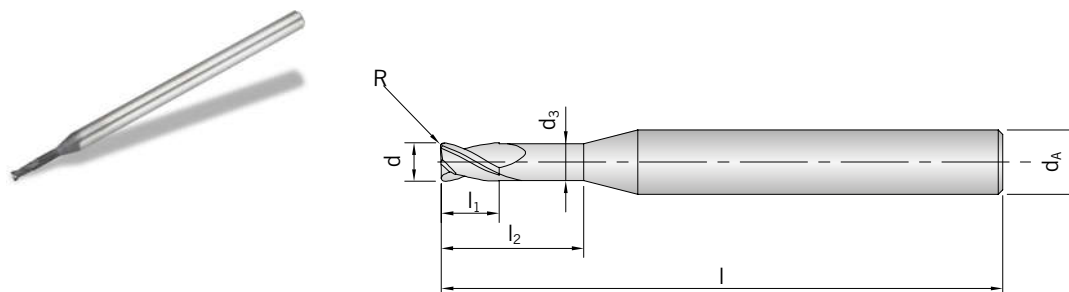
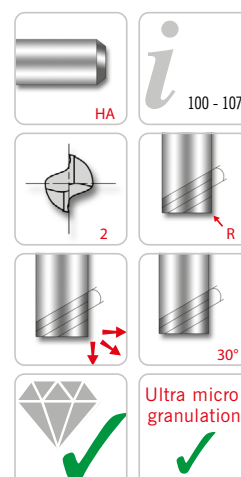
ESPECIALLY FOR GRAPHITE MACHINING

The hard coating ensures excellent wear resistance and long tool life, the ultra-fine diamond coating leaves an outstanding surface finish.



AFD50724-...R...

2 flutes, mini design, with corner radius



Only for graphite machining

Shank DIN 6535HA	d -0,02	d _A h6	d ₃	l ₁	l ₂	l	R	HC
								D100
AFD50724-002A	0.2	3	-	0.3	-	40	-	◆
AFD50724-003A	0.3	3	-	0.5	-	40	-	◆
AFD50724-004A	0.4	3	-	0.6	-	40	-	◆
AFD50724-005AR0,05	0.5	3	0.45	0.7	2.5	40	0.05	◆
AFD50724-005BR0,05	0.5	3	0.45	0.7	4.0	40	0.05	◆
AFD50724-006AR0,05	0.6	3	0.55	0.9	3.0	40	0.05	◆
AFD50724-006BR0,05	0.6	3	0.55	0.9	5.0	40	0.05	◆
AFD50724-008AR0,05	0.8	3	0.75	1.2	4.0	40	0.05	◆
AFD50724-008BR0,05	0.8	3	0.75	1.2	7.0	40	0.05	◆
AFD50724-010AR0,1	1.0	3	0.95	1.5	5.0	40	0.10	◆
AFD50724-010BR0,1	1.0	3	0.95	1.5	8.5	40	0.10	◆
AFD50724-010CR0,1	1.0	3	0.95	1.5	12.0	40	0.10	◆
AFD50724-012AR0,1	1.2	3	1.15	1.8	6.0	50	0.10	◆
AFD50724-012BR0,1	1.2	3	1.15	1.8	10.0	50	0.10	◆
AFD50724-015AR0,15	1.5	3	1.40	2.2	7.5	50	0.15	◆
AFD50724-015BR0,15	1.5	3	1.40	2.2	12.0	50	0.15	◆
AFD50724-015CR0,15	1.5	3	1.40	2.2	18.0	50	0.15	◆
AFD50724-020AR0,15	2.0	3	1.90	2.2	10.0	60	0.15	◆
AFD50724-020BR0,15	2.0	3	1.90	2.2	16.0	60	0.15	◆
AFD50724-020CR0,15	2.0	3	1.90	2.2	25.0	60	0.15	◆
AFD50724-030AR0,2	3.0	4	2.90	3.0	10.0	65	0.20	◆
AFD50724-030BR0,2	3.0	4	2.90	3.0	15.0	65	0.20	◆
AFD50724-030CR0,2	3.0	4	2.90	3.0	20.0	65	0.20	◆
AFD50724-030DR0,2	3.0	4	2.90	3.0	25.0	75	0.20	◆
AFD50724-030ER0,2	3.0	4	2.90	3.0	30.0	75	0.20	◆
AFD50724-040AR0,2	4.0	6	3.90	4.0	20.0	65	0.20	◆
AFD50724-040BR0,2	4.0	6	3.90	4.0	30.0	75	0.20	◆
AFD50724-040CR0,2	4.0	6	3.90	4.0	40.0	90	0.20	◆
AFD50724-050AR0,3	5.0	6	4.90	5.0	20.0	75	0.30	◆
AFD50724-050BR0,3	5.0	6	4.90	5.0	30.0	75	0.30	◆
AFD50724-050CR0,3	5.0	6	4.90	5.0	40.0	90	0.30	◆

Only for graphite machining

Shank DIN 6535HA	d -0,02	d _A h6	d ₃	l ₁	l ₂	l	R	HC
								D100
AFD50724-050DR0,3	5.0	6	4.90	5.0	50.0	90	0.30	◆
AFD50724-060AR0,3	6.0	6	5.90	6.0	30.0	75	0.30	◆
AFD50724-060BR0,3	6.0	6	5.90	6.0	40.0	90	0.30	◆
AFD50724-060CR0,3	6.0	6	5.90	6.0	50.0	90	0.30	◆
AFD50724-060DR0,3	6.0	6	5.90	6.0	60.0	100	0.30	◆

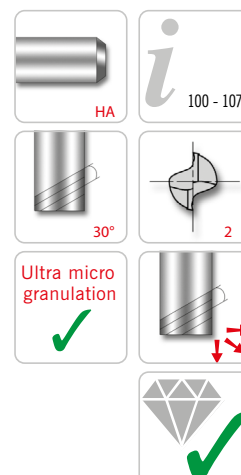
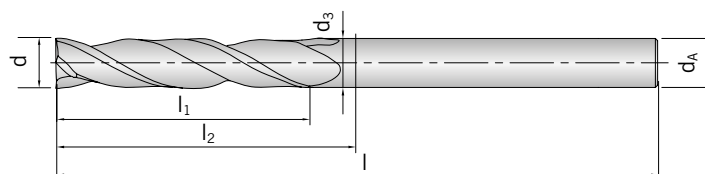
HC = Carbide coated

P	
M	
K	
N	●
S	
H	

- Main application
- Secondary application

AFD50121-...

2 flutes, long design



Only for graphite machining

Shank DIN 6535HA	d -0,03	d _A h6	d ₃	l ₁	l ₂	l	HC
							D100
AFD50121-005	0.5	3	0.45	1	2	40	◆
AFD50121-006	0.6	3	0.55	2	3	40	◆
AFD50121-007	0.7	3	0.65	2	4	40	◆
AFD50121-008	0.8	3	0.75	2	5	40	◆
AFD50121-009	0.9	3	0.85	2	6	40	◆
AFD50121-010	1.0	4	0.95	3	8	75	◆
AFD50121-015	1.5	4	1.45	4	10	75	◆
AFD50121-020	2.0	4	1.90	6	16	100	◆
AFD50121-025	2.5	4	2.40	8	20	100	◆
AFD50121-030	3.0	6	2.80	8	30	100	◆
AFD50121-035	3.5	6	3.20	10	35	100	◆
AFD50121-040	4.0	6	3.70	20	40	100	◆
AFD50121-050	5.0	6	4.60	25	50	125	◆
AFD50121-060	6.0	6	5.60	30	60	140	◆
AFD50121-070	7.0	6	-	35	-	140	◆
AFD50121-080	8.0	8	7.40	40	80	150	◆
AFD50121-090	9.0	8	-	45	-	150	◆
AFD50121-100	10.0	10	9.40	50	80	150	◆
AFD50121-110	11.0	10	-	50	-	150	◆
AFD50121-120	12.0	12	11.40	55	80	150	◆

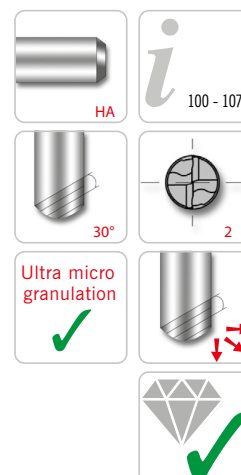
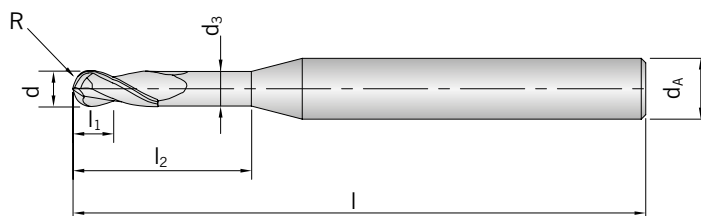
HC = Carbide coated

P	
M	
K	
N	●
S	
H	

● Main application
○ Secondary application

AFD51824-...

2 flutes, mini design



AFD

Only for graphite machining

Shank DIN 6535HA	d -0,02	d _A h6	d ₃	l ₁	l ₂	l	R ± 0,01	HC
								D100
AFD51824-002A	0.2	3	-	0.2	-	40	0.10	◆
AFD51824-003A	0.3	3	-	0.3	-	40	0.15	◆
AFD51824-004A	0.4	3	-	0.4	-	40	0.20	◆
AFD51824-005A	0.5	3	0.45	0.5	2.5	40	0.25	◆
AFD51824-006A	0.6	3	0.55	0.6	3.0	40	0.30	◆
AFD51824-006B	0.6	3	0.55	0.6	5.0	40	0.30	◆
AFD51824-008A	0.8	3	0.75	0.8	4.0	40	0.40	◆
AFD51824-008B	0.8	3	0.75	0.8	7.0	40	0.40	◆
AFD51824-010A	1.0	3	0.95	1.0	5.0	40	0.50	◆
AFD51824-010B	1.0	3	0.95	1.0	8.5	40	0.50	◆
AFD51824-010C	1.0	3	0.95	1.0	12.0	40	0.50	◆
AFD51824-012A	1.2	3	1.15	1.2	6.0	50	0.60	◆
AFD51824-012B	1.2	3	1.15	1.2	10.0	50	0.60	◆
AFD51824-015A	1.5	3	1.40	1.5	7.5	50	0.75	◆
AFD51824-015B	1.5	3	1.40	1.5	12.0	50	0.75	◆
AFD51824-015C	1.5	3	1.40	1.5	18.0	50	0.75	◆
AFD51824-020A	2.0	3	1.90	2.2	10.0	60	1.00	◆
AFD51824-020B	2.0	3	1.90	2.2	16.0	60	1.00	◆
AFD51824-020C	2.0	3	1.90	2.2	25.0	60	1.00	◆
AFD51824-030A	3.0	4	2.90	3.0	10.0	65	1.50	◆
AFD51824-030B	3.0	4	2.90	3.0	15.0	65	1.50	◆
AFD51824-030C	3.0	4	2.90	3.0	20.0	65	1.50	◆
AFD51824-030D	3.0	4	2.90	3.0	25.0	75	1.50	◆
AFD51824-030E	3.0	4	2.90	3.0	30.0	75	1.50	◆
AFD51824-040A	4.0	6	3.90	4.0	20.0	65	2.00	◆
AFD51824-040B	4.0	6	3.90	4.0	30.0	75	2.00	◆
AFD51824-040C	4.0	6	3.90	4.0	40.0	90	2.00	◆
AFD51824-050A	5.0	6	4.90	5.0	20.0	65	2.50	◆
AFD51824-050B	5.0	6	4.90	5.0	30.0	75	2.50	◆
AFD51824-050C	5.0	6	4.90	5.0	40.0	90	2.50	◆
AFD51824-050D	5.0	6	4.90	5.0	50.0	90	2.50	◆

Only for graphite machining

Shank DIN 6535HA	d -0,02	d _A h6	d ₃	l ₁	l ₂	l	R ± 0,01	HC
								D100
AFD51824-060A	6.0	6	5.90	6.0	30.0	75	3.00	◆
AFD51824-060B	6.0	6	5.90	6.0	40.0	90	3.00	◆
AFD51824-060C	6.0	6	5.90	6.0	50.0	90	3.00	◆
AFD51824-060D	6.0	6	5.90	6.0	60.0	100	3.00	◆

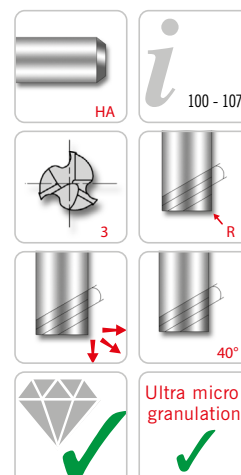
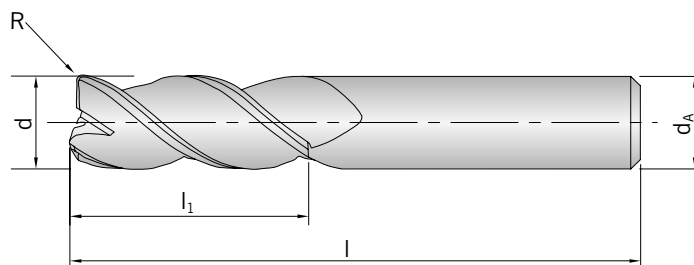
HC = Carbide coated

P	
M	
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H	

- Main application
○ Secondary application

AFD54030-...R...

3 flutes, short design, with corner radius



AFD

Only for graphite machining

Shank DIN 6535HA	d -0,03	d _A h6	l ₁	l	R	HC
						D100
AFD54030-020R0,15	2	3	6	40	0.15	◆
AFD54030-030R0,15	3	3	12	40	0.15	◆
AFD54030-040R0,2	4	4	14	50	0.20	◆
AFD54030-050R0,3	5	5	16	50	0.30	◆
AFD54030-060R0,3	6	6	20	65	0.30	◆
AFD54030-080R0,5	8	8	20	65	0.50	◆
AFD54030-100R0,5	10	10	25	75	0.50	◆
AFD54030-120R0,5	12	12	25	75	0.50	◆

HC = Carbide coated

P	
M	
K	
N	●
S	
H	

● Main application
○ Secondary application

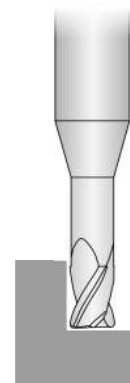
Recommended cutting data feed tables

AFD50724-...R...

D100 coating for graphite machining

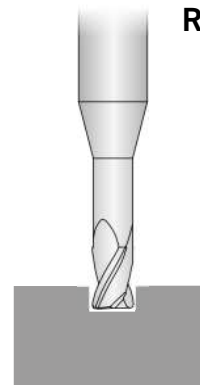
AFD

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,004	120	200	240	360
0,3	2	0,005	150	250	300	450
0,4	2	0,005	150	250	300	450
0,5	2	0,006	180	300	360	540
0,6	2	0,007	210	350	420	630
0,8	2	0,009	270	450	540	810
1,0	2	0,012	360	600	720	1080
1,2	2	0,015	450	750	900	1350
1,5	2	0,018	540	900	1080	1620
2,0	2	0,024	720	1200	1440	2160
3,0	2	0,035	1050	1750	2100	3150
4,0	2	0,047	1410	2350	2820	4230
5,0	2	0,059	1770	2950	3540	5310
6,0	2	0,071	2130	3550	4260	6390



Roughing

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,004	120	200	240	360
0,3	2	0,004	120	200	240	360
0,4	2	0,004	120	200	240	360
0,5	2	0,005	150	250	300	450
0,6	2	0,005	150	250	300	450
0,8	2	0,007	210	350	420	630
1,0	2	0,009	270	450	540	810
1,2	2	0,011	330	550	660	990
1,5	2	0,014	420	700	840	1260
2,0	2	0,018	540	900	1080	1620
3,0	2	0,027	810	1350	1620	2430
4,0	2	0,036	1080	1800	2160	3240
5,0	2	0,045	1350	2250	2700	4050
6,0	2	0,055	1650	2750	3300	4950



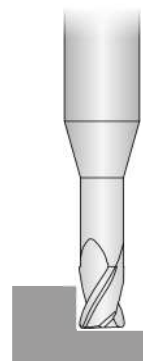
Roughing

Attention: These cutting data are recommendations only.
Customer specific circumstances such as machine power, stability, tool overhang etc. are not taken into consideration.

AFD50724-...R...

D100 coating for graphite machining

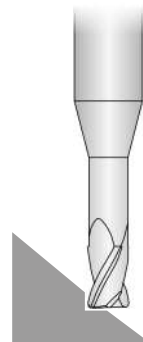
Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,004	120	200	240	360
0,3	2	0,004	120	200	240	360
0,4	2	0,005	150	250	300	450
0,5	2	0,007	210	350	420	630
0,6	2	0,008	240	400	480	720
0,8	2	0,011	330	550	660	990
1,0	2	0,013	390	650	780	1170
1,2	2	0,015	450	750	900	1350
1,5	2	0,020	600	1000	1200	1800
2,0	2	0,027	810	1350	1620	2430
3,0	2	0,040	1200	2000	2400	3600
4,0	2	0,053	1590	2650	3180	4770
5,0	2	0,067	2010	3350	4020	6030
6,0	2	0,080	2400	4000	4800	7200



Finishing

AFD

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,004	120	200	240	360
0,3	2	0,004	120	200	240	360
0,4	2	0,005	150	250	300	450
0,5	2	0,007	210	350	420	630
0,6	2	0,008	240	400	480	720
0,8	2	0,011	330	550	660	990
1,0	2	0,013	390	650	780	1170
1,2	2	0,015	450	750	900	1350
1,5	2	0,020	600	1000	1200	1800
2,0	2	0,027	810	1350	1620	2430
3,0	2	0,040	1200	2000	2400	3600
4,0	2	0,053	1590	2650	3180	4770
5,0	2	0,067	2010	3350	4020	6030
6,0	2	0,080	2400	4000	4800	7200



Finishing

Attention: These cutting data are recommendations only.

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Recommended cutting data feed tables

AFD50121-...

D100 coating for graphite machining

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,5	2	0,005	150	250	300	450
0,6	2	0,006	180	300	360	540
0,7	2	0,007	210	350	420	630
0,8	2	0,008	240	400	480	720
0,9	2	0,008	240	400	480	720
1,0	2	0,009	270	450	540	810
1,5	2	0,014	420	700	840	1260
2,0	2	0,019	570	950	1140	1710
2,5	2	0,024	720	1200	1440	2160
3,0	2	0,029	840	1400	1680	2520
3,5	2	0,032	960	1600	1920	2880
4,0	2	0,040	1200	2000	2400	3600
5,0	2	0,045	1350	2250	2700	4050
6,0	2	0,050	1500	2500	3000	4500
7,0	2	0,055	1650	2750	3300	4950
8,0	2	0,060	1800	3000	3600	5400
9,0	2	0,065	1950	3250	3900	5850
10,0	2	0,070	2100	3500	4200	6300
11,0	2	0,075	2250	3750	4500	6750
12,0	2	0,080	2400	4000	4800	7200



Roughing

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,5	2	0,003	90	150	180	270
0,6	2	0,003	90	150	180	270
0,7	2	0,003	90	150	180	270
0,8	2	0,004	120	200	240	360
0,9	2	0,005	150	250	300	450
1,0	2	0,005	150	250	300	450
1,5	2	0,008	240	400	480	720
2,0	2	0,011	330	550	660	990
2,5	2	0,014	420	700	840	1260
3,0	2	0,016	480	800	960	1440
3,5	2	0,019	570	950	1140	1710
4,0	2	0,021	630	1050	1260	1890
5,0	2	0,026	780	1300	1560	2340
6,0	2	0,031	930	1550	1860	2790
7,0	2	0,036	1080	1800	2160	3240
8,0	2	0,040	1200	2000	2400	3600
9,0	2	0,045	1350	2250	2700	4050
10,0	2	0,050	1500	2500	3000	4500
11,0	2	0,055	1650	2750	3300	4950
12,0	2	0,060	1800	3000	3600	5400



Roughing

Attention: These cutting data are recommendations only.

Customer specific circumstances such as machine power, stability, tool overhang etc. are not taken into consideration.

AFD50121-...

D100 coating for graphite machining

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,5	2	0,005	150	250	300	450
0,6	2	0,006	180	300	360	540
0,7	2	0,007	210	350	420	630
0,8	2	0,009	270	450	540	810
0,9	2	0,009	270	450	540	810
1,0	2	0,011	330	550	660	990
1,5	2	0,016	480	800	960	1440
2,0	2	0,021	630	1050	1260	1890
2,5	2	0,026	780	1300	1560	2340
3,0	2	0,031	930	1550	1860	2790
3,5	2	0,036	1080	1800	2160	3240
4,0	2	0,040	1200	2000	2400	3600
5,0	2	0,045	1350	2250	2700	4050
6,0	2	0,050	1500	2500	3000	4500
7,0	2	0,055	1650	2750	3300	4950
8,0	2	0,060	1800	3000	3600	5400
9,0	2	0,065	1950	3250	3900	5850
10,0	2	0,070	2100	3500	4200	6300
11,0	2	0,075	2250	3750	4500	6750
12,0	2	0,080	2400	4000	4800	7200



Finishing

AFD

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,5	2	0,005	150	250	300	450
0,6	2	0,006	180	300	360	540
0,7	2	0,007	210	350	420	630
0,8	2	0,009	270	450	540	810
0,9	2	0,009	270	450	540	810
1,0	2	0,011	330	550	660	990
1,5	2	0,016	480	800	960	1440
2,0	2	0,021	630	1050	1260	1890
2,5	2	0,026	780	1300	1560	2340
3,0	2	0,031	930	1550	1860	2790
3,5	2	0,036	1080	1800	2160	3240
4,0	2	0,040	1200	2000	2400	3600
5,0	2	0,045	1350	2250	2700	4050
6,0	2	0,050	1500	2500	3000	4500
7,0	2	0,055	1650	2750	3300	4950
8,0	2	0,060	1800	3000	3600	5400
9,0	2	0,065	1950	3250	3900	5850
10,0	2	0,070	2100	3500	4200	6300
11,0	2	0,075	2250	3750	4500	6750
12,0	2	0,080	2400	4000	4800	7200



Finishing

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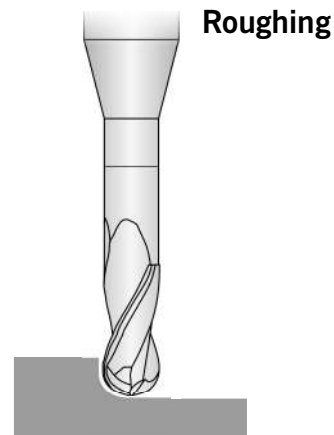
Recommended cutting data feed tables

AFD51824-...

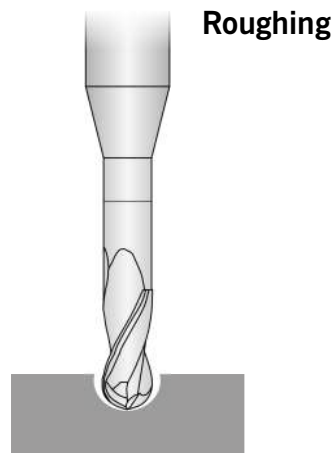
D100 coating for graphite machining

AFD

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,003	90	150	180	270
0,3	2	0,004	120	200	240	360
0,4	2	0,004	120	200	240	360
0,5	2	0,005	150	250	300	450
0,6	2	0,006	180	300	360	540
0,8	2	0,008	240	400	480	720
1,0	2	0,009	270	450	540	810
1,2	2	0,011	330	550	660	990
1,5	2	0,014	420	700	840	1260
2,0	2	0,019	570	950	1140	1710
3,0	2	0,028	840	1400	1680	2520
4,0	2	0,037	1110	1850	2220	3330
5,0	2	0,046	1380	2300	2760	4140
6,0	2	0,055	1650	2750	3300	4950



Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,003	90	150	180	270
0,3	2	0,003	90	150	180	270
0,4	2	0,004	120	200	240	360
0,5	2	0,004	120	200	240	360
0,6	2	0,004	120	200	240	360
0,8	2	0,006	180	300	360	540
1,0	2	0,007	210	350	420	630
1,2	2	0,009	270	450	540	810
1,5	2	0,011	330	550	660	990
2,0	2	0,015	450	750	900	1350
3,0	2	0,022	660	1100	1320	1980
4,0	2	0,029	870	1450	1740	2610
5,0	2	0,036	1080	1800	2160	3240
6,0	2	0,043	1290	2150	2580	3870



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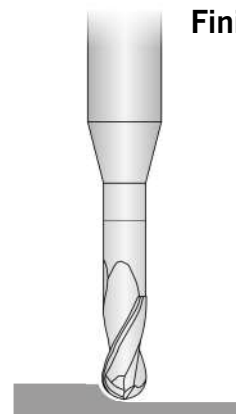
Customer specific circumstances such as machine power, stability, tool overhang etc. are not taken into consideration.

Recommended cutting data feed tables

AFD51824-...

D100 coating for graphite machining

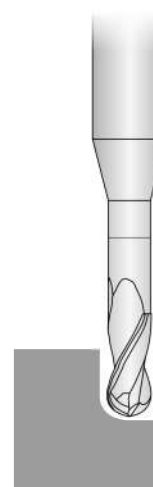
Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,003	90	150	180	270
0,3	2	0,004	120	200	240	360
0,4	2	0,004	120	200	240	360
0,5	2	0,005	150	250	300	450
0,6	2	0,006	180	300	360	540
0,8	2	0,009	270	450	540	810
1,0	2	0,011	330	550	660	990
1,2	2	0,013	390	650	780	1170
1,5	2	0,016	480	800	960	1440
2,0	2	0,021	630	1050	1260	1890
3,0	2	0,032	960	1600	1920	2880
4,0	2	0,042	1260	2100	2520	3780
5,0	2	0,053	1590	2650	3180	4770
6,0	2	0,063	1890	3150	3780	5670



Finishing

AFD

Ø d ₁ [mm]	Z	fz [mm]	n 15000 min1 vf [mm/min.]	n 25000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]	n 45000 min1 vf [mm/min.]
0,2	2	0,003	90	150	180	270
0,3	2	0,004	120	200	240	360
0,4	2	0,004	120	200	240	360
0,5	2	0,005	150	250	300	450
0,6	2	0,006	180	300	360	540
0,8	2	0,009	270	450	540	810
1,0	2	0,011	330	550	660	990
1,2	2	0,013	390	650	780	1170
1,5	2	0,016	480	800	960	1440
2,0	2	0,021	630	1050	1260	1890
3,0	2	0,032	960	1600	1920	2880
4,0	2	0,042	1260	2100	2520	3780
5,0	2	0,053	1590	2650	3180	4770
6,0	2	0,063	1890	3150	3780	5670



Finishing

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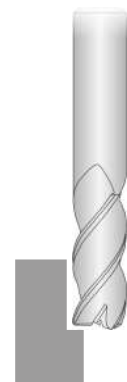
Recommended cutting data feed tables

AFD54030-...R...

D100 coating for graphite machining

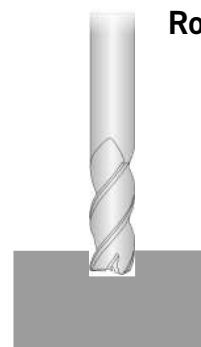
AFD

$\varnothing d_1$ [mm]	Z	fz [mm]	n 10000 min1 vf [mm/min.]	n 15000 min1 vf [mm/min.]	n 20000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]
2,0	3	0,024	720	1080	1440	2160
3,0	3	0,035	1050	1575	2100	3150
4,0	3	0,047	1410	2115	2820	4230
5,0	3	0,059	1770	2655	3540	5310
6,0	3	0,071	2130	3195	4260	6390
8,0	3	0,094	2820	4230	5640	8460
10,0	3	0,118	3540	5310	7080	10620
12,0	3	0,141	4230	6345	8460	12690



Roughing

$\varnothing d_1$ [mm]	Z	fz [mm]	n 10000 min1 vf [mm/min.]	n 15000 min1 vf [mm/min.]	n 20000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]
2,0	3	0,018	540	810	1080	1620
3,0	3	0,027	810	1215	1620	2430
4,0	3	0,036	1080	1620	2160	3240
5,0	3	0,045	1350	2025	2700	4050
6,0	3	0,055	1650	2475	3300	4950
8,0	3	0,073	2190	3285	4380	6570
10,0	3	0,091	2730	4095	5460	8190
12,0	3	0,109	3270	4905	6540	9810



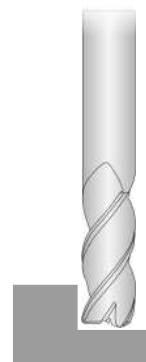
Roughing

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AFD54030-...R...

D100 coating for graphite machining

$\varnothing d_1$ [mm]	Z	fz [mm]	n 10000 min1 vf [mm/min.]	n 15000 min1 vf [mm/min.]	n 20000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]
2,0	3	0,027	810	1215	1620	2430
3,0	3	0,040	1200	1800	2400	3600
4,0	3	0,053	1590	2385	3180	4770
5,0	3	0,067	2010	3015	4020	6030
6,0	3	0,080	2400	3600	4800	7200
8,0	3	0,107	3210	4815	6420	9630
10,0	3	0,133	3990	5985	7980	11970
12,0	3	0,160	4800	7200	9600	14400



Finishing

AFD

$\varnothing d_1$ [mm]	Z	fz [mm]	n 10000 min1 vf [mm/min.]	n 15000 min1 vf [mm/min.]	n 20000 min1 vf [mm/min.]	n 30000 min1 vf [mm/min.]
2,0	3	0,027	810	1215	1620	2430
3,0	3	0,040	1200	1800	2400	3600
4,0	3	0,053	1590	2385	3180	4770
5,0	3	0,067	2010	3015	4020	6030
6,0	3	0,080	2400	3600	4800	7200
8,0	3	0,107	3210	4815	6420	9630
10,0	3	0,133	3990	5985	7980	11970
12,0	3	0,160	4800	7200	9600	14400



Finishing

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