

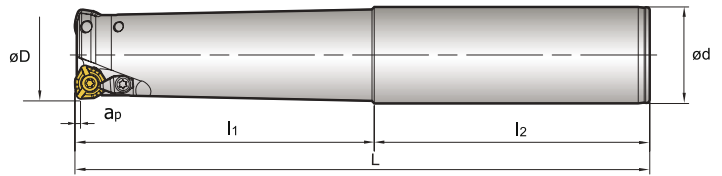
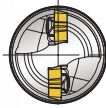
High Feed Milling

HRMS



COMBIDEX[®]

Threading Tools



HRMS

Type	$\varnothing D$	L	$\varnothing d$	l_1	l_2	a_p		Insert
HRMS 0820R-2S20	20	130	20	50	80	1.0	2	WDKT080316ZDSR-MH
HRMS 1025R-2S25	25	140	25	60	80	1.0~1.5	2	WDKT10T320ZDSR-MH
HRMS 1332R-2S32	32	150	32	70	80	1.5~2.0	2	WDKT130520ZDSR-MH
HRMS 1340R-3S32	40	150	32	50	100	1.5~2.0	3	WDKT130520ZDSR-MH

	Workpiece	Hardness	Grade	V (m/min)	fz (mm/t)	overhang (mm)	$\varnothing 20/21\text{mm}$ (2 teeth)					$\varnothing 25\text{mm}$ (2 teeth)				
							N(min-1)	F(mm/min)	a_p (mm)	Q	pc(KW)	N(min-1)	F(mm/min)	a_p (mm)	Q	pc(KW)
P	General structural steel & Mild steel	Under 200HB	PC3535	180(120~230)	1.0	150	2865	5730	1.0	114	4.1	2292	4584	1.1	126	4.5
			PC3535	160(120~200)	0.9	200	2546	4584	0.8	73	2.6	2037	3667	0.9	82	2.9
			PC3545	150(100~170)	0.7	250	2387	3342	0.6	40	1.4	1910	2674	0.7	46	1.7
	Carbon steel & Alloy steel	Under 30HRC	PC3535	160(130~190)	1.0	150	2546	5093	0.8	81	2.9	2037	4074	0.9	91	3.2
			PC3535	150(130~180)	0.9	200	2387	4297	0.6	51	1.8	1910	3438	0.7	60	2.1
			PC3545	130(100~150)	0.7	250	2069	2897	0.5	29	1.1	1655	2979	0.6	44	1.6
	HighCarbon steel & Alloy steel	30~40 HRC	PC3535	110(90~130)	0.9	150	1751	3151	0.8	50	1.8	1401	2521	0.9	56	2
			PC3545	100(80~130)	0.7	200	1592	2228	0.6	26	1	1273	1783	0.7	31	1.1
			PC3545	90(80~120)	0.5	250	1432	1432	0.4	11	0.41	1146	1146	0.5	14	0.51
	Pre-hardened steel	40~50 HRC	PC3535	100(70~120)	0.7	150	1592	2228	0.6	26	1	1273	1783	0.7	31	1.1
			PC3535	80(70~120)	0.5	200	1273	1273	0.4	10	0.36	1019	1019	0.5	12	0.46
	M	Stainless steel	Under 270HB	PC9530	120(70~160)	0.9	150	1910	3438	1.0	68	2.5	1528	2750	1.0	68
K	Cast iron	Under 350N/mm ²	PC8520	120(70~160)	0.7	200	1910	2674	0.8	42	1.5	1528	2139	0.8	42.78	1.5
			PC6510	150(100~200)	1.3	150	2387	6207	1.0	124	4.4	1910	4966	1.0	124	4.4
					1.1	200	2387	5252	0.8	84	3	1910	4202	0.8	84	3

	Workpiece	Hardness	Grade	V (m/min)	fz (mm/t)	overhang (mm)	$\varnothing 32\text{mm}$ (2 teeth)					$\varnothing 40\text{mm}$ (3 teeth)				
							N(min-1)	F(mm/min)	a_p (mm)	Q	pc(KW)	N(min-1)	F(mm/min)	a_p (mm)	Q	pc(KW)
P	General structural steel & Mild steel	Under 200HB	PC3535	180(120~230)	1.5	170	1790	5371	1.2	206	7.3	1432	6446	1.2	309	11.1
			PC3535	160(120~200)	1.3	220	1592	4138	1.0	132	4.7	1273	4966	1.0	198	7.1
			PC3545	150(100~170)	1.1	270	1492	3283	0.8	84	3	1194	3939	0.8	126	4.5
	Carbon steel & Alloy steel	Under 30HRC	PC3535	160(130~190)	1.4	170	1592	4456	1.0	142	5.1	1273	5348	1.0	214	7.6
			PC3535	150(130~180)	1.2	220	1492	3581	0.8	91	3.2	1194	4297	0.8	137	4.9
			PC3545	130(100~150)	1.0	270	1293	2586	0.7	57	2.1	1035	3104	0.7	87	3.1
	HighCarbon steel & Alloy steel	30~40 HRC	PC3535	110(90~130)	1.3	170	1094	2845	1.0	91	3.2	875	3414	1.0	136	4.8
			PC3545	100(80~130)	1.1	220	955	2188	0.8	56	2	796	2626	0.8	84	3
			PC3545	90(80~120)	0.9	270	895	1611	0.6	30	1.1	716	1934	0.6	46	1.6
	Pre-hardened steel	40~50 HRC	PC3535	100(70~120)	1.0	170	955	1989	0.8	50	1.8	796	2387	0.8	76	3.6
			PC3535	80(70~120)	0.8	250	796	1273	0.6	24	0.9	637	1528	0.6	36	1.3
	M	Stainless steel	Under 270HB	PC9530	120(70~160)	1.2	170	1194	2865	1.2	110	3.9	955	3438	1.2	165
K	Cast iron	Under 350N/mm ²	PC8520	120(70~160)	1.0	250	1194	2387	1.0	76	2.7	955	2865	1.0	114	4.1
			PC6510	150(100~200)	1.7	170	1492	5073	1.2	194	6.9	1194	6088	1.2	292	13.9
					1.5	250	1492	4476	1.0	143	5.1	1194	5371	1.0	214	7.6



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