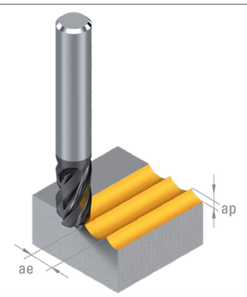
DIXI 7532-5D

$$n\ [rpm] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

$$Vf\ [mm/min] = n\ [rpm] \times fz\ [mm] \times Z$$

		VDI 3323		XIDUR Vc [m/min]	ae (mm)	ap (mm)
P	High-alloy steel > 800 N/mm², stainless steel ferr.- marten.	10 - 13		**240**	<0.3×ØD1	<0.07×ØD1
S	Refractory alloy, Fe, Ni, Co base	31- 35		**65**	<0.3×ØD1	<0.04×ØD1
H	Hardened steel (45 à 55 HRC)	38		**200**	<0.3×ØD1	<0.03×ØD1
	Hardened steel (55 à 65 HRC)	39		**120**	<0.2×ØD1	<0.02×ØD1

Feed per tooth **fz [mm]**

Ø D_1 0.20 - 0.40	Ø D_1 0.50 - 0.70	Ø D_1 0.80 - 1.00	Ø D_1 1.50 - 3.00	Ø D_1 4.00 - 6.00	Ø D_1 8.00 - 12.00
0.003 - 0.006	0.008 - 0.011	0.013 - 0.016	0.024 - 0.048	0.064 - 0.096	0.130 - 0.145
0.003 - 0.006	0.007 - 0.010	0.011 - 0.014	0.022 - 0.043	0.058 - 0.086	0.115 - 0.130
0.003 - 0.006	0.007 - 0.010	0.011 - 0.014	0.022 - 0.043	0.058 - 0.086	0.115 - 0.130
0.002 - 0.003	0.004 - 0.006	0.006 - 0.008	0.012 - 0.024	0.032 - 0.048	0.065 - 0.070