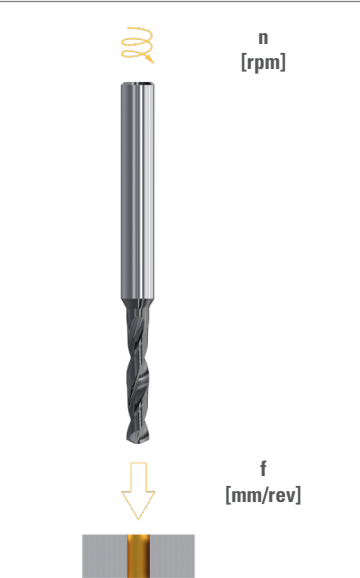


		Pecking cycle			
		VDI 3323		TiAlN Vc [m/min]	Q1
P	Unalloyed steel, leaded steel	1 - 5		70 - 100	<4×ØD1
	Low alloyed steel < 800 N/mm²	6 - 9		60 - 90	<4×ØD1
	High-alloy steel > 800 N/mm², stainless steel ferr.- marten.	10 - 13		40 - 70	<2×ØD1
M	Austenitic stainless steel < 700 N/mm²	14.1 - 14.2		30 - 50	<0.5×ØD1
	Nickel-free stainless steel / DUPLEX > 700 N/mm²	14.3 - 14.4		20 - 40	<0.6×ØD1
K	Grey cast iron < 250 HB	15 - 16		90 - 130	<4×ØD1
	Ductile, malleable, nodular cast iron > 250 HB	17 - 20		70 - 100	<2×ØD1
S	Refractory alloy, Fe, Ni, Co base	31 - 35		15 - 30	<3×ØD1
	Titanium, titanium alloy	36 - 37		30 - 60	<0.5×ØD1

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

$$Vf \text{ [mm/min]} = n \text{ [rpm]} \times f \text{ [mm]}$$

Feed per revolution f [mm]							
Ø D ₁ 0.50 - 1.00	Ø D ₁ 1.00 - 1.50	Ø D ₁ 1.50 - 2.00	Ø D ₁ 2.00 - 3.00	Ø D ₁ 3.00 - 5.00	Ø D ₁ 5.00 - 7.00	Ø D ₁ 7.00 - 10.00	
0.030 - 0.082	0.062 - 0.124	0.080 - 0.145	0.090 - 0.190	0.110 - 0.260	0.150 - 0.290	0.160 - 0.310	
0.028 - 0.074	0.054 - 0.110	0.072 - 0.130	0.080 - 0.170	0.100 - 0.230	0.140 - 0.260	0.140 - 0.280	
0.028 - 0.074	0.054 - 0.110	0.072 - 0.130	0.080 - 0.170	0.100 - 0.230	0.140 - 0.260	0.140 - 0.280	
0.012 - 0.030	0.022 - 0.044	0.030 - 0.050	0.030 - 0.070	0.040 - 0.090	0.060 - 0.100	0.060 - 0.110	
0.010 - 0.026	0.020 - 0.040	0.026 - 0.045	0.030 - 0.060	0.040 - 0.080	0.050 - 0.090	0.050 - 0.100	
0.034 - 0.092	0.068 - 0.138	0.090 - 0.160	0.100 - 0.210	0.130 - 0.290	0.170 - 0.320	0.180 - 0.350	
0.026 - 0.070	0.052 - 0.104	0.066 - 0.120	0.080 - 0.160	0.100 - 0.220	0.130 - 0.240	0.130 - 0.260	
0.008 - 0.024	0.018 - 0.034	0.022 - 0.040	0.030 - 0.050	0.030 - 0.070	0.040 - 0.080	0.040 - 0.090	
0.012 - 0.032	0.024 - 0.048	0.032 - 0.055	0.040 - 0.070	0.040 - 0.100	0.060 - 0.110	0.060 - 0.120	

Values based on cutting oil use. The cutting parameters are very strongly influenced by external parameters, such as tool and workpiece stability, etc.
The cutting conditions must be adapted to the operating conditions !