



**TRONÇONNAGE**

**ABTRENNEN**

**SLITTING**

**TRONCATURA**

**DARABOLÁS**

**SELECTION OF SLITTING SAWS** **238**



**SLITTING SAWS** **242**



**MILLING ARBORS** **257**



**T-SLOT CUTTERS** **259**



**HOB CUTTERS** **262**



















**TOOLS ON REQUEST** **266**





**CUTTING CONDITIONS** **270**

## SELECTION OF SLITTING SAWS




✓ = item from stock

SLITTING SAWS		Page		<input type="checkbox"/> CARBIDE	<input checked="" type="checkbox"/> CUTINOX				
<b>DIXI 1531</b> Ø 15 - 125		242	 	✓					
<b>DIXI 1533</b> Ø 15 - 160		245	 	✓					
<b>DIXI 1539</b> Ø 10 - 50		249		✓					
<b>DIXI 1534</b> Ø 20 - 100		253	 	✓					
<b>DIXI 1537</b> Ø 50 - 100		255	 		✓				
<b>DIXI 1640</b> Ø 50 - 100		256		✓					

## MILLING ARBORS

<b>DIXI 2713</b> Ø 3 - 16		257							
<b>DIXI 2714</b> Ø 5 - 16		258							

## T-SLOT CUTTERS

<b>DIXI 1525</b> Ø 2 - 30		259		✓	✓				
<b>DIXI 1528</b> Ø 4 - 30		260		✓	✓				
<b>DIXI 1527</b> Ø 4 - 16		261		✓	✓				



○ good    ⊙ excellent

Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Steel Hardened cast iron > 45 HRC	Cast iron	Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Al	Graphite	Plastic
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⊙	⊙	⊙	○		⊙	⊙	⊙	○	○	○		○
○	○	○	○		⊙	○	○	○	○	○		○
○	○	○	○		⊙	○	○	○	○			
○	○	○	⊙		○	○	○	⊙	⊙	⊙		⊙
○	○	⊙	⊙			⊙	⊙	○	○	○		○
○	○	○	○		⊙	○	○	⊙	○	○		○


⊙	⊙	○	○		⊙	○	○	⊙	○	⊙		○
⊙	⊙	○	○		⊙	○	○	⊙	○	⊙		○
⊙	⊙	○	○		⊙	○	○	⊙	○	⊙		○



## SELECTION OF SLITTING SAWS

✓ = item from stock

		Page	<input type="checkbox"/> CARBIDE					
<b>HOB CUTTERS</b>								
<b>DIXI 1675</b> Ø 6 - 24		262	✓					
<b>DIXI 1680</b> Ø 6 - 24		262	✓					
<b>DIXI 1685</b> Ø 6 - 24		263	✓					
<b>DIXI 1690</b> Ø 10 - 12		264	✓					
<b>DIXI 1674</b> Ø 6 - 24		265	✓					



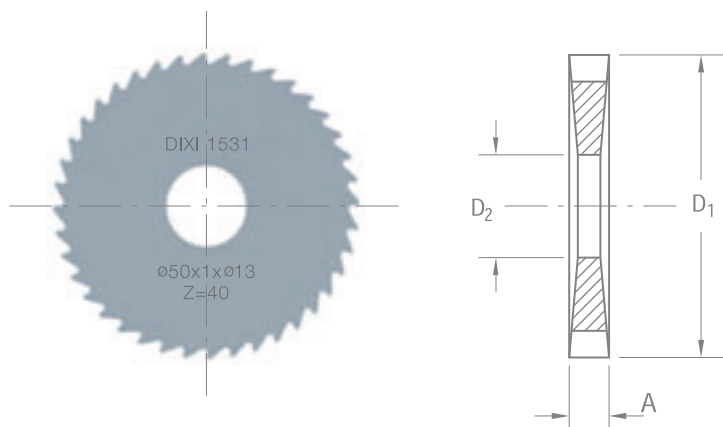
○ good    ⊙ excellent

Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Steel Hardened cast iron > 45 HRC	Cast iron	Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Al	Graphite	Plastic
⊙	⊙	○	○				○	⊙	○	⊙		
⊙	⊙	○	○				○	⊙	○	⊙		
⊙	⊙	○	○				○	⊙	○	⊙		
⊙	⊙	○	○				○	⊙	○	⊙		
⊙	⊙	○	○				○	⊙	○	⊙		



# DIXI 1531

## SLITTING SAWS COARSE PITCH TEETH



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				

D <sub>1</sub> js12	A ±0.01	D <sub>2</sub> H6	Z	CARBIDE
15	0.20	5	32	37180
15	0.30	5	24	37182
15	0.40	5	24	35382
15	0.50	5	24	35383
15	0.60	5	20	601
15	0.70	5	20	603
15	0.80	5	20	2532
15	0.90	5	20	7707
15	1.00	5	20	602
15	1.20	5	16	38947
15	1.50	5	16	38948
15	1.60	5	16	42457
15	1.80	5	16	42536
15	2.00	5	16	38949
20	0.20	5	40	35384
20	0.30	5	32	35385
20	0.40	5	32	3281
20	0.50	5	24	31481
20	0.60	5	24	604
20	0.70	5	24	605
20	0.80	5	24	37080
20	0.90	5	24	3282
20	1.00	5	20	3283
20	1.20	5	20	2425
20	1.50	5	20	3287
20	1.60	5	20	3288
20	1.80	5	20	3290
20	2.00	5	16	42458
20	2.50	5	16	42459
25	0.30	8	40	37740
25	0.40	8	32	42461
25	0.50	8	32	42376
25	0.60	8	32	42377
25	0.70	8	32	42378
25	0.80	8	24	2479
25	1.00	8	24	42380
25	1.20	8	24	42462



# DIXI 1531

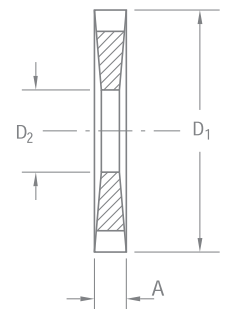
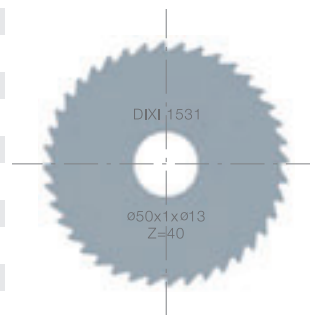
$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE
25	1.50	8	20	3299
25	1.60	8	20	3300
25	2.00	8	20	3303
30	0.30	8	40	37845
30	0.40	8	40	37841
30	0.50	8	40	35386
30	0.60	8	32	30662
30	0.70	8	32	3309
30	0.80	8	32	41350
30	0.90	8	32	41351
30	1.00	8	32	36413
30	1.20	8	24	1327
30	1.50	8	24	3316
30	1.60	8	24	3317
30	1.80	8	24	3319
30	2.00	8	24	3321
30	2.50	8	20	42466
30	3.00	8	20	42467
30	4.00	8	20	42468
40	0.40	10	48	42470
40	0.50	10	40	2662
40	0.60	10	40	6348
40	0.70	10	40	17953
40	0.80	10	40	42471
40	0.90	10	40	38817
40	1.00	10	32	3034
40	1.20	10	32	3307
40	1.50	10	32	3326
40	1.60	10	32	3798
40	1.80	10	32	39499
40	2.00	10	24	42472
40	2.50	10	24	42473
40	3.00	10	24	42474
40	4.00	10	20	42475
50	0.40	13	48	26023
50	0.50	13	48	42477
50	0.60	13	48	42478
50	0.70	13	48	14681
50	0.80	13	40	3330
50	0.90	13	40	41064
50	1.00	13	40	8636
50	1.20	13	40	8637
50	1.40	13	40	3336
50	1.50	13	32	25731
50	1.60	13	32	3337
50	1.80	13	32	3657
50	2.00	13	32	2533
50	2.50	13	32	3339
50	3.00	13	24	42479



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				





# DIXI 1531

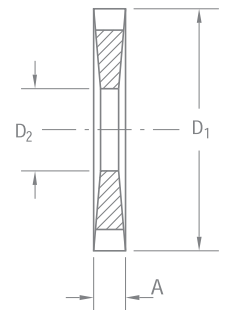
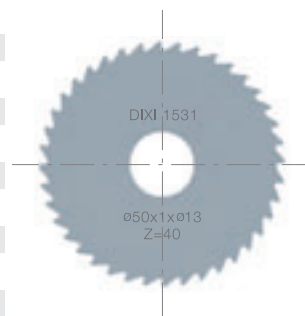
$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE
63	0.80	16	48	3342
63	1.00	16	48	609
63	1.20	16	40	3658
63	1.50	16	40	3345
63	1.60	16	40	3346
63	1.80	16	40	3347
63	2.00	16	40	610
63	2.50	16	32	42483
63	3.00	16	32	611
80	0.80	22	64	6070
80	1.00	22	48	3054
80	1.20	22	48	4016
80	1.50	22	48	3349
80	1.60	22	48	34808
80	1.80	22	48	22178
80	2.00	22	40	2807
80	2.50	22	40	42484
80	3.00	22	40	21847
100	1.00	22	64	38542
100	1.20	22	64	38543
100	1.50	22	48	35387
100	1.60	22	48	39146
100	1.80	22	48	38927
100	2.00	22	48	38928
125	1.00	22	80	42489
125	1.20	22	64	42490
125	1.50	22	64	38480
125	2.00	22	64	39005



P. 270

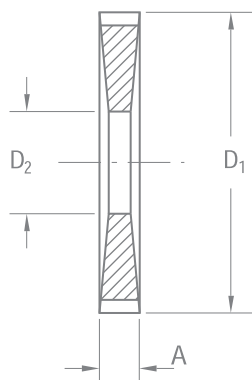
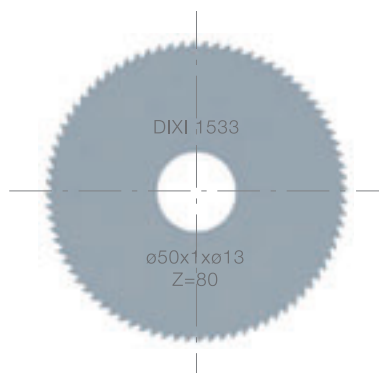


Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				



# DIXI 1533

## SLITTING SAWS FINE PITCH TEETH



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				

$D_1$ js12	$A$ ±0.01	$D_2$ H6	Z	CARBIDE
15	0.20	5	64	36382
15	0.25	5	64	35635
15	0.30	5	48	3707
15	0.40	5	48	3708
15	0.50	5	48	613
15	0.60	5	40	5453
15	0.70	5	40	6183
15	0.80	5	40	3244
15	0.90	5	40	3245
15	1.00	5	40	614
15	1.10	5	32	43250
15	1.20	5	32	37174
15	1.50	5	32	40710
15	1.60	5	32	40711
15	1.70	5	32	40712
15	1.80	5	32	40713
15	2.00	5	32	37175
20	0.20	5	80	617
20	0.25	5	64	618
20	0.30	5	64	34590
20	0.40	5	64	1659
20	0.50	5	48	18560
20	0.60	5	48	36647
20	0.70	5	48	39659
20	0.80	5	48	627
20	0.90	5	48	623
20	1.00	5	40	35565
20	1.10	5	40	2689
20	1.20	5	40	38141
20	1.30	5	40	3407
20	1.40	5	40	3408
20	1.50	5	40	624
20	1.60	5	40	3010
20	1.80	5	40	23600
20	2.00	5	32	625
20	2.50	5	32	36690
20	3.00	5	32	626



# DIXI 1533

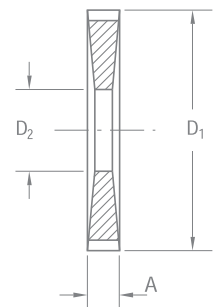
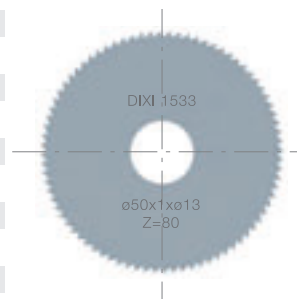
$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE
25	0.20	8	80	1660
25	0.25	8	80	3249
25	0.30	8	80	2421
25	0.35	8	80	1688
25	0.40	8	64	37661
25	0.50	8	64	14254
25	0.60	8	64	630
25	0.70	8	64	36365
25	0.80	8	48	632
25	0.90	8	48	633
25	1.00	8	48	634
25	1.10	8	48	2422
25	1.20	8	48	3250
25	1.30	8	48	3410
25	1.40	8	48	3412
25	1.50	8	40	35450
25	1.80	8	40	3414
25	2.00	8	40	636
25	2.50	8	40	637
25	3.00	8	32	38971
25	4.00	8	32	3728
30	0.20	8	100	14689
30	0.25	8	100	4262
30	0.30	8	80	638
30	0.40	8	80	639
30	0.50	8	80	18429
30	0.60	8	64	18375
30	0.70	8	64	37731
30	0.80	8	64	35516
30	0.90	8	64	36052
30	1.00	8	64	2376
30	1.10	8	48	35420
30	1.20	8	48	36384
30	1.30	8	48	3417
30	1.40	8	48	2424
30	1.50	8	48	2924
30	1.60	8	48	3418
30	1.70	8	48	5948
30	1.80	8	48	6362
30	2.00	8	48	645
30	2.50	8	40	6361
30	3.00	8	40	3419
30	4.00	8	40	33482
30	5.00	8	32	35095
40	0.20	10	128	24084
40	0.25	10	100	22049
40	0.30	10	100	35370
40	0.40	10	100	4690
40	0.50	10	80	648
40	0.60	10	80	677
40	0.70	10	80	649
40	0.80	10	80	35444
40	0.90	10	80	35369
40	1.00	10	64	653
40	1.10	10	64	3253



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				



# DIXI 1533

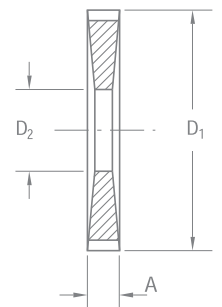
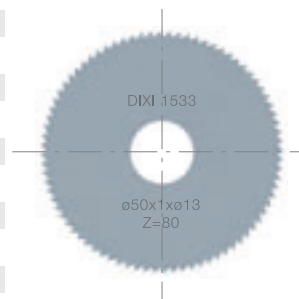
$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE
40	1.20	10	64	36049
40	1.30	10	64	43352
40	1.40	10	64	3422
40	1.50	10	64	36050
40	1.60	10	64	36051
40	1.70	10	64	6170
40	1.80	10	64	3424
40	2.00	10	48	656
40	2.50	10	48	36648
40	3.00	10	48	658
40	4.00	10	40	3737
40	5.00	10	40	35097
50	0.20	13	128	36385
50	0.25	13	128	3426
50	0.30	13	128	659
50	0.40	13	100	35234
50	0.50	13	100	31880
50	0.60	13	100	3030
50	0.70	13	100	2957
50	0.80	13	80	661
50	0.90	13	80	3255
50	1.00	13	80	662
50	1.10	13	80	1663
50	1.20	13	80	2536
50	1.30	13	80	3429
50	1.40	13	80	43114
50	1.50	13	64	37517
50	1.60	13	64	663
50	1.70	13	64	8001
50	1.80	13	64	36336
50	2.00	13	64	37806
50	2.50	13	64	37732
50	3.00	13	48	35636
50	4.00	13	48	667
50	5.00	13	48	35109
63	0.30	16	128	5398
63	0.40	16	128	669
63	0.50	16	128	2969
63	0.60	16	100	2634
63	0.70	16	100	3207
63	0.80	16	100	36739
63	1.00	16	100	671
63	1.20	16	80	35233
63	1.40	16	80	5093
63	1.50	16	80	2774
63	1.60	16	80	676
63	1.70	16	80	3432
63	1.80	16	80	3433
63	2.00	16	80	672
63	2.50	16	64	673
63	3.00	16	64	674
63	4.00	16	64	3748
63	5.00	16	48	31882



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				



# DIXI 1533

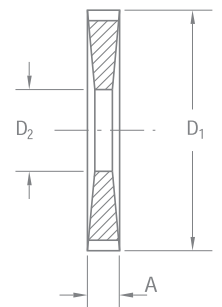
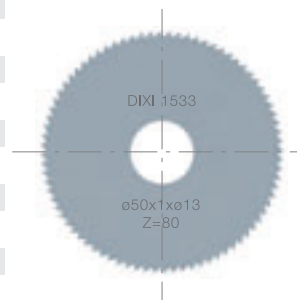
$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE
80	0.80	22	128	35817
80	1.00	22	100	679
80	1.20	22	100	680
80	1.40	22	100	3534
80	1.50	22	100	35721
80	1.60	22	100	19241
80	1.80	22	100	14115
80	2.00	22	80	17745
80	2.50	22	80	4030
80	3.00	22	80	684
80	4.00	22	64	21256
100	0.80	22	128	685
100	1.00	22	128	35816
100	1.20	22	128	38383
100	1.50	22	100	36363
100	1.60	22	100	3438
100	2.00	22	100	36048
100	2.50	22	100	689
100	3.00	22	80	36364
100	4.00	22	80	35138
100	5.00	22	80	35136
125	1.00	22	160	30687
125	1.20	22	128	35141
125	1.50	22	128	34954
125	2.00	22	128	34827
125	3.00	22	100	35294
160	1.20	32	160	34523
160	1.50	32	160	35299



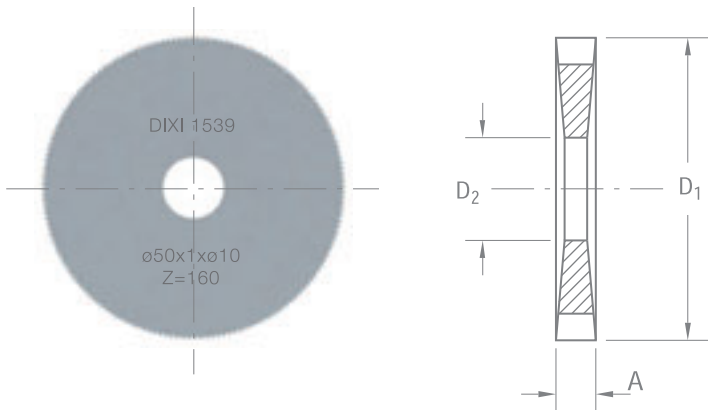
P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				



## SLITTING SAWS EXTRA FINE TEETH



P. 272



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	

$D_1 \pm 0.03$	$A \pm 0.005$	$D_2 H6$	Z	CARBIDE
10	0.10	3	60	964494
10	0.11	3	60	964499
10	0.12	3	60	964500
10	0.13	3	60	964501
10	0.14	3	60	964502
10	0.15	3	60	964503
10	0.16	3	60	964504
10	0.17	3	60	964505
10	0.18	3	60	964506
10	0.19	3	60	964507
10	0.20	3	60	964508
10	0.22	3	60	965568
10	0.24	3	60	963179
15	0.08	5	80	45005
15	0.10	5	80	40599
15	0.11	5	80	57238
15	0.12	5	80	23559
15	0.13	5	80	46325
15	0.14	5	80	38354
15	0.15	5	80	40588
15	0.16	5	80	28784
15	0.17	5	80	57240
15	0.18	5	80	27224
15	0.19	5	80	46858
15	0.20	5	80	19385
15	0.21	5	80	66021
15	0.23	5	80	58358
15	0.24	5	80	950356
15	0.25	5	80	19823
15	0.30	5	80	26517
15	0.35	5	80	40299
15	0.40	5	80	19825
15	0.50	5	80	19826
15	0.60	5	80	40300
15	0.70	5	80	40301
15	0.80	5	80	40302
15	0.90	5	80	40303
15	1.00	5	80	26518
15	1.10	5	80	40304
15	1.20	5	80	40305
15	1.40	5	80	40306
15	1.50	5	80	33843



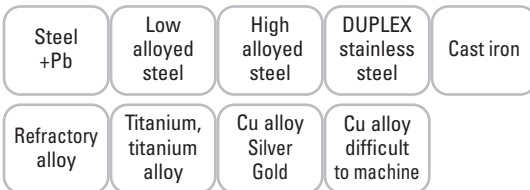
# DIXI 1539



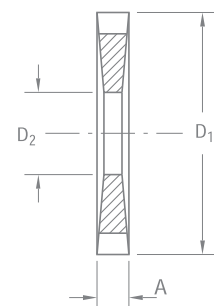
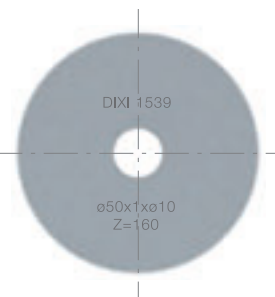
P. 272



$D_1 \pm 0.03$	$A \pm 0.005$	$D_2 H6$	Z	CARBIDE
20	0.12	5	100	40314
20	0.14	5	100	40307
20	0.15	5	100	43684
20	0.16	5	100	4913
20	0.18	5	100	16032
20	0.20	5	100	4914
20	0.25	5	100	28665
20	0.30	5	100	28340
20	0.35	5	100	40317
20	0.40	5	100	38355
20	0.50	5	100	35628
20	0.60	5	100	40320
20	0.70	5	100	40322
20	0.80	5	100	40324
20	0.90	5	100	40326
20	1.00	5	100	40328
20	1.10	5	100	40330
20	1.20	5	100	40332
20	1.40	5	100	40334
20	1.50	5	100	40336



20	0.12	6	100	40315
20	0.14	6	100	40308
20	0.16	6	100	40309
20	0.18	6	100	40310
20	0.20	6	100	40311
20	0.25	6	100	40312
20	0.30	6	100	40313
20	0.35	6	100	40316
20	0.40	6	100	40318
20	0.50	6	100	40319
20	0.60	6	100	40321
20	0.70	6	100	40323
20	0.80	6	100	40325
20	0.90	6	100	40327
20	1.00	6	100	40329
20	1.10	6	100	40331
20	1.20	6	100	40333
20	1.40	6	100	40335
20	1.50	6	100	40337



$D_1 js10$	$A \pm 0.01$	$D_2 H6$	Z	CARBIDE
25	0.20	6	120	3649
25	0.25	6	120	40339
25	0.30	6	120	40341
25	0.35	6	120	40343
25	0.40	6	120	40345
25	0.50	6	120	40347
25	0.60	6	120	40349
25	0.70	6	120	40351
25	0.80	6	120	40353
25	0.90	6	120	40355
25	1.00	6	120	40357
25	1.10	6	120	40359
25	1.20	6	120	40361
25	1.40	6	120	40363
25	1.50	6	120	40365

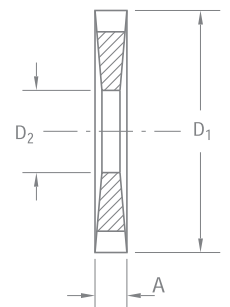
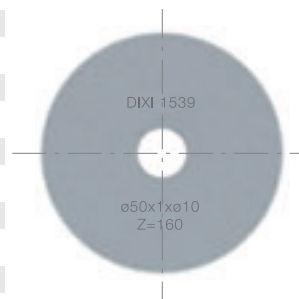
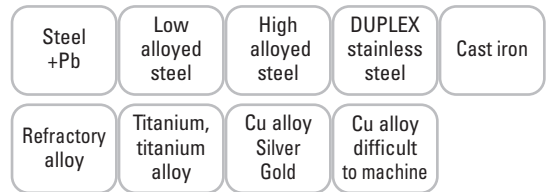


# DIXI 1539

$D_1 \pm 0.03$	$A \pm 0.005$	$D_2 H_6$	Z	CARBIDE
25	0.20	8	120	40338
25	0.25	8	120	40340
25	0.30	8	120	40342
25	0.35	8	120	40344
25	0.40	8	120	40346
25	0.50	8	120	40348
25	0.60	8	120	40350
25	0.70	8	120	40352
25	0.80	8	120	40354
25	0.90	8	120	40356
25	1.00	8	120	40358
25	1.10	8	120	40360
25	1.20	8	120	40362
25	1.40	8	120	40364
25	1.50	8	120	40366
30	0.30	8	128	40367
30	0.35	8	128	40368
30	0.40	8	128	40369
30	0.50	8	128	40370
30	0.60	8	128	40371
30	0.70	8	128	40372
30	0.80	8	128	40373
30	0.90	8	128	40374
30	1.00	8	128	40375
30	1.10	8	128	40376
30	1.20	8	128	40377
30	1.40	8	128	40378
30	1.50	8	128	40379
40	0.30	8	160	40393
40	0.35	8	160	40395
40	0.40	8	160	40397
40	0.50	8	160	40399
40	0.60	8	160	40401
40	0.70	8	160	40403
40	0.80	8	160	40405
40	0.90	8	160	40407
40	1.00	8	160	40409
40	1.20	8	160	40413
40	1.40	8	160	40415
40	1.50	8	160	40417
40	0.30	10	160	40394
40	0.35	10	160	40396
40	0.40	10	160	40398
40	0.50	10	160	40400
40	0.60	10	160	40402
40	0.70	10	160	40404
40	0.80	10	160	40406
40	0.90	10	160	40408
40	1.00	10	160	40410
40	1.10	10	160	40412
40	1.20	10	160	40414
40	1.50	10	160	40418



P. 272





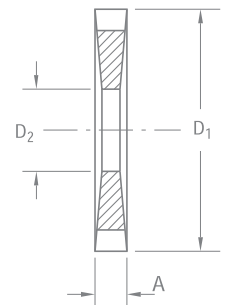
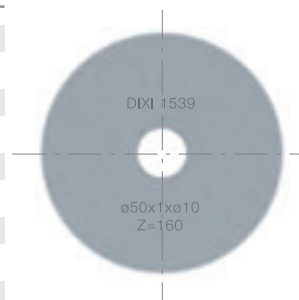


P. 272



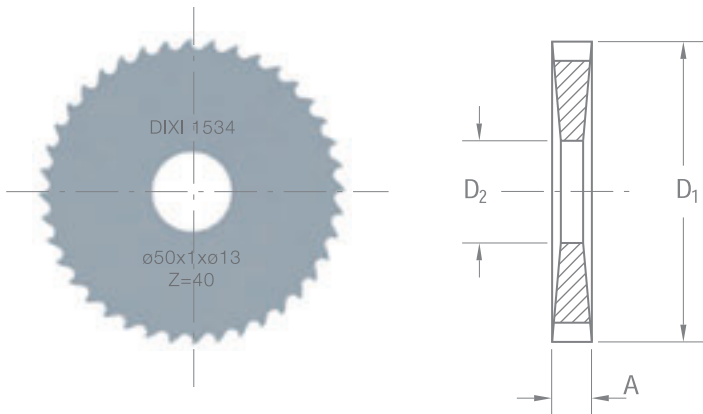
Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	

$D_1 \pm 0.03$	$A \pm 0.005$	$D_2 H6$	Z	CARBIDE
50	0.30	10	160	40445
50	0.40	10	160	40447
50	0.50	10	160	40448
50	0.60	10	160	40449
50	0.70	10	160	40450
50	0.80	10	160	40451
50	0.90	10	160	40452
50	1.00	10	160	40453
50	1.20	10	160	40455
50	1.50	10	160	40457



# DIXI 1534

## SLITTING SAWS HELLER PITCH TEETH



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				

$D_1$ js12	$A_{\pm 0.01}$	$D_2$ H6	Z	CARBIDE
20	0.30	5	32	34869
20	0.50	5	24	29836
20	0.60	5	24	29541
20	0.70	5	24	29282
20	0.80	5	24	31598
20	0.90	5	24	42581
20	1.00	5	20	39176
20	1.20	5	20	42582
20	1.30	5	20	42583
20	1.50	5	20	31267
20	1.80	5	20	953401
20	2.00	5	16	39550
20	3.00	5	16	42424
25	0.30	8	40	29785
25	0.50	8	32	42427
25	0.60	8	32	42428
25	0.80	8	24	29542
25	0.90	8	24	42430
25	1.00	8	24	30411
25	1.20	8	24	37925
25	1.30	8	24	42431
25	1.50	8	20	38204
25	2.50	8	20	38360
30	0.30	8	40	42434
30	0.40	8	40	42435
30	0.50	8	40	28826
30	0.60	8	32	3308
30	0.70	8	32	38803
30	0.80	8	32	38804
30	1.00	8	32	38806
30	1.20	8	24	36576



# DIXI 1534

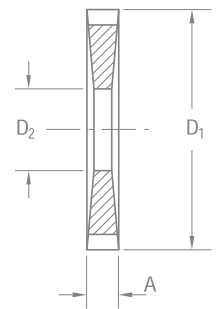
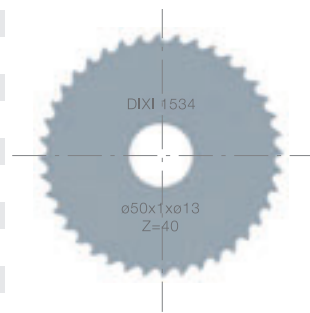
$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE
30	1.30	8	24	38114
30	1.50	8	24	36577
30	1.60	8	24	38756
30	1.80	8	24	36419
30	2.00	8	24	35379
63	0.40	16	64	34999
63	0.50	16	64	2872
63	0.60	16	48	37364
63	0.80	16	48	29794
63	1.00	16	48	28979
63	1.20	16	40	42586
63	1.30	16	40	40597
63	1.50	16	40	28990
63	1.60	16	40	41638
63	1.80	16	40	37787
63	2.00	16	40	28845
63	2.50	16	32	35380
63	3.00	16	32	28828
80	0.80	22	64	36043
80	1.00	22	48	29219
80	1.20	22	48	35967
80	1.50	22	48	18568
80	1.60	22	48	42449
80	2.00	22	40	28829
100	0.80	22	64	35381
100	1.00	22	64	35429
100	1.20	22	64	35431
100	1.50	22	48	25267
100	1.60	22	48	25335
100	2.00	22	48	29408



P. 270



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				

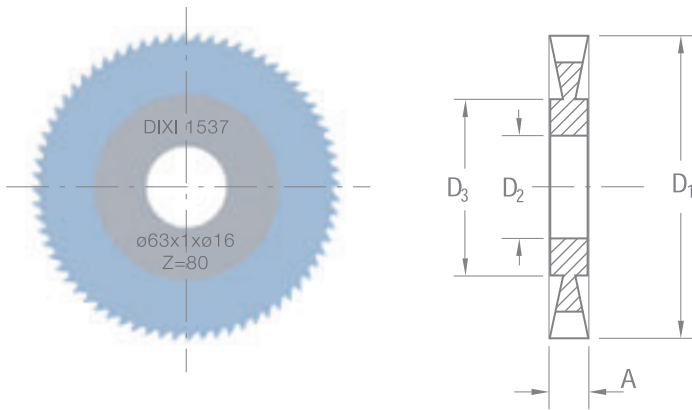


# DIXI 1537 CUTINOX

## SLITTING SAWS FOR STAINLESS STEEL



P. 272



High alloyed steel

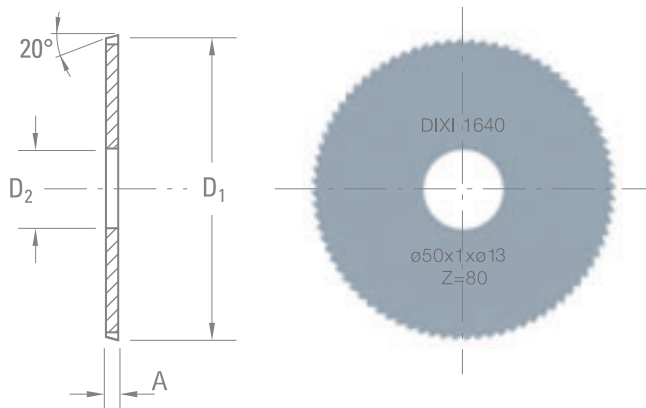
DUPLEX stainless steel

$D_{1js12}$	$A_{\pm 0.01}$	$D_3$	$D_{2H6}$	Z	CUTINOX
50	0.80	30	13	68	954330
50	1.00	30	13	68	954331
63	0.60	40	16	80	60407
63	0.80	40	16	80	60408
63	1.00	40	16	80	60409
80	0.60	50	22	100	60410
80	0.80	50	22	100	60411
80	1.00	50	22	100	60414
100	0.80	60	22	120	60412
100	1.00	60	22	120	60413



## DIXI 1640 R + L

### PARTING OFF SLITTING SAWS LEFT AND RIGHT HAND CUTTING

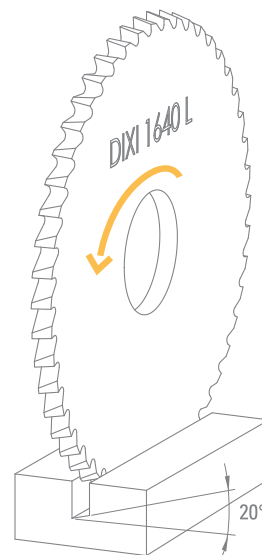


P. 270

Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Alu
Plastic				

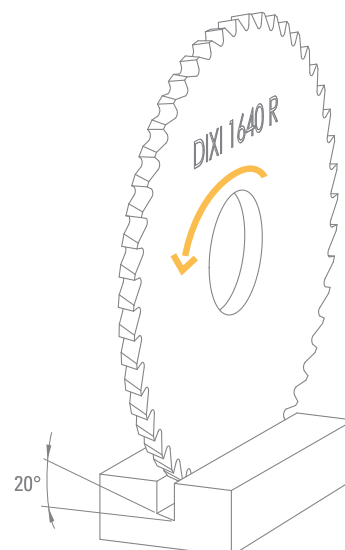
### DIXI 1640 L

$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE	CUTINOX
50	0.50	13	100	977529	977548
50	0.80	13	80	977530	957215
50	1.00	13	80	977531	977549
63	0.50	16	128	977532	977552
63	0.80	16	100	954255	977553
63	1.00	16	100	977533	955787
80	0.80	22	128	975393	975569
80	1.00	22	100	977534	977554
100	0.80	22	100	977535	977555
100	1.00	22	100	977536	977556

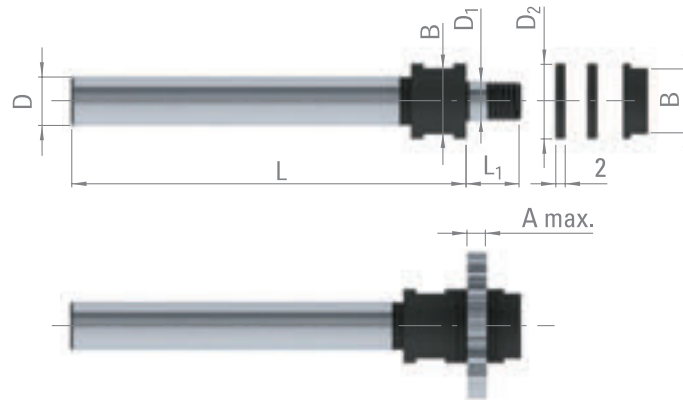


### DIXI 1640 R

$D_{1js12}$	$A_{\pm 0.01}$	$D_{2H6}$	Z	CARBIDE	CUTINOX
50	0.50	13	100	977520	977537
50	0.80	13	80	977521	977538
50	1.00	13	80	59024	977539
63	0.50	16	128	977522	977540
63	0.80	16	100	977523	977541
63	1.00	16	100	977524	977542
80	0.80	22	128	977525	977543
80	1.00	22	100	977526	977544
100	0.80	22	100	977527	977545
100	1.00	22	100	977528	977547



MILLING ARBORS  
WITH FRONT CLAMPING

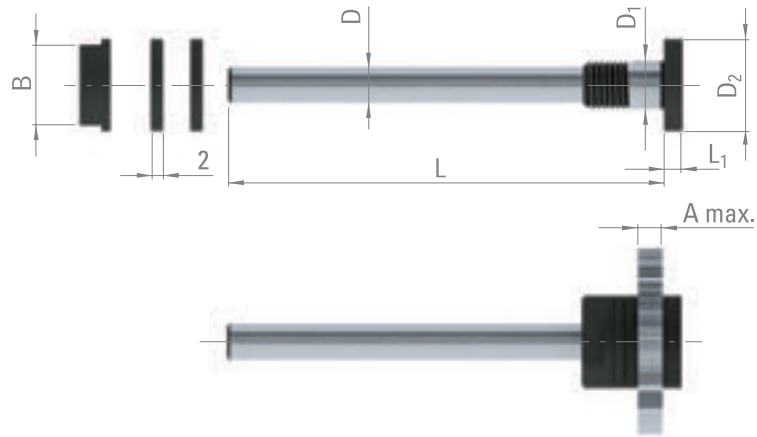


$D_{1\ h6}$	$D_{h6}$	$D_2$	L	$L_1$	B	$A_{\max.}$	Art.
3.00	5	5	60	7.0	4	3	968329
5.00	6	10	70	10.0	8	6	953911
5.00	10	10	80	10.0	8	6	953917
6.00	10	12	80	10.5	10	6	953918
8.00	10	15	80	10.0	13	6	954975
8.00	12	15	90	11.0	13	6	953919
10.00	10	18	80	10.5	15	6	954976
10.00	16	18	100	11.5	15	6	953920
13.00	16	22	110	12.0	19	6	953921
16.00	20	26	120	13.0	22	6	953922



# DIXI 2714

## MILLING ARBORS WITH REAR CLAMPING



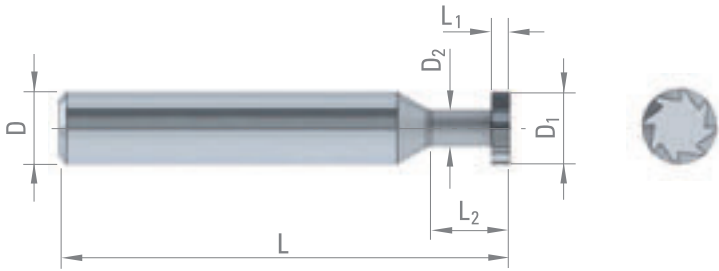
$D_{1\ h6}$	$D_{\ h6}$	$D_2$	L	$L_1$	B	$A_{\ max.}$	Art.
5.00	4	10	50	3.0	8	6	953923
6.00	5	12	60	3.0	10	6	953924
8.00	6	15	70	3.0	13	6	953925
8.00	7	15	80	3.0	13	6	953926
10.00	6	18	70	3.5	15	6	953927
10.00	8	18	90	3.5	15	6	953928
13.00	10	22	110	3.5	19	6	953929
16.00	12	26	120	3.5	22	6	953930



T-SLOT CUTTERS  
STRAIGHT FLUTE

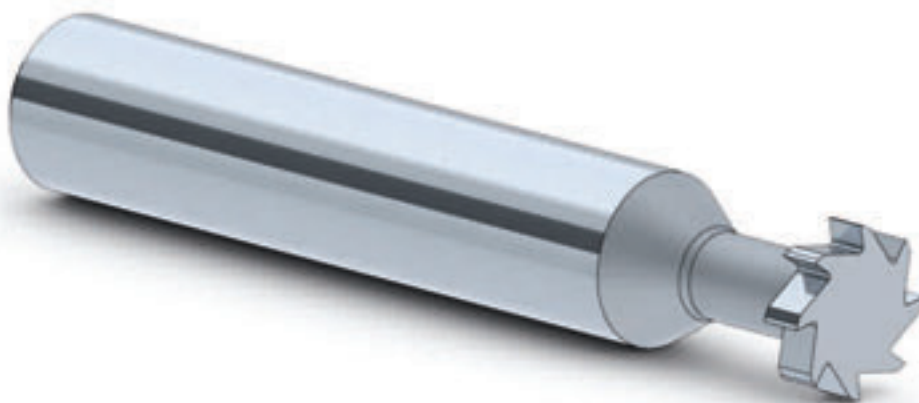


P. 274



- Steel +Pb
- Low alloyed steel
- DUPLEX stainless steel
- Titanium, titanium alloy
- Cu alloy Silver Gold
- Alu
- Plastic

D <sub>1</sub> ∅ < 4.0 ±0.01 ∅ ≥ 4.0 -0.05/-0.10	L <sub>1</sub>	D <sub>2</sub> 0/-0.20	L <sub>2</sub> ±0.2	D <sub>h5</sub>	L	Z	CARBIDE	CUTINOX
2.0	0.2 - 1.0	1.0	3.0	4	42	3 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
3.0	0.2 - 1.5	1.5	3.5	4	42	3 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.0	0.2 - 1.5	2.5	6.0	4	42	3 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
5.0	0.5 - 1.5	3.0	6.0	5	42	3 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
6.0	0.5 - 2.5	3.5	7.0	6	42	4 - 8	<input type="checkbox"/>	<input checked="" type="checkbox"/>
8.0	0.5 - 3.0	4.0	9.0	8	50	5 - 10	<input type="checkbox"/>	<input checked="" type="checkbox"/>
10.0	0.5 - 4.0	5.0	9.0	10	50	5 - 12	<input type="checkbox"/>	<input checked="" type="checkbox"/>
12.0	0.5 - 3.5	5.0	11.5	6	50	6 - 16	<input type="checkbox"/>	<input checked="" type="checkbox"/>
12.0	0.5 - 4.0	6.0	14.0	10	50	6 - 16	<input type="checkbox"/>	<input checked="" type="checkbox"/>
15.0	0.5 - 5.0	8.0	14.0	10	60	8 - 18	<input type="checkbox"/>	<input checked="" type="checkbox"/>
16.0	0.5 - 2.9	8.0	14.0	10	60	8 - 20	<input type="checkbox"/>	<input checked="" type="checkbox"/>
16.0	3.0 - 6.0	8.0	14.0	10	60	8 - 20	<input type="checkbox"/>	<input checked="" type="checkbox"/>
18.0	0.5 - 2.9	8.0	14.0	10	60	10 - 24	<input type="checkbox"/>	<input checked="" type="checkbox"/>
18.0	3.0 - 6.0	8.0	14.0	10	60	10 - 24	<input type="checkbox"/>	<input checked="" type="checkbox"/>
20.0	0.5 - 2.9	8.0	11.0	10	60	10 - 24	<input type="checkbox"/>	<input checked="" type="checkbox"/>
20.0	3.0 - 6.0	8.0	14.0	10	60	10 - 24	<input type="checkbox"/>	<input checked="" type="checkbox"/>
25.0	0.5 - 3.9	8.0	13.0	10	60	10 - 32	<input type="checkbox"/>	<input checked="" type="checkbox"/>
25.0	4.0 - 8.0	8.0	18.0	10	60	10 - 32	<input type="checkbox"/>	<input checked="" type="checkbox"/>
30.0	0.5 - 3.9	8.0	13.0	10	60	10 - 36	<input type="checkbox"/>	<input checked="" type="checkbox"/>
30.0	4.0 - 8.0	8.0	18.0	10	60	10 - 36	<input type="checkbox"/>	<input checked="" type="checkbox"/>

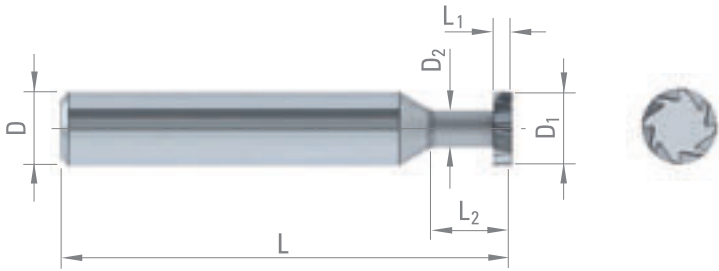




T-SLOT CUTTERS  
STAGGERED TOOTH

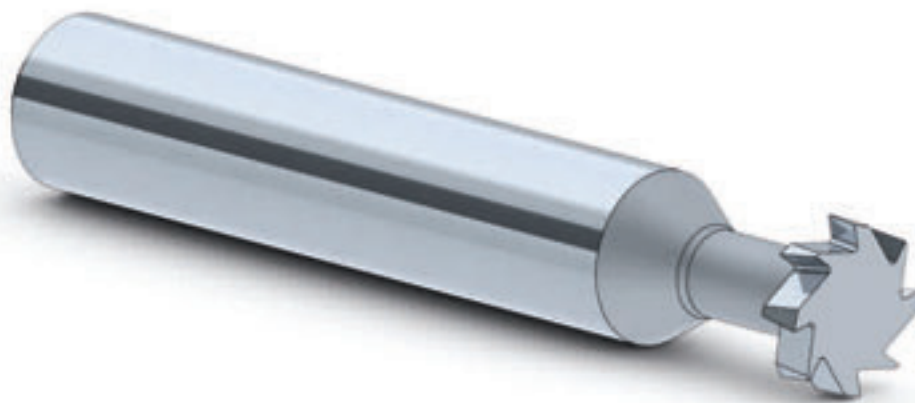


P. 274



- Steel +Pb
- Low alloyed steel
- DUPLEX stainless steel
- Titanium, titanium alloy
- Cu alloy Silver Gold
- Alu
- Plastic

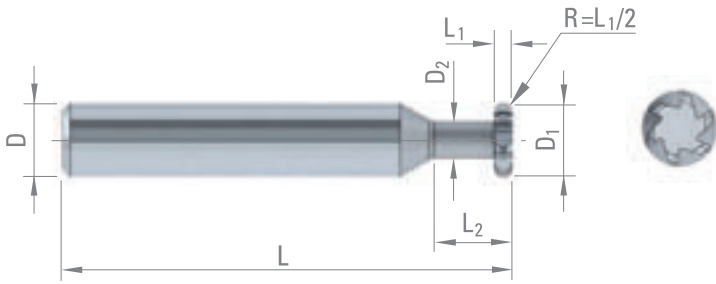
D <sub>1</sub> Ø < 4.0 ±0.01 Ø ≥ 4.0 -0.05/-0.10	L <sub>1</sub>	D <sub>2</sub> 0/-0.20	L <sub>2</sub> ±0.2	D <sub>h5</sub>	L	Z	CARBIDE	CUTINOX
4.0	0.5 - 3.0	2.5	6.0	4	42	4 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
5.0	0.5 - 3.0	3.0	6.0	5	42	4 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
6.0	0.5 - 3.0	3.5	7.0	6	42	4 - 6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
8.0	1.0 - 4.0	4.0	9.0	8	50	4 - 8	<input type="checkbox"/>	<input checked="" type="checkbox"/>
10.0	1.0 - 4.0	5.0	9.0	10	50	6 - 10	<input type="checkbox"/>	<input checked="" type="checkbox"/>
12.0	0.5 - 3.5	5.0	11.5	6	50	6 - 10	<input type="checkbox"/>	<input checked="" type="checkbox"/>
12.0	1.0 - 5.0	6.0	14.0	10	50	6 - 10	<input type="checkbox"/>	<input checked="" type="checkbox"/>
15.0	1.5 - 6.0	8.0	14.0	10	60	8 - 14	<input type="checkbox"/>	<input checked="" type="checkbox"/>
16.0	1.5 - 3.9	8.0	14.0	10	60	8 - 14	<input type="checkbox"/>	<input checked="" type="checkbox"/>
16.0	4.0 - 6.0	8.0	14.0	10	60	8 - 14	<input type="checkbox"/>	<input checked="" type="checkbox"/>
18.0	1.5 - 3.9	8.0	14.0	10	60	10 - 16	<input type="checkbox"/>	<input checked="" type="checkbox"/>
18.0	4.0 - 6.0	8.0	14.0	10	60	10 - 16	<input type="checkbox"/>	<input checked="" type="checkbox"/>
20.0	1.5 - 3.9	8.0	11.0	10	60	10 - 18	<input type="checkbox"/>	<input checked="" type="checkbox"/>
20.0	4.0 - 6.0	8.0	14.0	10	60	10 - 18	<input type="checkbox"/>	<input checked="" type="checkbox"/>
25.0	1.5 - 4.9	8.0	13.0	10	60	10 - 24	<input type="checkbox"/>	<input checked="" type="checkbox"/>
25.0	5.0 - 10.0	8.0	18.0	10	60	14 - 24	<input type="checkbox"/>	<input checked="" type="checkbox"/>
30.0	1.5 - 4.9	8.0	13.0	10	60	18 - 28	<input type="checkbox"/>	<input checked="" type="checkbox"/>
30.0	5.0 - 10.0	8.0	18.0	10	60	18 - 28	<input type="checkbox"/>	<input checked="" type="checkbox"/>



T-SLOT CUTTERS  
FULL RADIUS

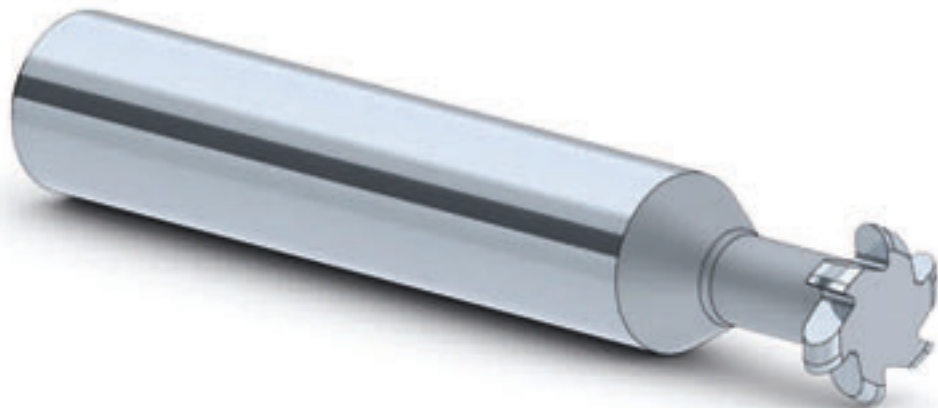


P. 274



- Steel +Pb
- Low alloyed steel
- DUPLEX stainless steel
- Titanium, titanium alloy
- Cu alloy Silver Gold
- Alu
- Plastic

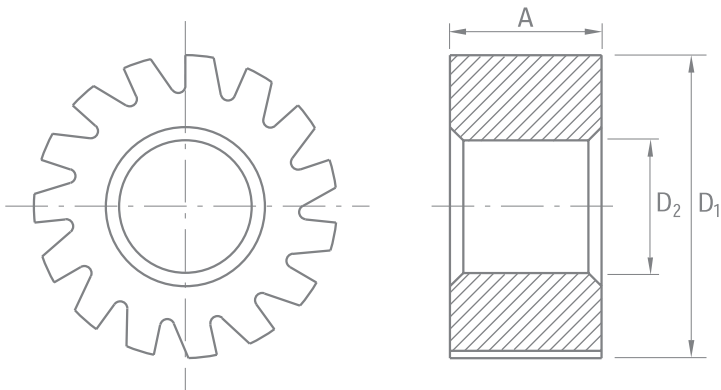
D <sub>1</sub> ∅ < 4.0 ±0.03 ∅ ≥ 4.0 -0.05/-0.10	L <sub>1</sub>	D <sub>2</sub> 0/-0.20	L <sub>2</sub> ±0.2	D <sub>h5</sub>	L	Z	CARBIDE	CUTINOX
4.0	0.4 - 1.5	1.5	6.0	4	42	4	<input type="checkbox"/>	<input checked="" type="checkbox"/>
6.0	0.5 - 2.0	3.5	7.0	6	42	6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
8.0	1.0 - 3.0	4.0	9.0	8	50	6	<input type="checkbox"/>	<input checked="" type="checkbox"/>
10.0	1.0 - 4.0	5.0	9.0	10	50	8	<input type="checkbox"/>	<input checked="" type="checkbox"/>
12.0	0.5 - 3.5	5.0	11.5	6	50	10	<input type="checkbox"/>	<input checked="" type="checkbox"/>
12.0	1.0 - 5.0	6.0	14.0	10	50	10	<input type="checkbox"/>	<input checked="" type="checkbox"/>
16.0	1.0 - 6.0	8.0	14.0	10	60	12	<input type="checkbox"/>	<input checked="" type="checkbox"/>



Other tooth shapes see page 269



HOB CUTTERS  
EPICYCLIC AND INVOLUTE PROFILE



- Steel +Pb
- Low alloyed steel
- High alloyed steel
- DUPLEX stainless steel
- Titanium, titanium alloy
- Cu alloy Silver Gold
- Cu alloy difficult to machine
- Alu

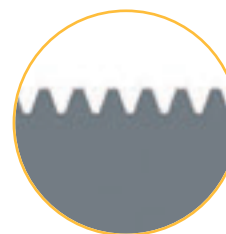
D <sub>1</sub>	A	D <sub>2H3</sub>	Z	CARBIDE
6	4	3.5	12	□
	5	3.5	12	□
	6	3.5	12	□
8	4	3.5	15	□
	5	3.5	12	□
10	6	3.5	12	□
	4	3.5	15	□
	5	3.5	12	□
	6	3.5	12	□
	6	4.5	12	□
	6	4.5	15	□
12	6	3.5	15	□
	6	4.5	12	□
	6	4.5	15	□
	6	5.0	12	□
	6	5.0	15	□
	6	6.0	12	□
	6	6.0	15	□
	8	4.5	15	□
	8	5.0	15	□
	8	6.0	15	□
16	10	8.0	12	□
	6	8.0	12	□
	6	8.0	15	□
	8	8.0	12	□
	8	8.0	15	□
	10	8.0	12	□
18	10	8.0	15	□
	10	8.0	12	□
	12	8.0	12	□
	12	8.0	15	□
	6	6.0	12	□
	6	8.0	12	□
	6	8.0	15	□
24	8	8.0	12	□
	8	8.0	15	□
	10	8.0	12	□
	10	8.0	15	□
	12	8.0	12	□
	12	8.0	15	□
	16	8.0	12	□
	16	8.0	15	□
	16	10.0	12	□

Module (m) = 0.04 - 1.00

DIXI 1675  
Epicyclic



DIXI 1680  
Involute



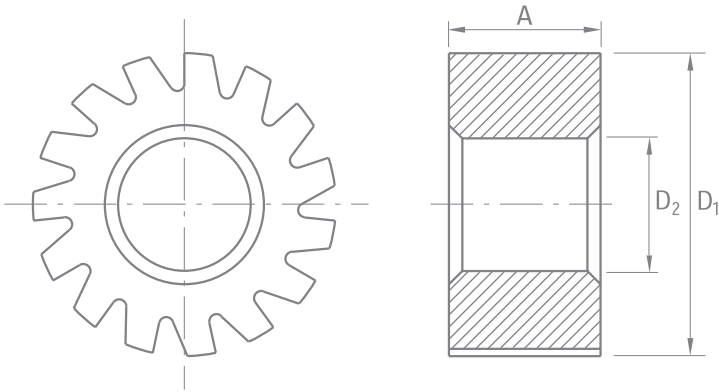
Regrindable  
logarithmic relief



Coatings on request

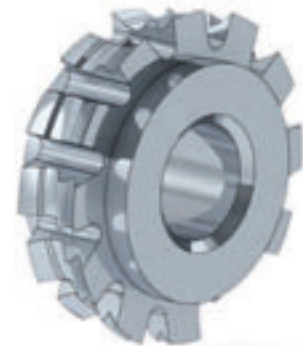


HOB CUTTERS  
FOR INDEX

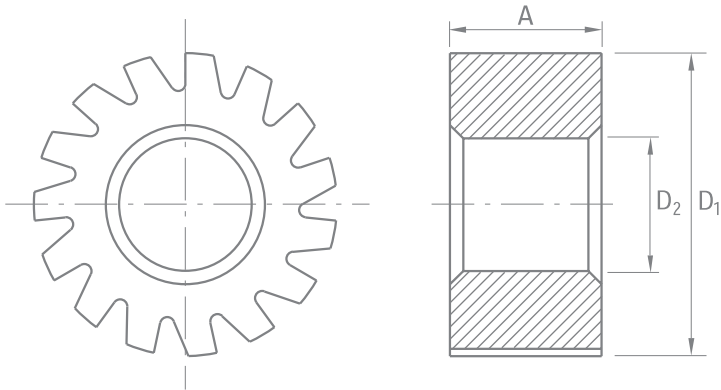


Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Titanium, titanium alloy
Cu alloy Silver Gold	Cu alloy difficult to machine	Alu		

D <sub>1</sub>	A	D <sub>2 H3</sub>	Z	CARBIDE
6	4	3.5	12	<input type="checkbox"/>
6	5	3.5	12	<input type="checkbox"/>
6	6	3.5	12	<input type="checkbox"/>
8	5	3.5	12	<input type="checkbox"/>
8	6	3.5	12	<input type="checkbox"/>
10	5	3.5	12	<input type="checkbox"/>
10	6	3.5	12	<input type="checkbox"/>
10	6	4.5	12	<input type="checkbox"/>
12	6	4.5	12	<input type="checkbox"/>
12	6	5.0	12	<input type="checkbox"/>
12	6	6.0	12	<input type="checkbox"/>
16	6	8.0	12	<input type="checkbox"/>
16	8	8.0	12	<input type="checkbox"/>
16	10	8.0	12	<input type="checkbox"/>
18	6	6.0	12	<input type="checkbox"/>
18	8	8.0	12	<input type="checkbox"/>
18	10	8.0	12	<input type="checkbox"/>
24	6	8.0	12	<input type="checkbox"/>
24	8	8.0	12	<input type="checkbox"/>
24	10	8.0	12	<input type="checkbox"/>
24	12	8.0	12	<input type="checkbox"/>



HOB CUTTERS  
FRONTAL GEAR CUTTING



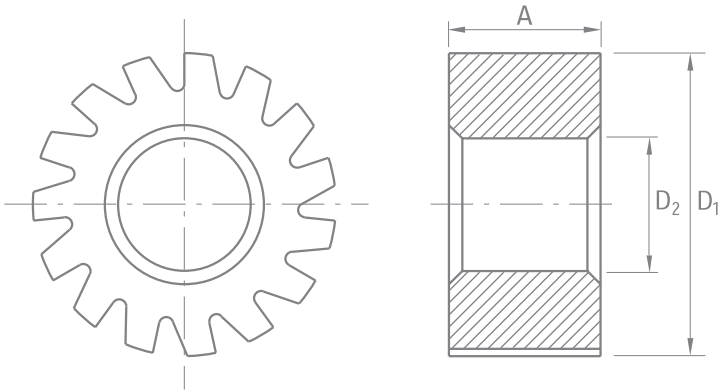
Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Titanium, titanium alloy
Cu alloy Silver Gold	Cu alloy difficult to machine	Alu		

D <sub>1</sub>	A	D <sub>2H3</sub>	Z	CARBIDE
10	2	4.5	4	<input type="checkbox"/>
10	2	4.5	5	<input type="checkbox"/>
10	2	4.5	6	<input type="checkbox"/>
12	2	4.5	2	<input type="checkbox"/>
12	2	4.5	3	<input type="checkbox"/>
12	2	4.5	4	<input type="checkbox"/>
12	2	4.5	5	<input type="checkbox"/>
12	2	4.5	6	<input type="checkbox"/>

Module (m) = 0.03 - 1.00



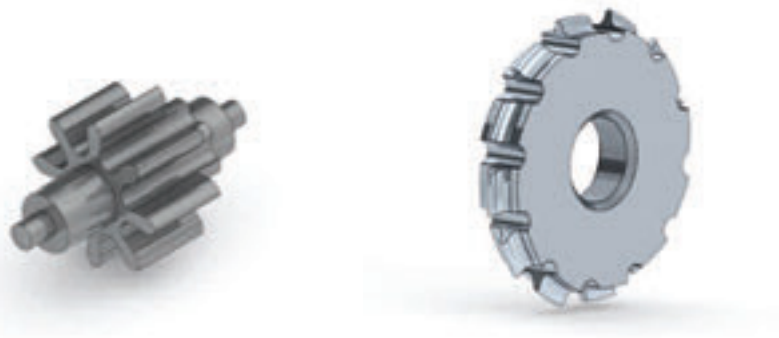
MODULE CUTTERS  
TOOTH PER TOOTH CUTTING



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Titanium, titanium alloy
Cu alloy Silver Gold	Cu alloy difficult to machine	Alu		

Module (m) = 0.03 - 1.00

D <sub>1</sub>	A	D <sub>2H3</sub>	Z	CARBIDE
6	4	3.5	12	<input type="checkbox"/>
8	5	3.5	12	<input type="checkbox"/>
8	6	3.5	12	<input type="checkbox"/>
10	2	3.5	12	<input type="checkbox"/>
10	2	4.5	12	<input type="checkbox"/>
10	2	5.0	12	<input type="checkbox"/>
10	5	3.5	12	<input type="checkbox"/>
10	6	3.5	12	<input type="checkbox"/>
12	2	3.5	12	<input type="checkbox"/>
12	2	4.5	12	<input type="checkbox"/>
12	6	5.0	12	<input type="checkbox"/>
16	6	8.0	12	<input type="checkbox"/>
18	6	8.0	12	<input type="checkbox"/>
24	6	8.0	12	<input type="checkbox"/>





TOOLS ON REQUEST

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Norm 

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Plan 

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DXF 

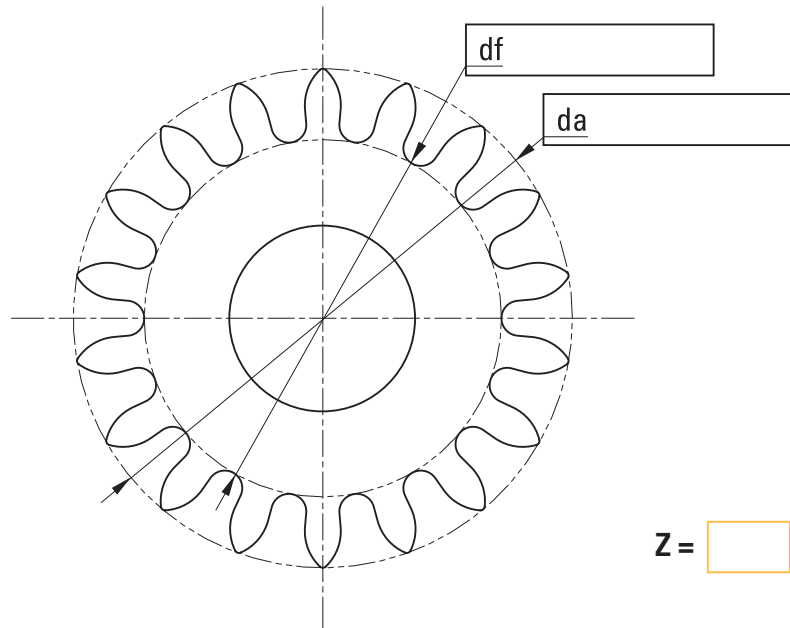
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Material to be machined 

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Module (m) 

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$D_1$  

---

A 

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$D_2$  

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Helix angle (profile) **R**  **L**

Number of profile 

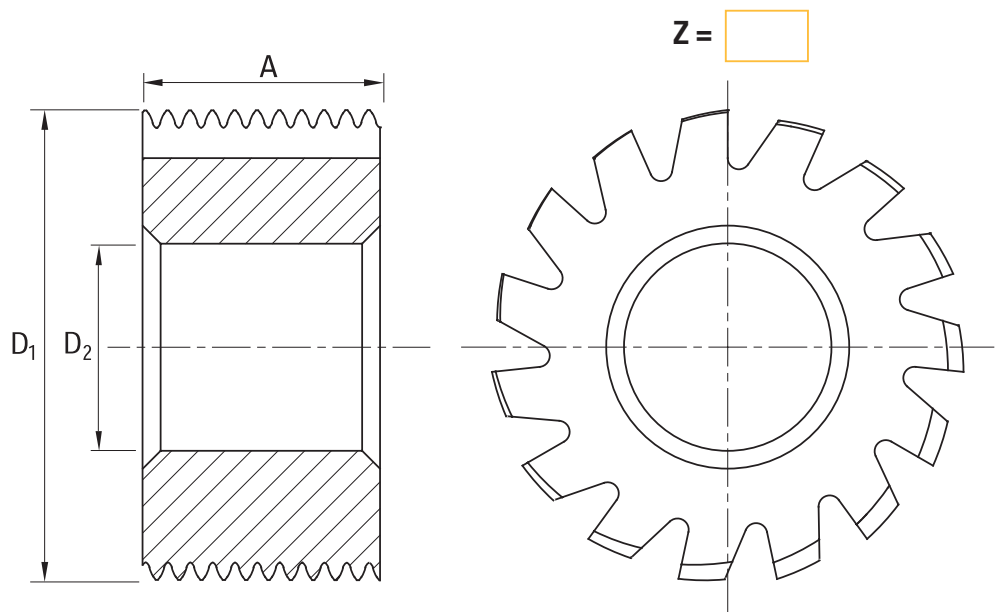
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Coating 

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Quantity 

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Notice 

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TOOLS ON REQUEST

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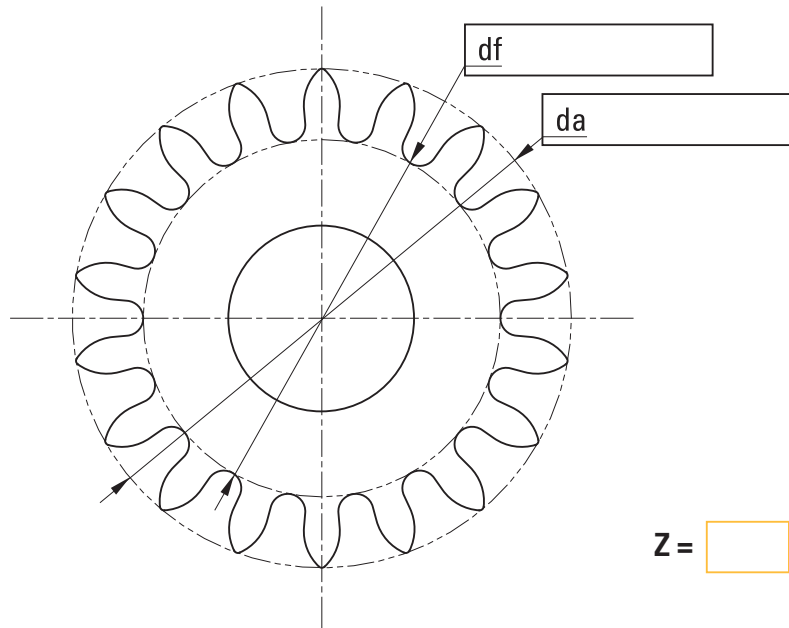
Norm \_\_\_\_\_

Plan \_\_\_\_\_

DXF \_\_\_\_\_

Material to be machined \_\_\_\_\_

Module (m) \_\_\_\_\_



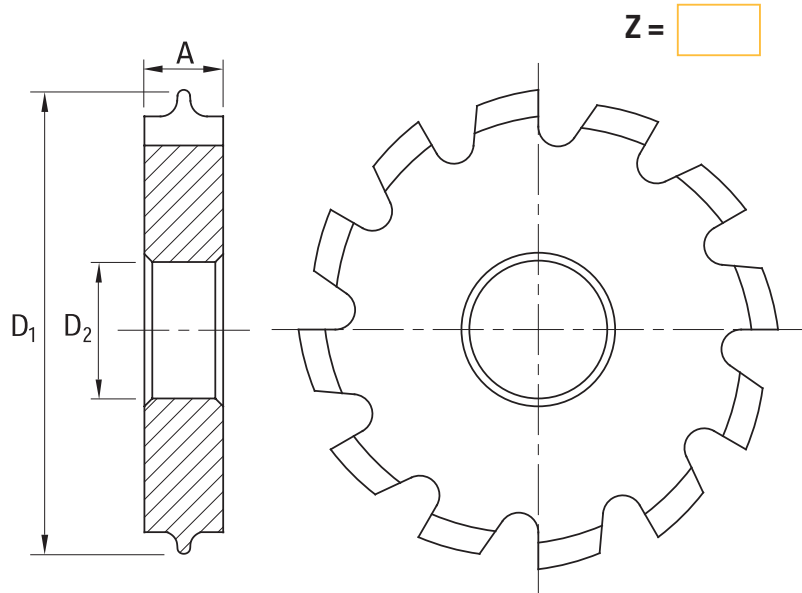
$D_1$  \_\_\_\_\_

A \_\_\_\_\_

$D_2$  \_\_\_\_\_

Coating \_\_\_\_\_

Quantity \_\_\_\_\_



Notice

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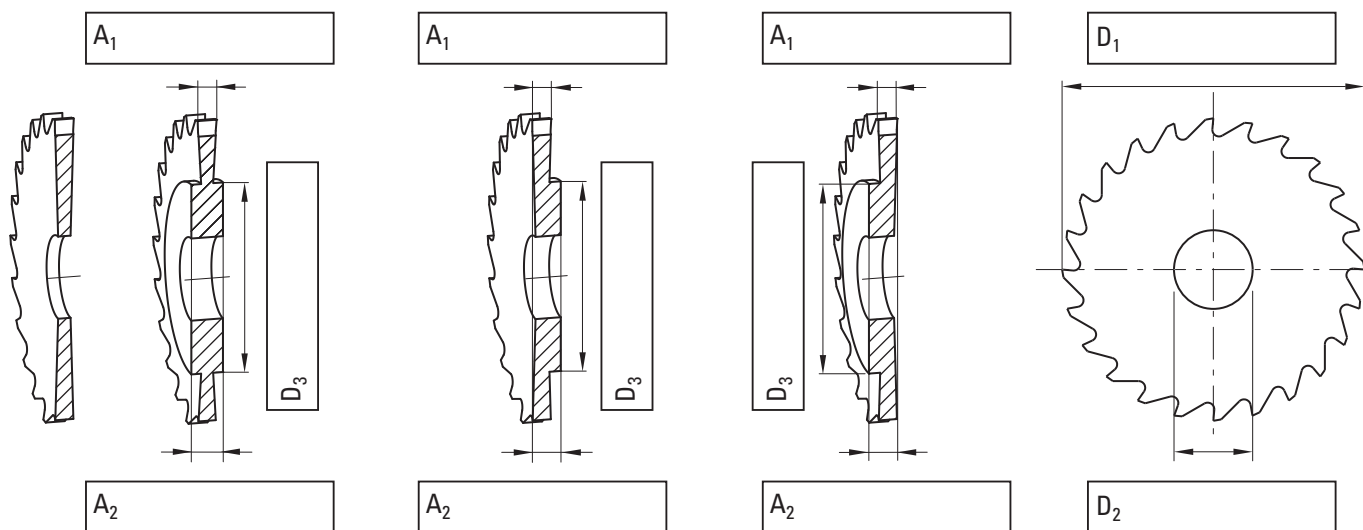




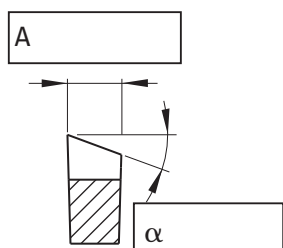
# TOOLS ON REQUEST

Quantity

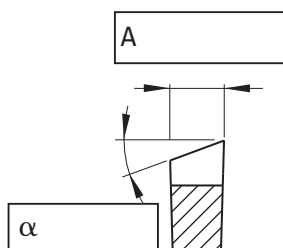
Material to be machined



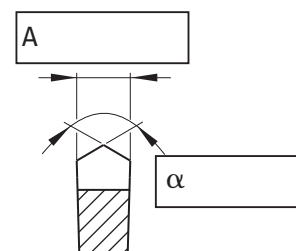
**1640 L**



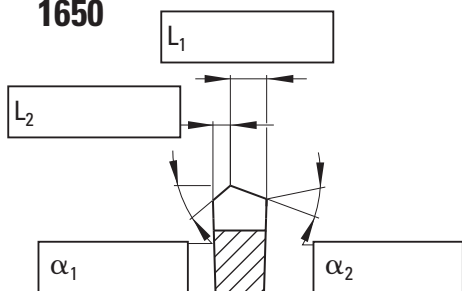
**1640 R**



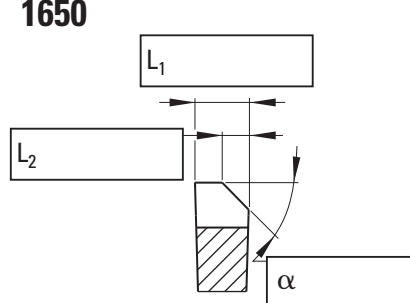
**1643**



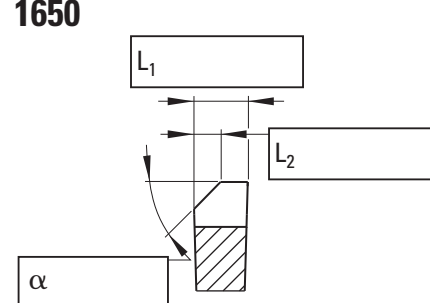
**1650**



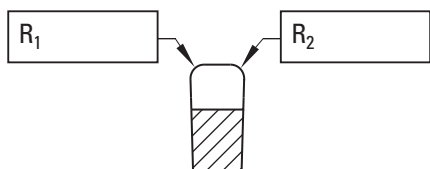
**1650**



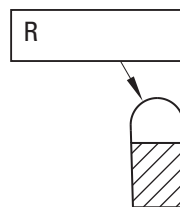
**1650**



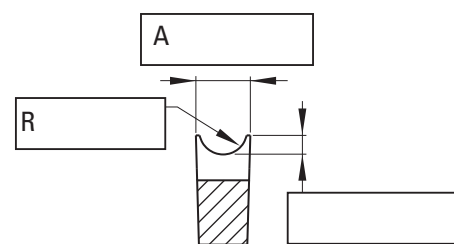
**1650**



**1654**



**1650**





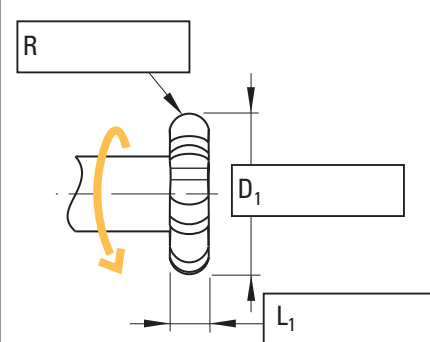
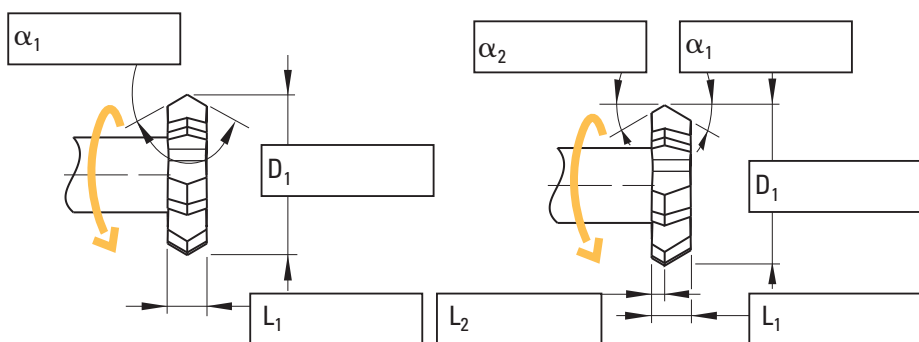
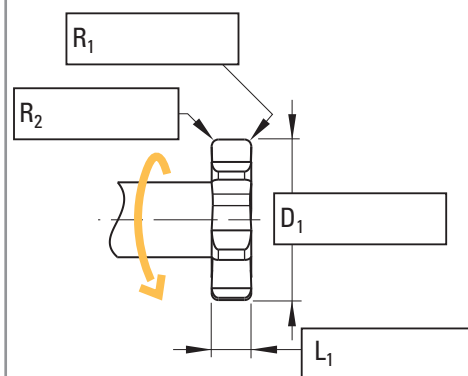
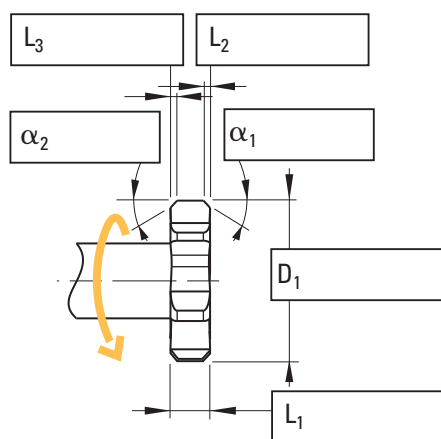
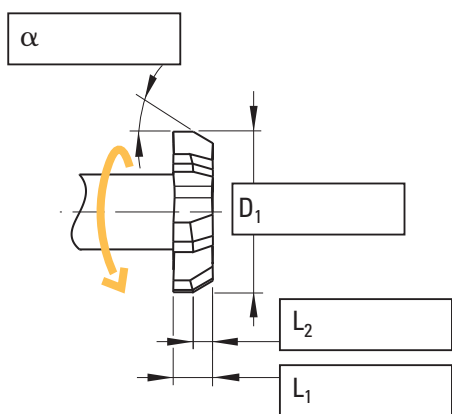
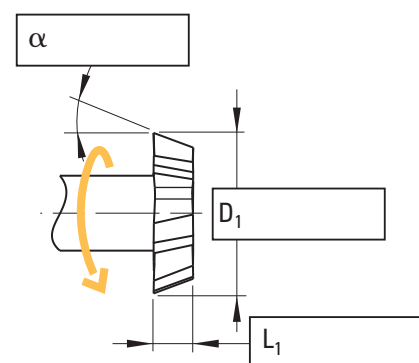
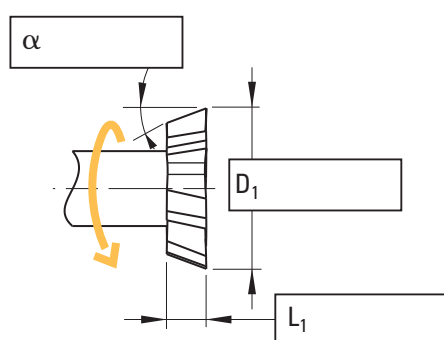
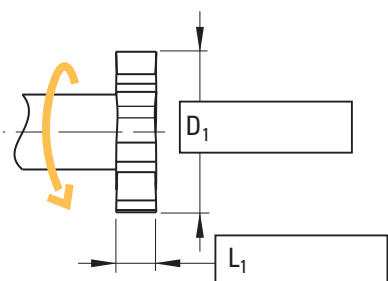
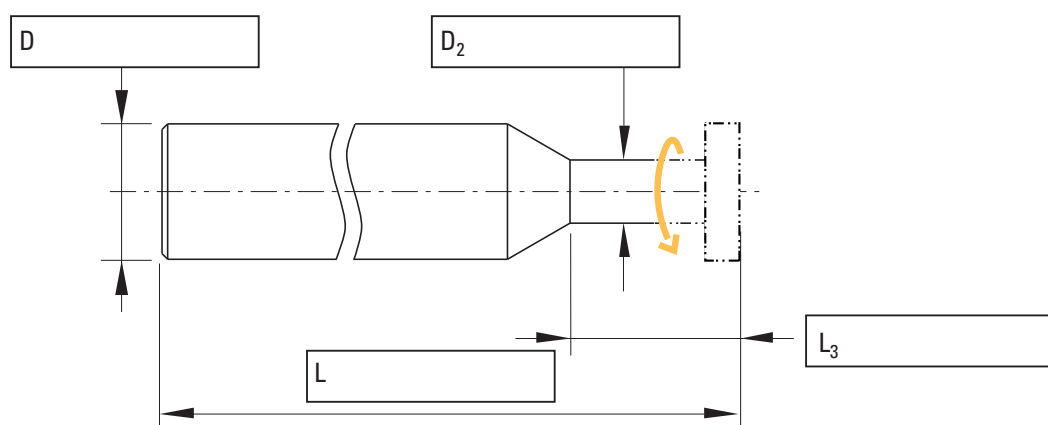
# TOOLS ON REQUEST

## T-SLOT CUTTERS

Z =

Quantity

Material to be machined



VISIT OUR E-QUOTATION ON [WWW.DIXIPOLYTOOL.COM](http://WWW.DIXIPOLYTOOL.COM)



## CUTTING CONDITIONS

Material to be machined			CARBIDE	
			Vc [m/min]	
<b>P</b>	Unalloyed steel / Low alloyed steel	< 600 N/mm <sup>2</sup>	<b>80</b>	140
<b>P</b>	Unalloyed steel / Low alloyed steel	600 – 1500 N/mm <sup>2</sup>	<b>50</b>	80
<b>P</b>	Lead alloyed cutting steel		<b>120</b>	160
<b>P</b>	High alloyed steel	700 – 1500 N/mm <sup>2</sup>	<b>50</b>	80
<b>M</b>	Stainless steel	400 – 700 N/mm <sup>2</sup>	<b>80</b>	120
<b>M</b>	DUPLEX stainless steel	> 800 N/mm <sup>2</sup>	<b>50</b>	80
<b>K</b>	Grey cast iron / Nodular pearlitic iron	< 250 HB	<b>80</b>	140
<b>K</b>	Alloyed cast iron / Nodular pearlitic iron	> 250 HB	<b>50</b>	80
<b>K</b>	Nodular ferritic cast iron / Malleable cast iron		<b>50</b>	80
<b>S</b>	Special alloys / Heat resistant stainless steel	Inconel Nimonic Hastelloy	<b>20</b>	30
<b>S</b>	Titanium, titanium alloys		<b>30</b>	70
<b>N</b>	Copper alloys - easy to machine (brass - bronze)		<b>200</b>	450
<b>N</b>	Copper alloys - difficult to machine / Aluminium bronze	(CuAlFe) (Ampco)	<b>150</b>	300
<b>N</b>	Aluminium alloys	Si < 8%	<b>200</b>	500
<b>N</b>	Cast aluminium	Si > 8%	<b>200</b>	450
<b>N</b>	Plastic		<b>130</b>	200
<b>N</b>	Gold, silver		<b>140</b>	180



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

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

Feed per tooth

$f_z$  [mm]

$\emptyset D_1$ 15 - 30	$\emptyset D_1$ 30 - 50	$\emptyset D_1$ 50 - 80	$\emptyset D_1$ 80 - 125	$\emptyset D_1$ 125 - 160
0.002 - 0.004	0.003 - 0.007	0.004 - 0.008	0.004 - 0.012	0.004 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.002 - 0.004	0.003 - 0.007	0.004 - 0.01	0.004 - 0.01	0.004 - 0.01
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.002 - 0.004	0.003 - 0.007	0.004 - 0.01	0.004 - 0.01	0.004 - 0.01
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.001 - 0.004	0.002 - 0.005	0.002 - 0.008	0.003 - 0.012	0.003 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012
0.003 - 0.010	0.004 - 0.010	0.005 - 0.012	0.005 - 0.012	0.005 - 0.015
0.003 - 0.007	0.004 - 0.008	0.005 - 0.010	0.005 - 0.010	0.005 - 0.012



**CUTTING CONDITIONS**

<b>Material to be machined</b>			<b>CUTINOX</b>	
			Vc [m/min]	
<b>P</b>	High alloyed steel	700 – 1500 N/mm <sup>2</sup>	<b>100</b>	150
<b>M</b>	Stainless steel	400 – 700 N/mm <sup>2</sup>	<b>250</b>	400
<b>M</b>	DUPLEX stainless steel	> 800 N/mm <sup>2</sup>	<b>100</b>	150

<b>Material to be machined</b>			<b>CARBIDE</b>	
			Vc [m/min]	
<b>P</b>	Unalloyed steel / Low alloyed steel	< 600 N/mm <sup>2</sup>	<b>80</b>	140
<b>P</b>	Unalloyed steel / Low alloyed steel	600 – 1500 N/mm <sup>2</sup>	<b>50</b>	80
<b>P</b>	Lead alloyed cutting steel		<b>120</b>	160
<b>P</b>	High alloyed steel	700 – 1500 N/mm <sup>2</sup>	<b>50</b>	80
<b>M</b>	Stainless steel	400 – 700 N/mm <sup>2</sup>	<b>80</b>	120
<b>M</b>	DUPLEX stainless steel	> 800 N/mm <sup>2</sup>	<b>50</b>	80
<b>K</b>	Grey cast iron / Nodular pearlitic iron	< 250 HB	<b>80</b>	140
<b>K</b>	Alloyed cast iron / Nodular pearlitic iron	> 250 HB	<b>50</b>	80
<b>K</b>	Nodular ferritic cast iron / Malleable cast iron		<b>50</b>	80
<b>S</b>	Special alloys / Heat resistant stainless steel	Inconel Nimonic Hastelloy	<b>20</b>	30
<b>S</b>	Titanium, titanium alloys		<b>30</b>	70
<b>N</b>	Copper alloys - easy to machine (brass - bronze)		<b>200</b>	450
<b>N</b>	Copper alloys - difficult to machine / Aluminium bronze	(CuAlFe) (Ampco)	<b>150</b>	300



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

$$V_f \text{ [mm/min]} = n \text{ [tr/min]} \times f_z \text{ [mm]} \times z$$

Feed per tooth **fz [mm]**

$\emptyset D_1$ 50	$\emptyset D_1$ 63	$\emptyset D_1$ 80	$\emptyset D_1$ 100
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008
0.002 - 0.008	0.002 - 0.008	0.002 - 0.008	0.002 - 0.008

Feed per tooth **fz [mm]**

$\emptyset D_1$ 15 - 30	$\emptyset D_1$ 30 - 40	$\emptyset D_1$ 40 - 50
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002
0.0003 - 0.002	0.0003 - 0.002	0.0003 - 0.002



CUTTING CONDITIONS

Materials to be machined			CARBIDE	CUTINOX
			Vc [m/min]	Vc [m/min]
<b>P</b>	Unalloyed steel / Low alloyed steel	< 600 N/mm <sup>2</sup>	<b>70</b> 100	
<b>P</b>	Unalloyed steel / Low alloyed steel	600 – 1500 N/mm <sup>2</sup>	<b>70</b> 90	
<b>P</b>	Lead alloyed cutting steel			<b>70</b> 100
<b>P</b>	High alloyed steel	700 – 1500 N/mm <sup>2</sup>	<b>40</b> 70	
<b>M</b>	Stainless steel	400 – 700 N/mm <sup>2</sup>		<b>60</b> 90
<b>M</b>	DUPLEX stainless steel	> 800 N/mm <sup>2</sup>		<b>40</b> 70
<b>K</b>	Grey cast iron / Nodular pearlitic iron	< 250 HB	<b>70</b> 100	<b>90</b> 110
<b>K</b>	Alloyed cast iron / Nodular pearlitic iron	> 250 HB	<b>40</b> 70	<b>70</b> 90
<b>K</b>	Nodular ferritic cast iron / Malleable cast iron		<b>70</b> 100	<b>90</b> 110
<b>S</b>	Special alloys / Heat resistant stainless steel	Inconel Nimonic Hastelloy		<b>25</b> 35
<b>N</b>	Titanium, titanium alloys		<b>30</b> 45	
<b>N</b>	Copper alloys - easy to machine (brass - bronze)		<b>140</b> 160	
<b>N</b>	Copper alloys - difficult to machine / Aluminium bronze	(CuAlFe) (Ampco)	<b>120</b> 140	<b>170</b> 190
<b>N</b>	Aluminium alloys	Si < 8%	<b>180</b> 260	<b>230</b> 340
<b>N</b>	Cast aluminium	Si > 8%	<b>140</b> 160	<b>210</b> 230
<b>N</b>	Plastic		<b>240</b> 260	<b>300</b> 340
<b>N</b>	Gold, silver		<b>140</b> 160	<b>200</b> 220



