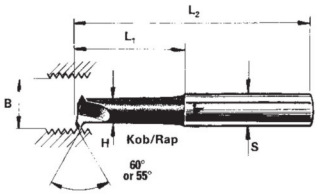
GWS - schroefdraadbeitels voor schroefdraad 60° & 55° (Kobalt/VHM)



G60(55) nos. 000–2A

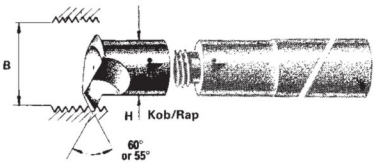


How to order (example): 10 pieces G60-1-A-T-Kob. (Original box of 5 pieces)

For sets refer to page 21

Size **GWS**	Code number Cutting form for: righthand thread by forward movement	Availability Kob	Rap	TiN	Code number Cutting form for: lefthand thread by forward movement	Availability Kob	TiN	Recommended minimum bore B/mm	∅ of neck H mm	∅ S-h7 of shank mm	Length of neck L_1 mm	Total length L_2 mm
000 60°	*G60-000-A-...*	●	●	●	*G60-000-B-...*	●	○	5	2.6	8	15	46
000 55°	*G55-000-A-...*	●	●	●	*G55-000-B-...*	●	○	5	2.6	8	15	46
00 60°	*G60-00-A-...*	●	●	●	*G60-00-B-...*	●	○	6.5	3.5	8	20	50
00 55°	*G55-00-A-...*	●	●	●	*G55-00-B-...*	●	○	6.5	3.5	8	20	50
0 60° normal	*G60-0-A-N-...*	●	●	●	*G60-0-B-N-...*	●	○	9	4.8	8	26	52
0 55° normal	*G55-0-A-N-...*	●	●	●	*G55-0-B-N-...*	●	○	9	4.8	8	26	52
0 60° long	*G60-0-A-T-...*	●	●	●	*G60-0-B-T-...*	●	○	9	4.8	8	31	64
0 55° long	*G55-0-A-T-...*	●	●	●	*G55-0-B-T-...*	●	○	9	4.8	8	31	64
1 60° normal	*G60-1-A-N-...*	●	●	●	*G60-1-B-N-...*	●	○	11	6	8	28	56
1 55° normal	*G55-1-A-N-...*	●	●	●	*G55-1-B-N-...*	●	○	11	6	8	28	56
1 60° long	*G60-1-A-T-...*	●	●	●	*G60-1-B-T-...*	●	○	11	6	8	34	70
1 55° long	*G55-1-A-T-...*	●	●	●	*G55-1-B-T-...*	●	○	11	6	8	34	70
2 60° normal	*G60-2-A-N-...*	●	●	●	*G60-2-B-N-...*	●	○	13	7.5	8	—	64
2 55° normal	*G55-2-A-N-...*	●	●	●	*G55-2-B-N-...*	●	○	13	7.5	8	—	64
2 60° long	*G60-2-A-T-...*	●	●	●	*G60-2-B-T-...*	●	○	13	7.5	8	—	80
2 55° long	*G55-2-A-T-...*	●	●	●	*G55-2-B-T-...*	●	○	13	7.5	8	—	80

▲ Please indicate here the alloy required ▲



Heads: **G60(55)** nos. 3–11A and
Shanks see page 12



How to order (example): 10 pieces G60-8-A-Rap. (Original box of 5 pieces)

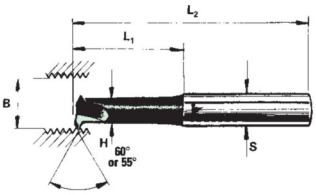
Size **GWS**	Code number Cutting form for: righthand thread by forward movement	Availability Kob	Rap	TiN	Code number Cutting form for: lefthand thread by forward movement	Availability Kob	TiN	Recomm. minimum bore B/mm	∅ of neck H mm	Thread
3 60°	*G60-3-A-...*	●	●	●	*G60-3-B-...*	●	○	17	10	M6
3 55°	*G55-3-A-...*	●	●	●	*G55-3-B-...*	●	○	17	10	M6
4 60°	*G60-4-A-...*	●	●	●	*G60-4-B-...*	●	○	21	12	M8
4 55°	*G55-4-A-...*	●	●	●	*G55-4-B-...*	●	○	21	12	M8
5 60°	*G60-5-A-...*	●	●	●	*G60-5-B-...*	●	○	24	14	M10×20TPI
5 55°	*G55-5-A-...*	●	●	●	*G55-5-B-...*	●	○	24	14	M10×20TPI
6 60°	*G60-6-A-...*	●	●	●	*G60-6-B-...*	●	○	28	16.3	M12×20TPI
6 55°	*G55-6-A-...*	●	●	●	*G55-6-B-...*	●	○	28	16.3	M12×20TPI
7 60°	*G60-7-A-...*	●	●	●	*G60-7-B-...*	●	○	31	18.3	M14×20TPI
7 55°	*G55-7-A-...*	●	●	●	*G55-7-B-...*	●	○	31	18.3	M14×20TPI
8 60°	*G60-8-A-...*	●	●	●	*G60-8-B-...*	●	○	34	20	M15×20TPI
8 55°	*G55-8-A-...*	●	●	●	*G55-8-B-...*	●	○	34	20	M15×20TPI
9 60°	*G60-9-A-...*	●	●	●	*G60-9-B-...*	●	○	37	22	M15×20TPI
9 55°	*G55-9-A-...*	●	●	●	*G55-9-B-...*	●	○	37	22	M15×20TPI
10 60°	*G60-10-A-...*	●	●	●	*G60-10-B-...*	●	○	42	25	M18×20TPI
10 55°	*G55-10-A-...*	●	●	●	*G55-10-B-...*	●	○	42	25	M18×20TPI
11 60°	*G60-11-A-...*	●		○	*G60-11-B-...*	●	○	50	30	M21×14TPI
11 55°	*G55-11-A-...*	●		○	*G55-11-B-...*	●	○	50	30	M21×14TPI

▲ Please indicate here alloy required ▲

The above mentioned tools for internal thread cutting are equipped with righthand-side thread of shank.
To determine correct size of tool and for different types (C+D) of internal thread cutting tools 60° and 55°, please see page 16.

Availability: ● ex stock / ○ within short notice

Internal Thread Cutting Tools GWS 60° and 55° with Carbide Tips



G 60 (55) nos. 000

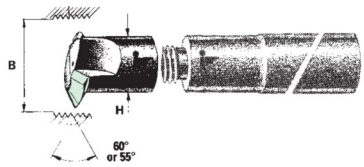


G 60 (55) nos. 00–2

How to order (example): 5 pieces G60-1-A-K10

Size **GWS**	Code number cutting form for: righthand thread by forward movement	Availability K10	Availability P30	Code number cutting form for: lefthand thread by forward movement	Availability K10	Availability P30	Recommended minimum bore B / mm	∅ of neck H mm	∅ S-h7 of shank mm	Length of neck L_1 mm	Total length L_2 mm
000 60°	*G60-000-A-HM*	●		*G60-000-B-HM*	●		5	2.6	8	15	46
000 55°	*G55-000-A-HM*	●		*G55-000-B-HM*	●		5	2.6	8	15	46
00 60°	*G60-00-A-HM*	●		*G60-00-B-HM*	●		6.5	3.5	8	20	50
00 55°	*G55-00-A-HM*	●		*G55-00-B-HM*	●		6.5	3.5	8	20	50
0 60°	*G60-0-A-HM*	●		*G60-0-B-HM*	●		9	4.8	8	22	64
0 55°	*G55-0-A-HM*	●		*G55-0-B-HM*	●		9	4.8	8	22	64
1 60°	*G60-1-A-...*	●	●	*G60-1-B-...*	●	●	11	6	8	30	70
1 55°	*G55-1-A-...*	●	●	*G55-1-B-...*	●	●	11	6	8	30	70
2 60°	*G60-2-A-...*	●	●	*G60-2-B-...*	●	●	13	7.5	8	----	80
2 55°	*G55-2-A-...*	●	●	*G55-2-B-...*	●	●	13	7.5	8	—	80

▲ Please indicate here the grade of carbide required ▲



Heads: **G60(55)** nos. 3–11 A
Shanks see page 12

How to order (example): 5 pieces G60-6-A-P30

Size **GWS**	Code number cutting form for: righthand thread by forward movement	Availability K10	Availability P30	Code number cutting form for: lefthand thread by forward movement	Availability K10	Availability P30	Recomm. minimum bore B / mm	∅ of neck H mm	Thread
3 60°	*G60-3-A-...*	●	●	*G60-3-B-...*	●	●	17	10	M6
3 55°	*G55-3-A-...*	●	●	*G55-3-B-...*	●	●	17	10	M6
4 60°	*G60-4-A-...*	●	●	*G60-4-B-...*	●	●	21	12	M8
4 55°	*G55-4-A-...*	●	●	*G55-4-B-...*	●	●	21	12	M8
5 60°	*G60-5-A-...*	●	●	*G60-5-B-...*	●	●	24	14	M10×20TPI
5 55°	*G55-5-A-...*	●	●	*G55-5-B-...*	●	●	24	14	M10×20TPI
6 60°	*G60-6-A-...*	●	●	*G60-6-B-...*	●	●	28	16.3	M12×20TPI
6 55°	*G55-6-A-...*	●	●	*G55-6-B-...*	●	●	28	16.3	M12×20TPI
7 60°	*G60-7-A-...*	●	●	*G60-7-B-...*	●	●	31	18.3	M14×20TPI
7 55°	*G55-7-A-...*	●	●	*G55-7-B-...*	●	●	31	18.3	M14×20TPI
8 60°	*G60-8-A-...*	●	●	*G60-8-B-...*	●	●	34	20	M15×20TPI
8 55°	*G55-8-A-...*	●	●	*G55-8-B-...*	●	●	34	20	M15×20TPI
9 60°	*G60-9-A-...*	●	●	*G60-9-B-...*	●	●	37	22	M15×20TPI
9 55°	*G55-9-A-...*	●	●	*G55-9-B-...*	●	●	37	22	M15×20TPI
10 60°	*G60-10-A-...*	●	●	*G60-10-B-...*	●	●	42	25	M18×20TPI
10 55°	*G55-10-A-...*	●	●	*G55-10-B-...*	●	●	42	25	M18×20TPI
11 60°	*G60-11-A-...*	●	●	*G60-11-B-...*	●	●	50	30	M21×14TPI
11 55°	*G55-11-A-...*	●	●	*G55-11-B-...*	●	●	50	30	M21×14TPI

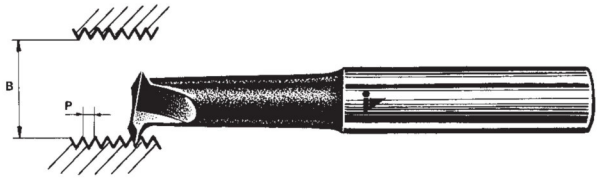
▲ Please indicate here the grade of carbide required ▲

The above mentioned tools for internal thread cutting are equipped with righthand-side thread of shank.
To determine correct size of tool and for different types (C+D) of internal thread cutting tools 60° and 55°, please see page 16.

Availability: ● ex stock

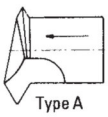
VAN CUTSEM tools BV - kmo zone Doornpark 19 - 9120 Beveren - tel +32 (0)3 776 84 92 - info@vancutsemtools.be - www.vancutsemtools.be

Table of Pitch and Size of Threads for Internal Thread Cutting Tools



Size		000	00	0	1	2	3	4	5	6	7	8	9	10	11
Maximum pitch possible P	in mm	1.25	1.5	1.75	2	2.5	3.5	4	5	5.5	6.5	7.5	8	10	12
	in threads per inch	20	16	14	12	10	7	6	5	4½	3½	3	2¾	2½	2
Minimum bore ∅ B in mm		5	6.5	9	11	13	17	21	24	28	31	34	37	42	50
Suitable for	metric thread	M6	M8	M10	M12-16	M14-22	M20-27	M24-33	M30-42	M33-48	M39-56	from M42	from M45	from M48	from M60
	English thread		5/16–3/8"	3/8"	1/2–5/8"	5/8–3/4"	3/4–1¼"	1-1½"	1¼-1¾"	1¼-2"	1½-2½"	1⅝-3"	1¾-3½"	2-4"	from 2½"

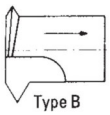
Table of Internal Thread Cutting Tools, Righthand and Lefthand



Type A

For righthand internal thread
cutting from right to left during forward movement
(normal tool for righthand threads)

(also suitable for external lefthand thread cutting during reverse spindle operation)

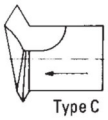


Type B

For lefthand internal thread
cutting from left to right during forward movement
(normal tool for lefthand threads)

(also suitable for external righthand thread cutting during reverse spindle operation)

When ordering GWS types B, C or D it is imperative to mark it clearly. (Types B, C and D available in HSS-CO, TiN-coated and with carbide tips grade K10 and P30.)



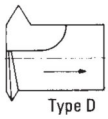
Type C

For lefthand internal thread
cutting from right to left during reverse spindle operation

(also suitable for external righthand thread cutting during forward movement)

requires lefthand-side threaded shank *(SCH...L...)*

Code number:
replace letter "A" in code for type A by "C".



Type D

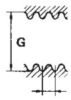
For righthand internal thread
cutting from left to right during reverse spindle operation

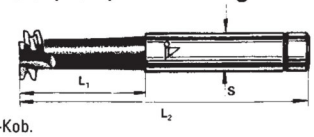
(also suitable for external lefthand thread cutting during forward movement)

requires lefthand-side threaded shank *(SCH...L...)*

Code number:
replace letter "A" in code for type A by "D".

RDG — Tools RDG of HSS-CO (Kob) for Cutting Round Threads, acc. to DIN 405





RDG nos. 0/1-2 R



Heads: **RDG** nos. 3-10 R
Shanks see page 12

How to order (example): 5 pieces RDG-4-28×8G-R-Kob.

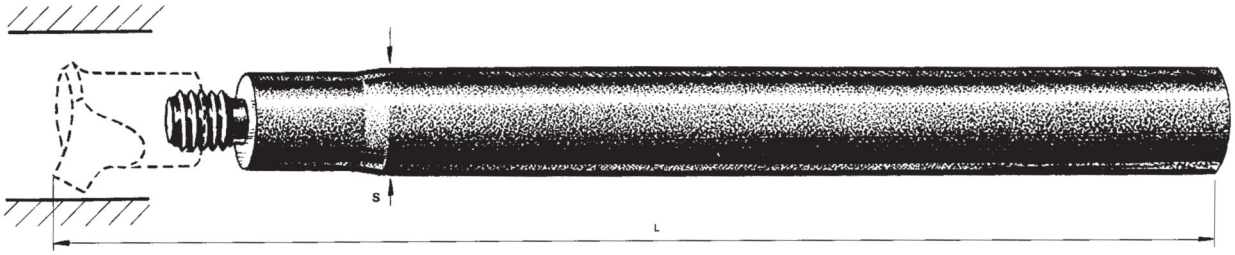
∅ G of thread	Size RDG	Pitch of thread **10 TPI** Code number	*	Pitch of thread **8 TPI** Code number	*	Pitch of thread **6 TPI** Code number	*	Pitch of thread **4 TPI** Code number	*	∅ S-h$_7$ mm	Thread	Lengths L_1 mm	L_2 mm
12	0/1	*RDG-0/1-12×10G-R-Kob*	●							8		31	60
14	1	*RDG-1-14×10G-R-Kob*	●							8		30	64
16	1/2	*RDG-1/2-16×10G-R-Kob*	●							8		35	69
18	2	*RDG-2-18×10G-R-Kob*	●							8		—	80
20	2	*RDG-2-20×10G-R-Kob*	●	*RDG-2-20×8G-R-Kob*	●					8		—	80
22	2			*RDG-2-22×8G-R-Kob*	●					8		—	80
22	3	*RDG-3-22×10G-R-Kob*	●								M6		
25	3	*RDG-3-25×10G-R-Kob*	●	*RDG-3-25×8G-R-Kob*	●						M6		
25	4					*RDG-4-25×6G-R-Kob*	●				M8		
28	4			*RDG-4-28×8G-R-Kob*	●	*RDG-4-28×6G-R-Kob*	●				M8		
30	4	*RDG-4-30×10G-R-Kob*	●	*RDG-4-30×8G-R-Kob*	●						M8		
30	5					*RDG-5-30×6G-R-Kob*	●				M10×20TPI		
32	5			*RDG-5-32×8G-R-Kob*	●						M10×20TPI		
35	4	*RDG-4-35×10G-R-Kob*	●								M8		
35	5					*RDG-5-35×6G-R-Kob*	●				M10×20TPI		
35	6			*RDG-6-35×8G-R-Kob*	●			*RDG-6-35×4G-R-Kob*	●		M12×20TPI		
38	6			*RDG-6-38×8G-R-Kob*	●	*RDG-6-38×6G-R-Kob*	●	*RDG-6-38×4G-R-Kob*	●		M12×20TPI		
40	5	*RDG-5-40×10G-R-Kob*	●								M10×20TPI		
40	6			*RDG-6-40×8G-R-Kob*	●	*RDG-6-40×6G-R-Kob*	●	*RDG-6-40×4G-R-Kob*	●		M12×20TPI		
45	5	*RDG-5-45×10G-R-Kob*	●								M10×20TPI		
45	6			*RDG-6-45×8G-R-Kob*	●						M12×20TPI		
45	8					*RDG-8-45×6G-R-Kob*	●	*RDG-8-45×4G-R-Kob*	●		M15×20TPI		
50	6	*RDG-6-50×10G-R-Kob*	●								M12×20TPI		
50	8			*RDG-8-50×8G-R-Kob*	●	*RDG-8-50×6G-R-Kob*	●	*RDG-8-50×4G-R-Kob*	●		M15×20TPI		
55	8			*RDG-8-55×8G-R-Kob*	●	*RDG-8-55×6G-R-Kob*	●	*RDG-8-55×4G-R-Kob*	●		M15×20TPI		
60	6	*RDG-6-60×10G-R-Kob*	●								M12×20TPI		
60	8			*RDG-8-60×8G-R-Kob*	●	*RDG-8-60×6G-R-Kob*	●	*RDG-8-60×4G-R-Kob*	●		M15×20TPI		
70	8			*RDG-8-70×8G-R-Kob*	●	*RDG-8-70×6G-R-Kob*	●				M15×20TPI		
70	10							*RDG-10-70×4G-R-Kob*	●		M18×20TPI		
80	8	*RDG-8-80×10G-R-Kob*	●	*RDG-8-80×8G-R-Kob*	●						M15×20TPI		
80	10					*RDG-10-80×6G-R-Kob*	●	*RDG-10-80×4G-R-Kob*	●		M18×20TPI		
100	8			*RDG-8-100×8G-R-Kob*	●						M15×20TPI		
100	10					*RDG-10-100×6G-R-Kob*	●	*RDG-10-100×4G-R-Kob*	●		M18×20TPI		
120	10							*RDG-10-120×4G-R-Kob*	●		M18×20TPI		
150	10							*RDG-10-150×4G-R-Kob*	●		M18×20TPI		

* Availability: ● ex stock for righthand thread

Prototool

SCH

Shanks SCH for detachable Head Type for Use on Turning Lathes



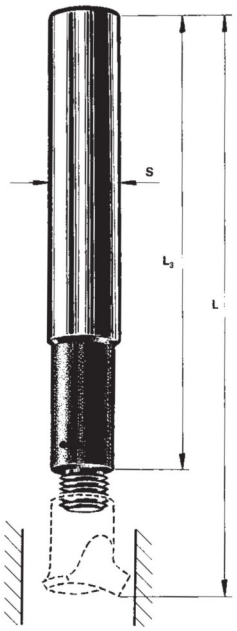
How to order (example): 10 pieces SCH-6-R-N

Normal series						
Size **SCH**	Code number for righthand-side (for lefthand-side: replace "R" by "L")	Availability "R"	Availability "L"	∅ S-h11 of shank mm	Thread	Total length L mm
3	*SCH-3-R-N*	●	●	10	M6	100
	SCH-3-R-T	●	●	10	M6	125
	SCH-3-R-V	●	●	12	M6	200
4	*SCH-4-R-N*	●	●	13	M8	230
5	*SCH-5-R-N*	●	●	15	M10×20TPI	260
6	*SCH-6-R-N*	●	●	17	M12×20TPI	280
7	*SCH-7-R-N*	●	●	19	M14×20TPI	310
8	*SCH-8-R-N*	●	●	20	M15×20TPI	330
9	*SCH-9-R-N*	●	●	22	M15×20TPI	360
10	*SCH-10-R-N*	●	●	25	M18×20TPI	390
11	*SCH-11-R-N*	●	●	30	M21×14TPI	430
12	*SCH-12-R-N*	●	●	35	M25×14TPI	500

Reinforced series for carbide tipped tools and wide overhang						
Size **SCH**	Code number for righthand-side (for lefthand-side: replace "R" by "L")	Availability "R"	Availability "L"	∅ S-h11 of shank mm	Thread	Total length L mm
3	*SCH-3-R-V*	●	●	12	M6	200
4	*SCH-4-R-V*	●	●	14	M8	230
5	*SCH-5-R-V*	●	●	16	M10×20TPI	260
6	*SCH-6-R-V*	●	●	18	M12×20TPI	280
7	*SCH-7-R-V*	●	●	20	M14×20TPI	310
8	*SCH-8-R-V*	●	●	22	M15×20TPI	330
9	*SCH-9-R-V*	●	●	25	M15×20TPI	360
10	*SCH-10-R-V*	●	●	30	M18×20TPI	390
11	*SCH-11-R-V*	●	●	35	M21×14TPI	430

SDK

Ground Shanks SDK for detachable Head Type for Use on Boring Heads and on NC/CNC Turning Machines



How to order (example): 5 pieces SDK-3-12089-R

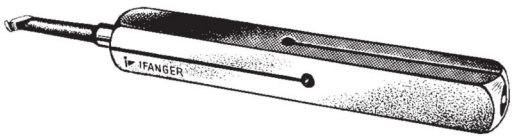
Size **SDK**	∅ S-h7 of shank mm	Length of shank L_3 mm	Code number for righthand-side (for lefthand-side: replace "R" by "L")	Availability "R"	Availability "L"	Thread	Total length L mm
3	10	79	*SDK-3-10079-R*	●	○	M6	100
3	10	119	*SDK-3-10119-R*	●	○	M6	140
3	12	89	*SDK-3-12089-R*	●	○	M6	110
3	12	129	*SDK-3-12129-R*	●	○	M6	150
4	12	97	*SDK-4-12097-R*	●	○	M8	120
4	12	147	*SDK-4-12147-R*	●	○	M8	170
5	14	74	*SDK-5-14074-R*	●	○	M10×20TPI	100
5	14	114	*SDK-5-14114-R*	●	○	M10×20TPI	140
5	14	164	*SDK-5-14164-R*	●	○	M10×20TPI	190
6	16	71	*SDK-6-16071-R*	●	○	M12×20TPI	100
6	16	111	*SDK-6-16111-R*	●	○	M12×20TPI	140
6	16	171	*SDK-6-16171-R*	●	○	M12×20TPI	200
6	18	111	*SDK-6-18111-R*	●	○	M12×20TPI	140
6	18	171	*SDK-6-18171-R*	●	○	M12×20TPI	200
7	18	68	*SDK-7-18068-R*	●	○	M14×20TPI	100
7	18	108	*SDK-7-18108-R*	●	○	M14×20TPI	140
7	18	188	*SDK-7-18188-R*	●	○	M14×20TPI	220
8	20	70	*SDK-8-20070-R*	●	○	M15×20TPI	105
8	20	110	*SDK-8-20110-R*	●	○	M15×20TPI	145
8	20	195	*SDK-8-20195-R*	●	○	M15×20TPI	230
8	22	70	*SDK-8-22070-R*	●	○	M15×20TPI	105
8	22	110	*SDK-8-22110-R*	●	○	M15×20TPI	145
8	22	195	*SDK-8-22195-R*	●	○	M15×20TPI	230
10	25	108	*SDK-10-25108-R*	●	○	M18×20TPI	150
10	25	188	*SDK-10-25188-R*	●	○	M18×20TPI	230
10	25	258	*SDK-10-25258-R*	●	○	M18×20TPI	300
10	30	108	*SDK-10-30108-R*	●	○	M18×20TPI	150
10	30	188	*SDK-10-30188-R*	●	○	M18×20TPI	230
10	30	258	*SDK-10-30258-R*	●	○	M18×20TPI	300

Availability: ● ex stock / ○ within short notice

KGI

Standard Tool Holders for Boring Tools

Clamping holders KGI

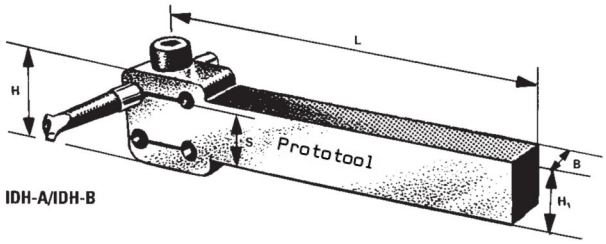


KGI

How to order (example): 5 pieces KGI

For tools of sizes	For ∅ of shank mm	Type and code number	Availability	Measurements mm
0000–3	8 and 10	*KGI*	●	16×16×125
0000–2	8	*KGI-A*	●	12×12×100
0000–2	8	*KGI-B*	●	14×10×100
Shank 4 and 6	4 and 6	*KGI-C*	●	10×10× 90

IDH Tool holders IDH for internal turning tools sizes 0000–3



IDH-A/IDH-B

How to order (example): 1 piece IDH-A-18

Type	Code number	Height of center S above tool rest in mm	Measurements H×B×L mm	Bores mm	Availability
IDH-A	IDH-A-..	12–20	30×12×150	8 and 10	●

Please state accurate height of center S above tool rest

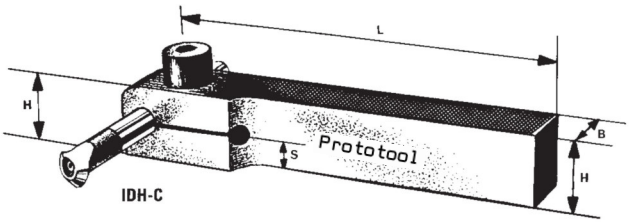
Height of holder H_1 in mm									
if S =	12	13	14	15	16	17	18	19	20
H_1 =	11.2	13.2	15.2	17.2	19.2	21.2	23.2	25.2	27.2

How to order (example): 1 piece IDH-B-25

Type	Code number	Height of center S above tool rest in mm	Measurements H×B×L mm	Bores mm	Availability
IDH-B	IDH-B-..	21–30	40×22×175	8 and 10	●

Please state accurate height of center S above tool rest

Height of holder H_1 in mm										
if S =	21	22	23	24	25	26	27	28	29	30
H_1 =	21.2	23.2	25.2	27.2	29.2	31.2	33.2	35.2	37.2	39.2



IDH-C

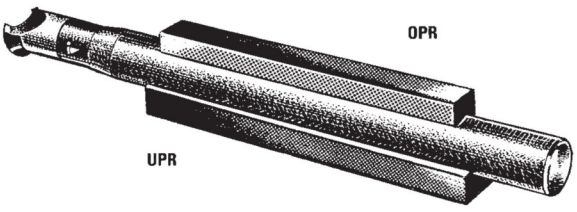
How to order (example): 1 piece IDH-C-12/8

Type	Code number	Height of center S above tool rest in mm	Measurements H×B×L mm	Bores mm	Availability
IDH-C	IDH-C-../..	8 or 10 or 12	20×10×100	8 or 10	●

Please indicate ∅ of bores (8 or 10 mm)
Please state here height of center S above tool rest (8 or 10 or 12 mm)

OPR – UPR

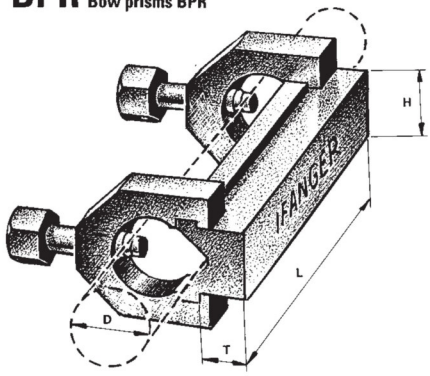
Prisms



How to order (example): 5 pieces UPR-130

For tools of sizes	Lower prisms UPR			Upper prisms OPR		
	Type and code number	Availability	Measurements in mm	Type and code number	Availability	Measurements in mm
0000– 3	*PR-50*	●	8×10× 50	*PR-50*	●	8×10× 50
3– 8	*UPR-130*	●	12×22×130	*OPR-100*	●	8×14×100
6–10	*UPR-150*	●	15×25×150	*OPR-125*	●	8×14×125
10–12	*UPR-180*	●	20×35×180	*OPR-150*	●	8×14×150

BPR Bow prisms BPR



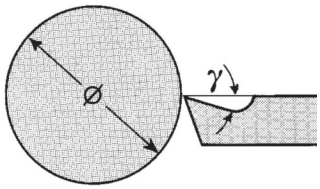
How to order (example): 1 piece BPR-20

For IFANGER shanks no.	Size	Code number	Availability	D mm	Measurements in mm L×H×T
3– 8	20	*BPR-20*	●	10–20	130×16×12
4–12	35	*BPR-35*	●	12–35	180×30×20

Availability: ● ex stock

Recommendations regarding cutting speeds, number of revolutions and rake angles when turning

Prototool



Material to be machined	Cross section of chip (feed "s" × depth of chip "t")		Cutting speed m/min (tool life approx. 1 h.) for cutting tool					Rake angle γ for cutting tool		
	Section mm²	Example for "s" × "t"	HSS-CO (Kob)	HSS (Rap)	TiN	Carbide P30	Carbide K10	HSS-CO/HSS/TiN	Carbide P30	Carbide K10
Steel up to 50 kg/mm² tensile strength	0.3	0.1×3/0.2×1.5	60	40	100	200				
	0.6	0.3×2/0.2×3	50	35	90	200				
	1.5	0.3×5/0.5×3	40	30	75	150		25	18	
	3	0.3×10/0.5×6	35	25	60	150				
	6	0.6×10/0.8×7.5	30	20		100				
Steel of more than 60 kg/mm² tensile strength	0.3	0.1×3/0.2×1.5	50	35	90	150				
	0.6	0.2×3/0.3×2	40	30	75	150				
	1.5	0.3×5/0.5×3	35	25	60	100		20	12	
	3	0.3×10/0.5×6	30	20	50	100				
	6	0.6×10/0.8×7.5	25	20		70				
Grey cast iron	0.3	0.1×3/0.2×1.5	35	25	60		150			
	0.6	0.2×3/0.3×2	30	25	50		100			
	1.5	0.3×5/0.5×3	25	20	45		100	15		10
	3	0.3×10/0.5×6	20	15	35		70			
	6	0.6×10/0.8×7.5	15	10			50			
Aluminum	0.3	0.1×3/0.2×1.5	200	150	270		500			
	1	0.2×5/0.4×2.5	150	100	240		400			
Copper	2	0.4×5/0.2×10	100	70	180		400	30		20
	5	0.4×12/0.6×8	70	50	125		300			
	10	0.6×17/1×10	50	40			200			
Brass	0.3	0.1×3/0.2×1.5	150	100	250		400			
	1	0.2×5/0.4×2.5	100	70	180		300			
	2	0.4×5/0.2×10	70	50	125		300	5		5
	5	0.4×12/0.6×8	50	35	90		200			
	10	0.6×17/1×10	35	25			150			

Piece to be machined	Number of revolutions at cutting speed (m/min) of														
Ø mm	10	15	20	25	30	35	40	50	70	100	150	200	300	400	500
5	640	950	1270	1590	1910	2250	2550	3200	4450	6350	9550				
6	530	800	1060	1330	1590	1860	2100	2650	3700	5300	7950				
8	400	600	800	990	1190	1390	1590	1990	2800	4000	5950	7950			
10	320	480	640	800	950	1110	1270	1590	2250	3200	4750	6350	9550		
12	265	400	530	660	800	930	1060	1330	1860	2650	4000	5300	7950		
15	210	320	420	530	640	740	850	1060	1490	2100	3200	4250	6350	8500	
20	160	240	320	400	480	560	640	800	1110	1590	2400	3200	4750	6350	795
25	127	190	255	320	380	450	510	640	890	1270	1910	2550	3800	5100	635
30	106	160	210	265	320	370	420	530	740	1060	1590	2100	3200	4250	530
35	91	136	180	225	275	320	360	450	640	910	1360	1820	2750	3650	455
40	80	119	160	200	240	280	320	400	560	800	1190	1590	2400	3200	400
50	64	95	127	160	190	225	255	320	450	640	950	1270	1910	2550	320
60	53	80	106	133	160	185	210	265	370	530	800	1060	1590	2100	265
80	40	60	80	99	119	140	160	200	280	400	600	800	1190	1590	199
100	32	48	64	80	95	111	127	160	225	320	480	640	950	1270	159
120	27	40	53	66	80	93	106	133	185	265	400	530	800	1060	133
150	21	32	42	53	64	74	85	106	149	210	320	420	640	850	106
200	16	24	32	40	48	56	64	80	111	160	240	320	480	640	80(
250	13	19	25	32	38	45	51	64	89	127	190	255	380	510	64(
300	11	16	21	27	32	37	42	53	74	106	159	210	320	420	53(
400	8	12	16	20	24	28	32	40	56	80	119	160	240	320	40(
500	6	10	13	16	19	22	25	32	45	64	95	127	190	255	32(

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