

Cutting data



	45° 45°-R01 255 S1		S1-SP S2-SP2		S1-PKD PKD		VG 12° RX R3	
Material	vc [m/min]	f [U/min]	vc [m/min]	f [U/min]	vc [m/min]	f [U/min]	vc [m/min]	f [U/min]
PUR			200-500	0,1-0,5			200-500	0,1-0,5
PTFE (Teflon)	200-500	0,1-0,4	200-500	0,1-0,4				
POM	300-600	0,1-0,4	300-600	0,1-0,4			300-600	0,1-0,4
PA	200-500	0,1-0,4	200-500	0,1-0,4				
PVC	200-750	0,3-0,5	200-750	0,3-0,5			200-750	0,3-0,5
PP	250-500	0,1-0,5	250-500	0,1-0,5			250-500	0,1-0,5
PE-HD			250-500	0,1-0,5			250-500	0,1-0,5
PEEK	200-500	0,1-0,4	200-500	0,1-0,4			200-500	0,1-0,4
Vulkollan			300-800	0,1-0,5			300-800	0,1-0,5
PMMA (Plexiglass)	200-300	0,1-0,2	200-300	0,1-0,2				
With fillers					150-200	0,1-0,5		
PC	200-300	0,1-0,5	200-350	0,1-0,5				
PET							200-500	0,1-0,5
PVDF	150-500	0,1-0,3	150-500	0,1-0,3				
PEI			300-400	0,2-0,3			300-400	0,2-0,3
PPS	200-500	0,1-0,5	200-500	0,1-0,5				

Abbreviations

2-7 Tool system plastic processing 2-7
 2-9 Tool system plastic processing 2-9
 B Width
 CFK Carbon fiber reinforced plastics
 CVD Chemical Vapor Deposition
 D / d Diameter
 f Feed
 GFK Glass fiber reinforced plastics
 H Height
 KH Plastic holder
 KH-H Holders for chip-free machining
 KH-H1 Holders for R3-blade
 KP Plastic processing plates
 L / l Length
 M Thread sizes metric
 PA Polyamides
 PC Polycarbonate
 PE-HD ... High-density polyethylene
 PEEK Polyetheretherketone

PEI Polyetherimide
 PET Polyethylene terephthalate
 PKD Polycrystalline diamond
 PMMA Polymethyl methacrylate (Acrylic or Plexiglass)
 POM Polyoxymethylene
 PP Polypropylene
 PPS Polyurethane plastics
 PTFE Polytetrafluoroethylene (Teflon)
 PUR Polyurethane
 PVC Polyvinyl chloride
 PVDF Polyvinylidene fluoride
 S1 without cutting-off direction
 S2 with cutting-off direction
 S5 opposite cutting-off direction
 T TORX
 vc Cutting speed
 Vulkollan High-performance polyurethane
 With fillers Fibre-reinforced plastics

