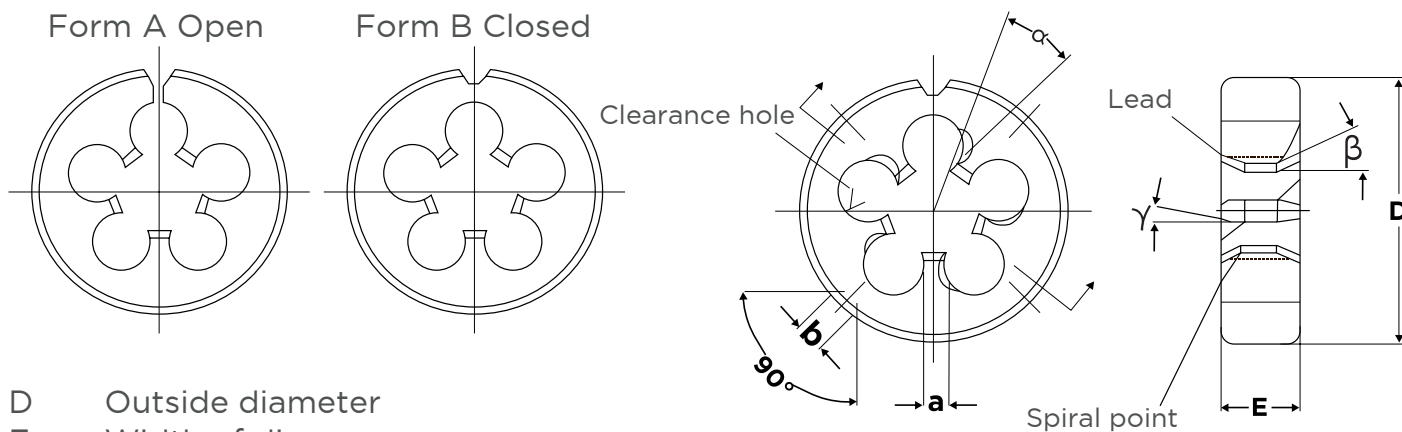




TECHNICAL INFORMATION

Recommended Cutting Speed for Round Dies

Material	Rake Angle	m/min	Lubricant
Structural Steel	17-22°	8-12	Cutting Oil
Free-cutting Steel	17-22°	10-14	Cutting Oil
Cementation Steel	17-22°	6-10	Cutting Oil
Heat treatable Steel	13-18°	5-8	Cutting Oil
VASTainless Steel	13-18°	4-6	Special Cutting Oil
Cast Iron GG	8-12°	5-8	Cutting Oil, Kerosene
Brass, Short-chipping	3-7°	20-30	Cutting Oil
Brass, Long-chipping	10-15°	12-18	Cutting Oil
Bronzes	8-12°	5-8	Cutting Oil, Oil Emulsion
Copper	23-28°	11-15	Cutting Oil, Oil Emulsion
Al-alloys, Long-chipping	23-28°	15-25	Special Cutting Oil, Kerosene
Al-alloys, Short-chipping	13-18°	8-12	Special Cutting Oil, Kerosene



- D Outside diameter
- E Width of die
- a Width of land
- b Hole for holding screws
- α Rake angle
- β Lead angle
- γ Angle of gun nose

