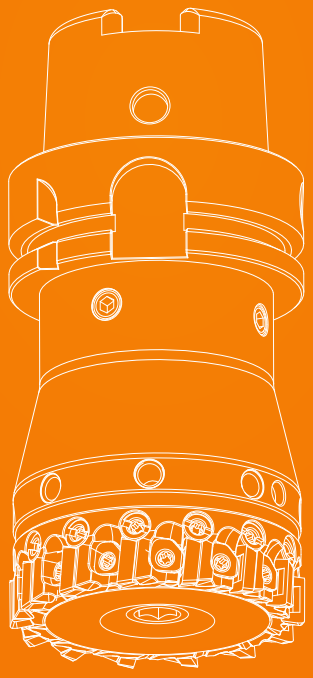
PREZISS

K_MILL

The new powerful face milling cutter



K_MILL

PREZISS TOOLS in its constant evolution to improve tooling production continuously invests in new technologies & technical knowledge. Because of our concern, we work daily to improve our processes and tooling. A good example of this is the new face milling cutter K_MILL.

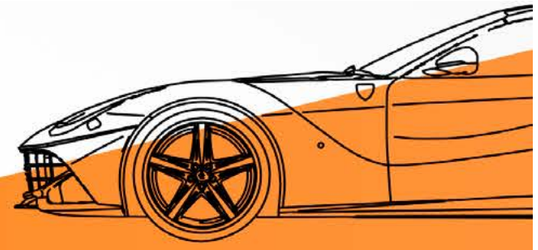
With the K_MILL face miller, PREZISS has developed a high yield tool, as the K_MILL system allows PREZISS to produce an indexable cutter with the same number of cuts as a PCD brazed tool version & improving the production costs, thanks to its indexable & reversible inserts.

K_MILL

The quick precise micro adjustment system allows the user to set each individual PCD insert up easily, in order to achieve minimal axial run-out and thus ensure a good surface quality and a long life of the cutting edges.

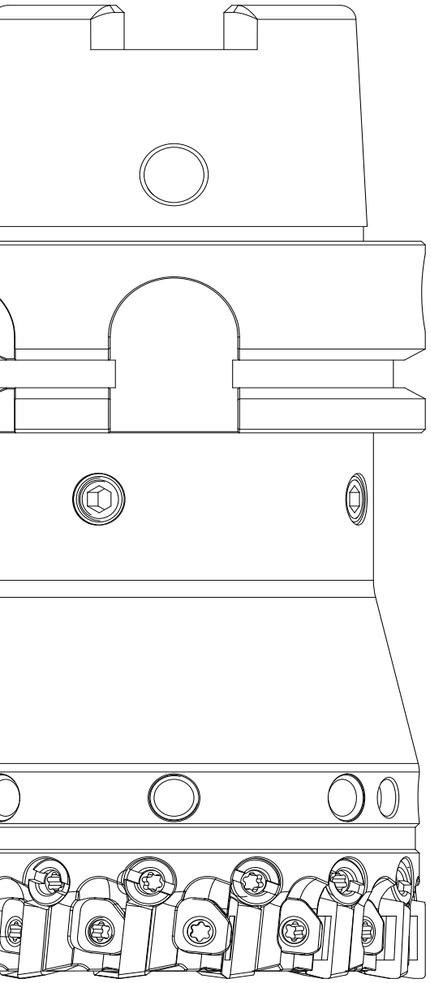
All K_MILL cutters are designed to perform with the coolant supply oriented directly to the cutting edge to ensure better surface quality.
The structural features and stability guarantee machining efficiency in finishing and roughing operations.

Cutters in PCD are the best solution to machine aluminium alloys, magnesium alloys, carbon, graphite, bimetallic alloys and generally abrasive materials.



63

HSK63A

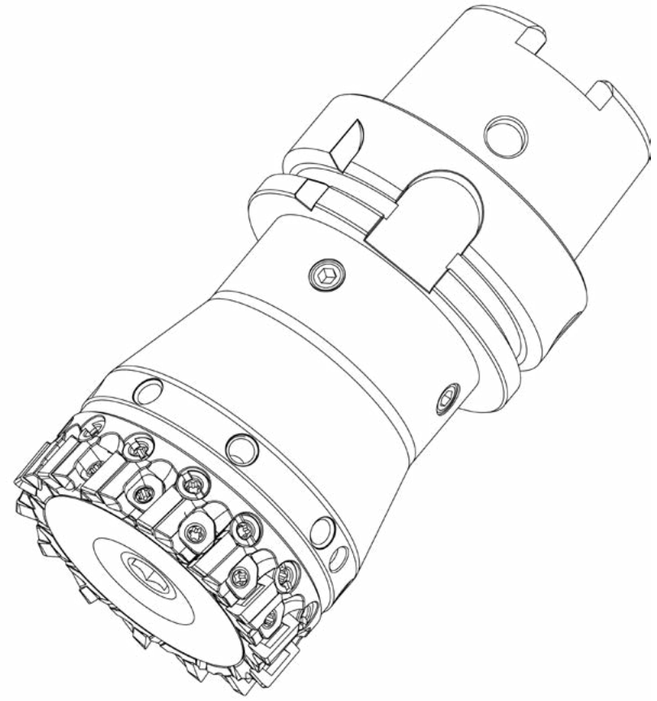


The newly developed clamping & adjusting system of the K_MILL allows you to adjust the axial run out in an easy and precise way. Made with high quality materials, the design and the production af all K_MILL components guarantee an excellent performance and machining stability for both, roughing and finishing operations.

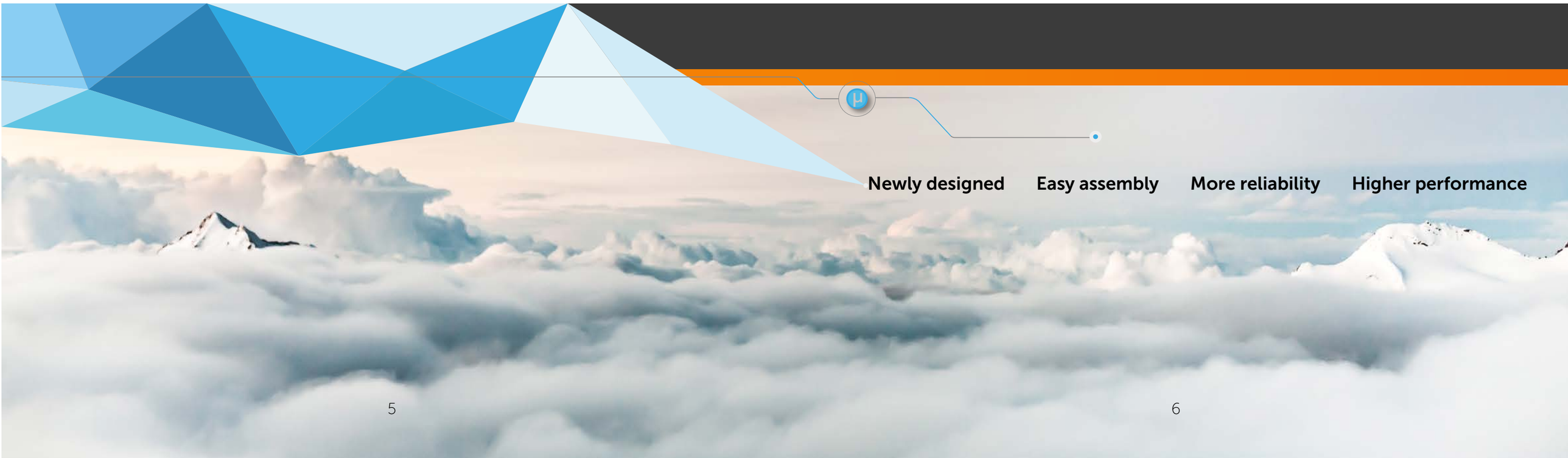
The insert clamping and adjusting system K_MILL allows you to run and/or replace the insert in as fast easy secure way.
In the K_MILL design, the coolant supply is directly oriented to the edge to ensure a better surface quality and a longer tool life.

K_MILL face milling cutter advantages:

- Higher number of teeth compared to other cartridges cutters.
- Full face PCD inserts.
- Reversible inserts with 2 cutting edges.
- Ap=8mm.
- Inserts available from stock or short delivery.
- Easy fast assembly.
- Easy precise adjustment.
- Precision Laser sharpening



PREZISS



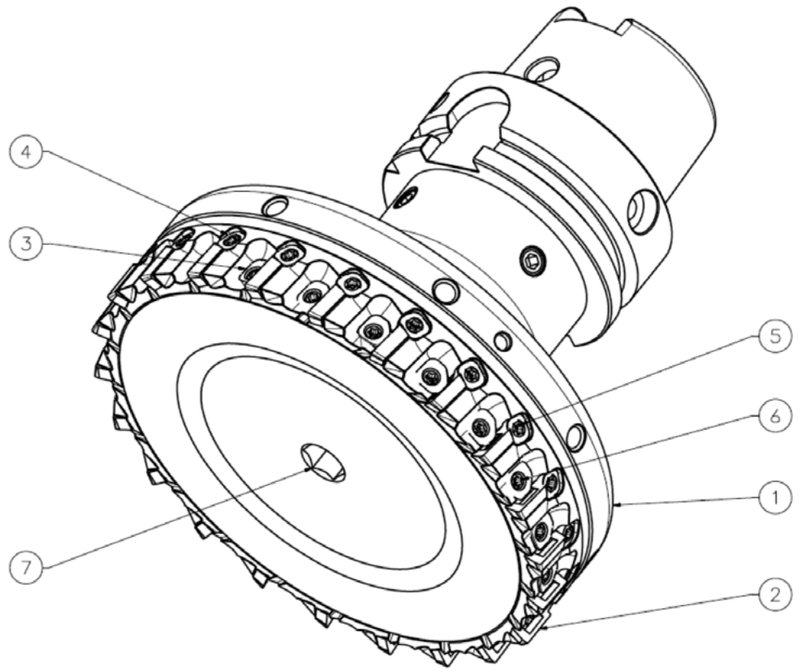
K_MILL SYSTEM

high feed and performance

FACE MILLING HEAD – HIGH FEED

With maximum Nr of teeth for the highest performance

HSK – A63	PCD TIPS	STEEL BODY	INTERNAL COOLAN



1	Tool body
2	Insert
3	Clamping wedge
4	Adjusting wedge
5	Adjusting wedge - screw
6	Clamping wedge - screw
7	Coolant cover

Adjustment instructions, see page 26

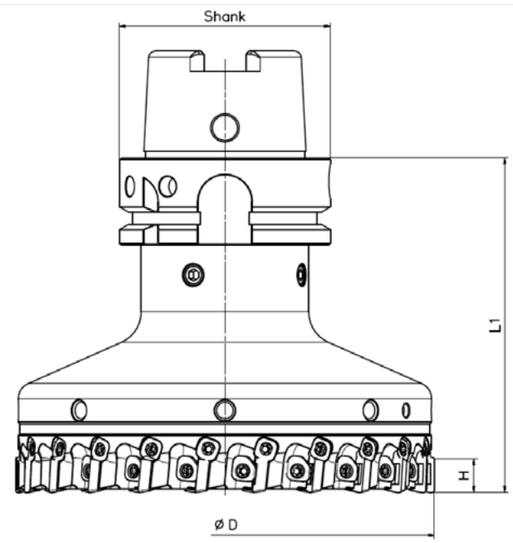
Working conditions, see page 27

Cutting geometry, see page 25

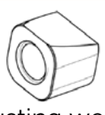
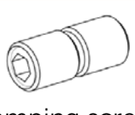
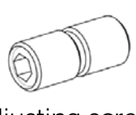
K_MILL

FACE MILLING HEAD – HIGH FEED

With maximum Nr of teeth for the highest performance



Art. Ref.	ØD	Shank	L1	H	Z	N max.	Kg
DPM2004001	32	HSK-A63	100	10	6	36.000	1,0
DPM2004002	40	HSK-A63	100	10	8	33.000	1,3
DPM2004003	50	HSK-A63	100	10	12	33.000	1,6
DPM2004004	63	HSK-A63	100	10	14	30.000	2,0
DPM2004005	80	HSK-A63	100	10	16	28.000	2,5
DPM2004006	100	HSK-A63	100	10	18	24.000	3,3
DPM2004007	125	HSK-A63	100	10	22	20.000	4,2

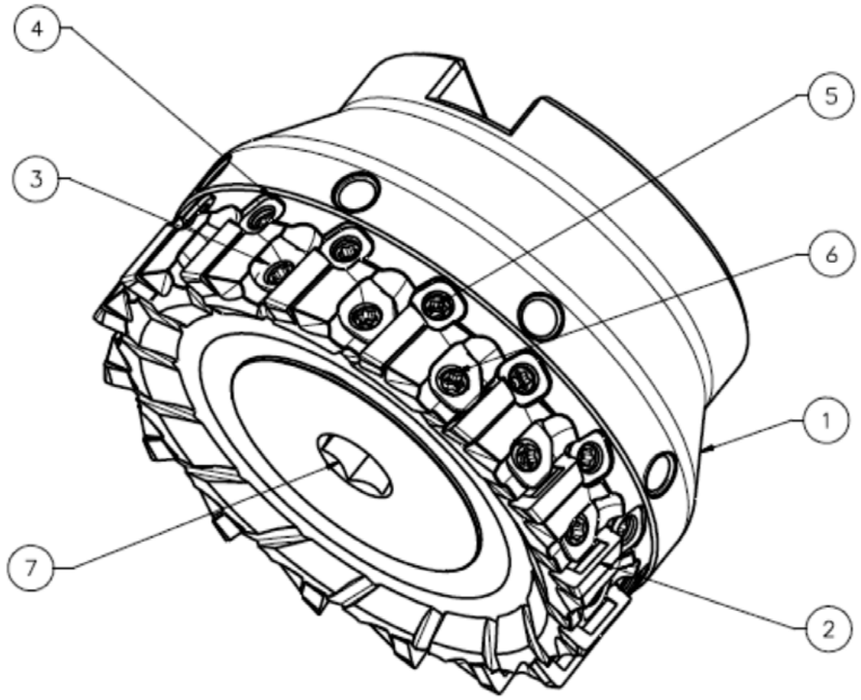
Clamping wedge	 Adjusting wedge	 Clamping screw	 Adjusting screw
ØD: 40, 50 DPM2004CU001	ØD: 40, 50 DPM2004RG001	ØD: 40, 50 DPM2004TC001	ØD: 40, 50 DPM2004TC001
ØD: 63, 80, 100, 125 DPM2004CU002	ØD: 63, 80, 100, 125 DPM2004RG002	ØD: 63, 80, 100, 125 DPM2004TC001	ØD: 63, 80, 100, 125 DPM2004TC001
ØD: 32 DPM2004CU003	ØD: 32 DPM2004RG003	ØD: 32 DPM2004TC001	ØD: 32 DPM2004TC001

Coolant Cover		Clamping & Adjusting key
ØD: 40 ; DPM2004TD001	ØD: 80 ; DPM2004TD004	ØD: 40, 50 ; DPM2004LL001
ØD: 50 ; DPM2004TD002	ØD: 100 ; DPM2004TD005	ØD: 63, 80, 100, 125 ; DPM2004LL002
ØD: 63 ; DPM2004TD003	ØD: 125 ; DPM2004TD006	ØD: 32 ; DPM2004LL003

FACE MILLING HEAD – HIGH FEED

With maximum Nr of teeth for the highest performance

ARBOUR	PCD TIPS	STEEL BODY	INTERNAL COOLAN



1	Tool body
2	Insert
3	Clamping wedge
4	Adjusting wedge
5	Adjusting wedge - screw
6	Clamping wedge - screw
7	Coolant cover

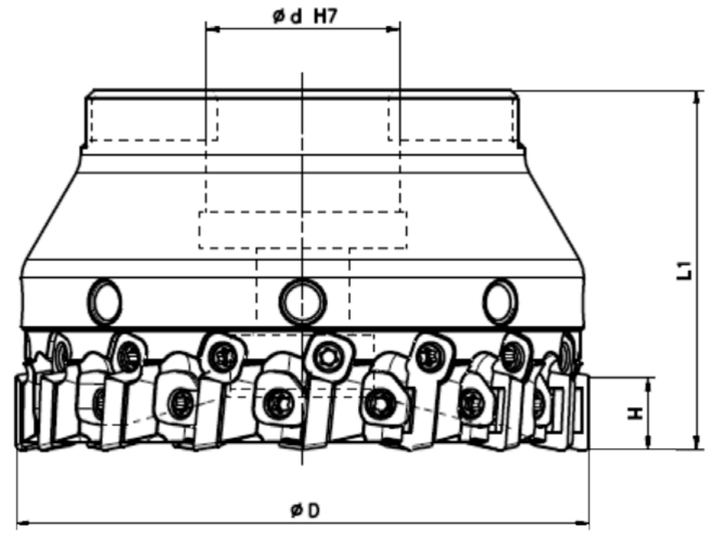
Adjustment instructions, see page 26

Working conditions, see page 27

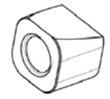
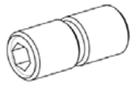
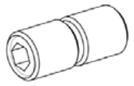
Cutting geometry, see page 25

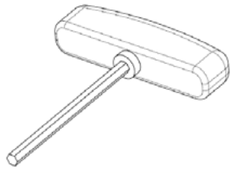
FACE MILLING HEAD – HIGH FEED

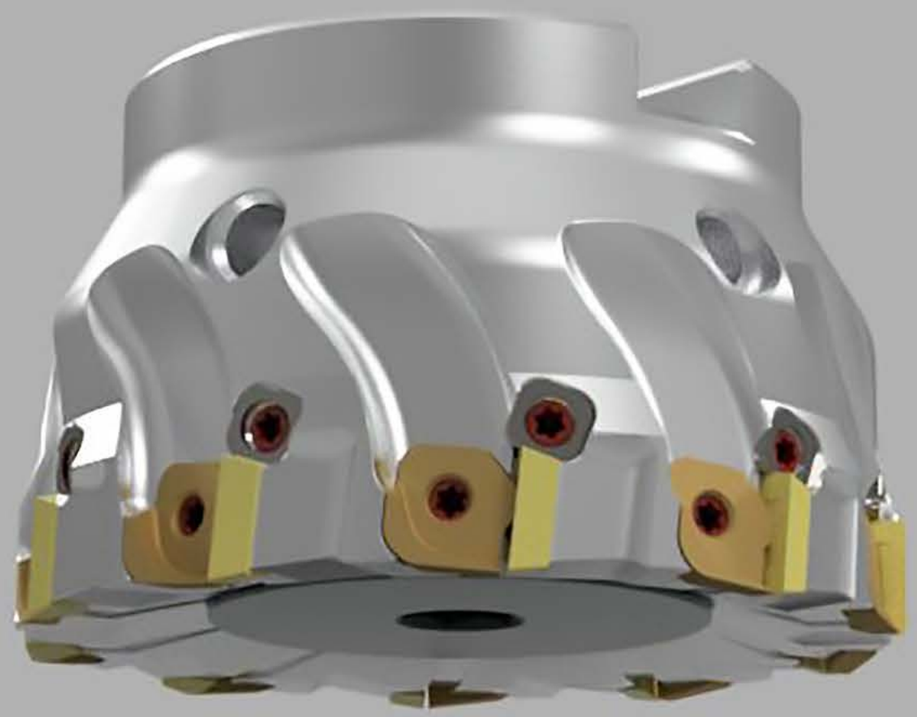
With maximum Nr of teeth for the highest performance



Art. Ref.	ØD	Bore	L1	H	Z	N max.	Kg
DPM2004301	40	16	40	10	8	45.000	0,3
DPM2004302	50	22	40	10	12	41.000	0,4
DPM2004303	63	22	50	10	14	36.000	0,9
DPM2004304	80	27	50	10	16	33.000	1,4
DPM2004305	100	32	63	10	18	30.000	2,7
DPM2004306	125	40	63	10	22	25.000	4,1

Clamping wedge	 Adjusting wedge	 Clamping screw	 Adjusting screw
ØD: 40, 50 DPM2004CU001	ØD: 40, 50 DPM2004RG001	ØD: 40, 50 DPM2004TC001	ØD: 40, 50 DPM2004TC001
ØD: 63, 80, 100, 125 DPM2004CU002	ØD: 63, 80, 100, 125 DPM2004RG002	ØD: 63, 80, 100, 125 DPM2004TC001	ØD: 63, 80, 100, 125 DPM2004TC001

Coolant Cover		 Clamping & Adjusting key
ØD: 40 ; DPM2004TD001	ØD: 80 ; DPM2004TD004	ØD: 40, 50 ; DPM2004LL001
ØD: 50 ; DPM2004TD002	ØD: 100 ; DPM2004TD005	ØD: 63, 80, 100, 125 ; DPM2004LL002
ØD: 63 ; DPM2004TD003	ØD: 125 ; DPM2004TD006	



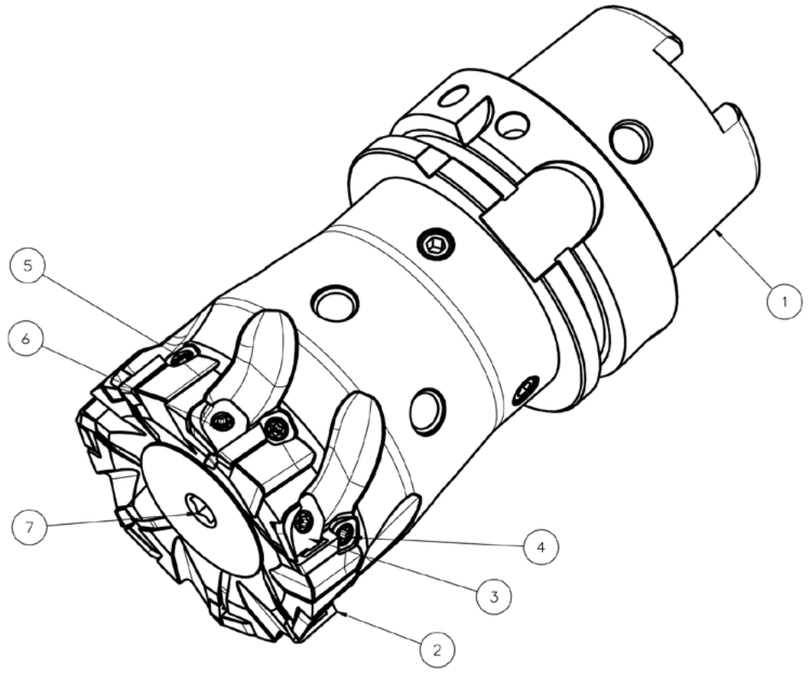
K_MILL D-FLOW SYSTEM

chips under control

FACE MILLING HEAD – D-FLOW

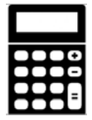
With maximum Nr of teeth for the highest performance

HSK – A63	PCD TIPS	STEEL BODY	INTERNAL COOLAN



1	Tool body
2	Insert
3	Clamping wedge
4	Adjusting wedge
5	Adjusting wedge - screw
6	Clamping wedge - screw
7	Coolant cover

Adjustment instructions, see page 26



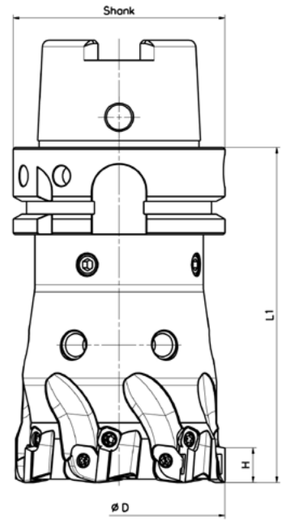
Working conditions, see page 27

Cutting geometry, see page 25

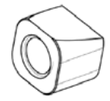
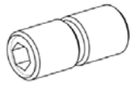
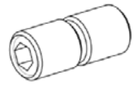
K_MILL

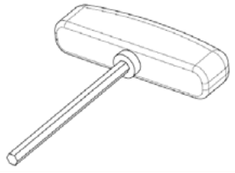
FACE MILLING HEAD – D-FLOW

With maximum Nr of teeth for the highest performance



Art. Ref.	ØD	Shank	L1	H	Z	N max.	Kg
DPM2004401	32	HSK-A63	100	10	3	36.000	1,20
DPM2004402	40	HSK-A63	100	10	5	36.000	1,36
DPM2004403	50	HSK-A63	100	10	5	33.000	1,56
DPM2004404	63	HSK-A63	100	10	7	33.000	1,90
DPM2004405	80	HSK-A63	100	10	9	28.000	2,30
DPM2004406	100	HSK-A63	100	10	14	29.500	3,20
DPM2004407	125	HSK-A63	100	10	16	25.500	4,48

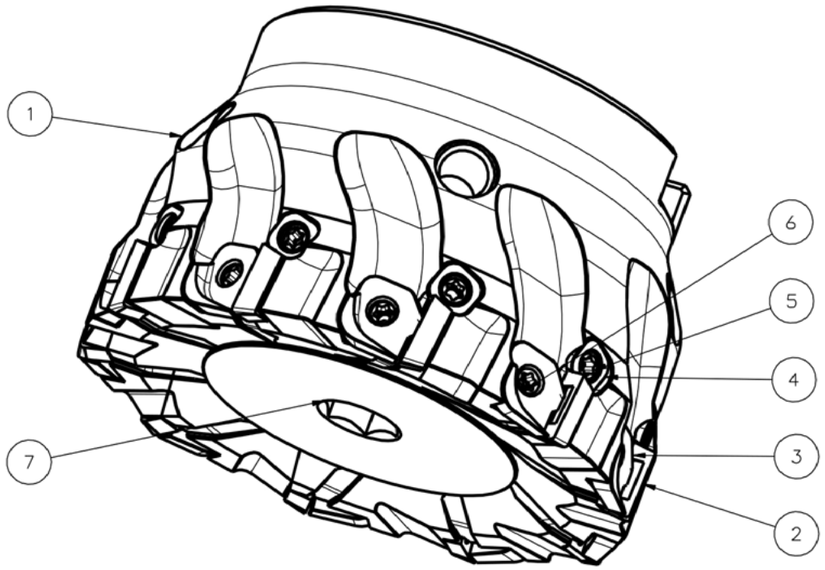
Clamping wedge	 Adjusting wedge	 Clamping screw	 Adjusting screw
ØD: 40, 50 DPM2004CU004	ØD: 40, 50 DPM2004RG001	ØD: 40, 50 DPM2004TC001	ØD: 40, 50 DPM2004TC001
ØD: 63, 80, 100, 125 DPM2004CU005	ØD: 63, 80, 100, 125 DPM2004RG002	ØD: 63, 80, 100, 125 DPM2004TC001	ØD: 63, 80, 100, 125 DPM2004TC001
ØD: 32 DPM2004CU004	ØD: 32 DPM2004RG001	ØD: 32 DPM2004TC001	ØD: 32 DPM2004TC001

Coolant Cover		 Clamping & Adjusting key
ØD: 40 ; DPM2004TD001	ØD: 80 ; DPM2004TD004	ØD: 40, 50 ; DPM2004LL001
ØD: 50 ; DPM2004TD002	ØD: 100 ; DPM2004TD005	ØD: 63, 80, 100, 125 ; DPM2004LL002
ØD: 63 ; DPM2004TD003	ØD: 125 ; DPM2004TD006	ØD: 32 ; DPM2004LL003

FACE MILLING HEAD – D-FLOW

With maximum Nr of teeth for the highest performance

ARBOUR	PCD TIPS	STEEL BODY	INTERNAL COOLAN



1	Tool body
2	Insert
3	Clamping wedge
4	Adjusting wedge
5	Adjusting wedge - screw
6	Clamping wedge - screw
7	Coolant cover

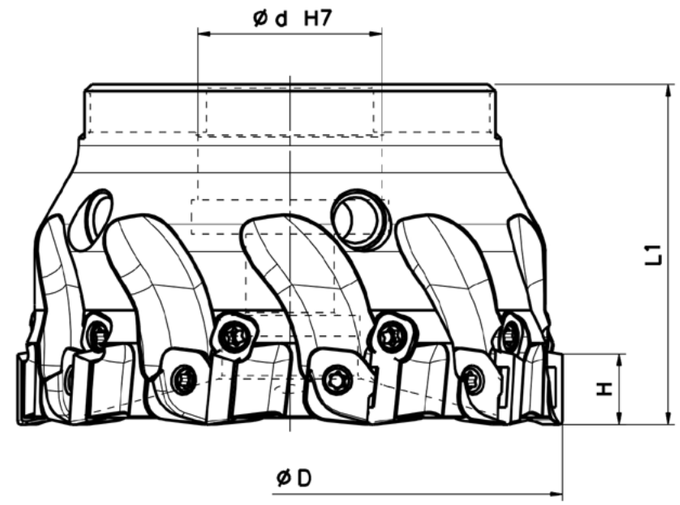
Adjustment instructions, see page 26

Working conditions, see page 27

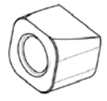
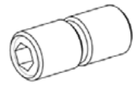
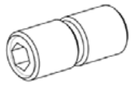
Cutting geometry, see page 25

FACE MILLING HEAD – D-FLOW

With maximum Nr of teeth for the highest performance



Art. Ref.	ØD	Bore	L1	H	Z	N max.	Kg
DPM2004410	40	16	40	11	5	36.000	0,25
DPM2004411	50	22	40	11	5	36.000	0,44
DPM2004412	63	22	50	11	7	33.000	0,85
DPM2004413	80	27	50	11	10	33.000	1,37
DPM2004414	100	32	63	11	14	29.500	2,87
DPM2004415	125	40	63	11	16	25.500	4,08

Clamping wedge	 Adjusting wedge	 Clamping screw	 Adjusting screw
ØD: 40, 50 DPM2004CU004	ØD: 40, 50 DPM2004RG001	ØD: 40, 50 DPM2004TC001	ØD: 40, 50 DPM2004TC001
ØD: 63, 80, 100, 125 DPM2004CU005	ØD: 63, 80, 100, 125 DPM2004RG002	ØD: 63, 80, 100, 125 DPM2004TC001	ØD: 63, 80, 100, 125 DPM2004TC001

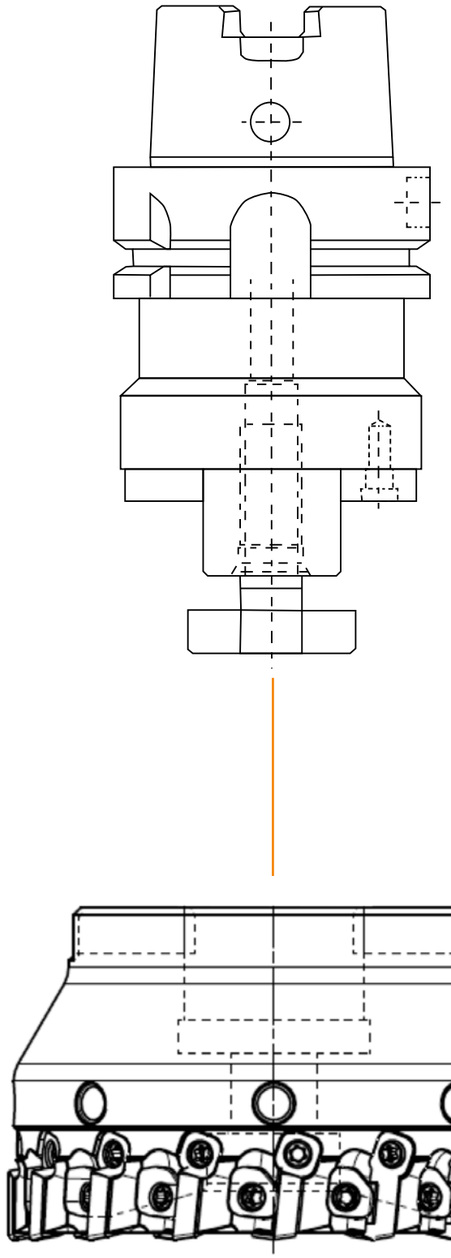
Coolant Cover		Clamping & Adjusting key
ØD: 40 ; DPM2004TD001	ØD: 80 ; DPM2004TD004	ØD: 40, 50 ; DPM2004LL001
ØD: 50 ; DPM2004TD002	ØD: 100 ; DPM2004TD005	ØD: 63, 80, 100, 125 ; DPM2004LL002
ØD: 63 ; DPM2004TD003	ØD: 125 ; DPM2004TD006	

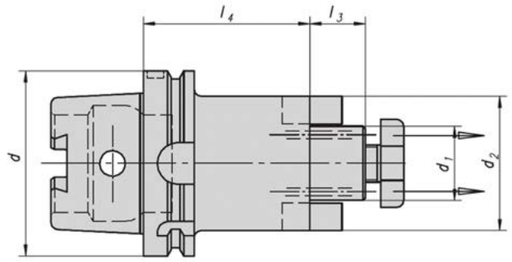
FACE MILLING HEAD – HIGH FEED

With maximum Nr of teeth for the highest performance

HSK - A ARBOR

* Special dimensions on request





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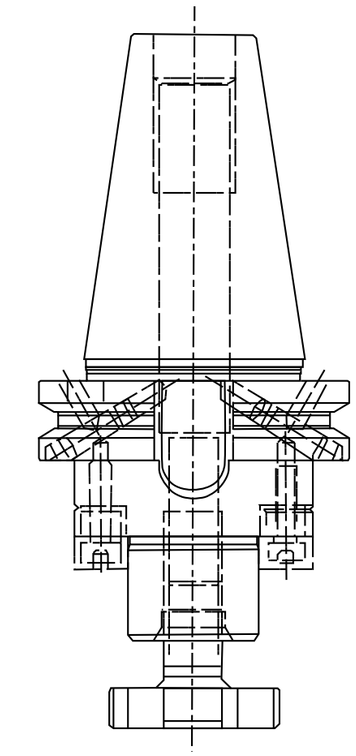
TSM1001003		27	60	21	60	
TSM1001004		32	78	24	60	
TSM1001005		40	89	27	60	
TSM1001006	HSK-A 63	16	40	17	100	
TSM1001007		22	48	19	100	
TSM1001008		27	60	21	100	
TSM1001009		32	78	24	100	
TSM1001010		40	89	27	100	
TSM1002001	HSK-A 80	16	40	17	100	
TSM1002002		22	48	19	100	
TSM1002003		27	60	21	100	
TSM1002004		32	78	24	100	
TSM1002005		40	89	27	60	
TSM1003001	HSK-A 100	16	40	17	100	
TSM1003002		22	48	19	100	
TSM1003003		27	60	21	100	
TSM1003004		32	78	24	100	
TSM1003005		40	89	27	100	
TSM1003006	HSK-A 100	16	38	17	130	
TSM1003007		16	38	17	160	
TSM1003008		22	48	19	160	
TSM1003009		27	60	21	160	
TSM1003010		32	78	24	160	
TSM1003011		40	89	27	160	
TSM1003012		60	128	30	160	

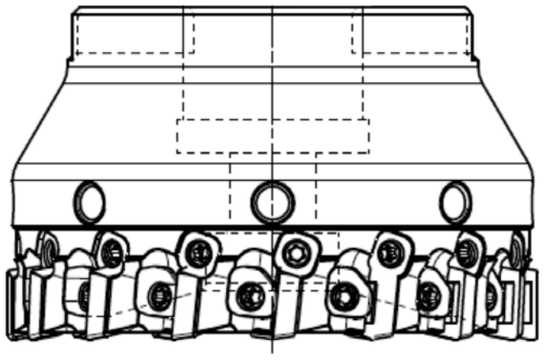
FACE MILLING HEAD – HIGH FEED

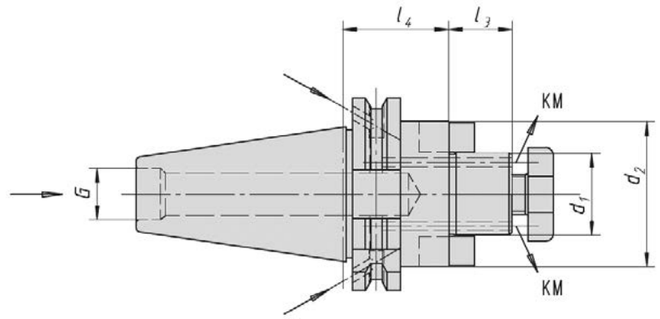
With maximum Nr of teeth for the highest performance

SK 40 / SK 50 ARBOR



* Special dimensions on request



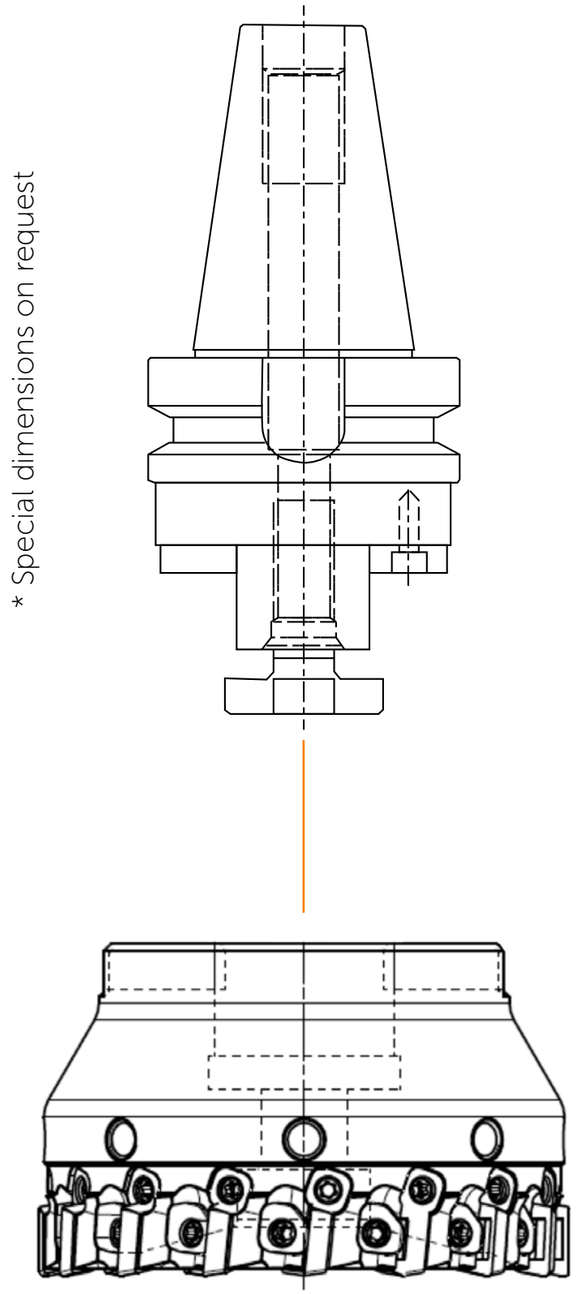


Code No.	Taper	d1	d2	l3	l4	G
TSM2001001	SK 40	16	40	17	35	M 16
TSM2001002		22	48	19	35	
TSM2001003		27	60	21	35	
TSM2001004		32	78	24	50	
TSM2001005		40	89	27	50	
TSM2002001	SK 50	16	40	17	35	M 24
TSM2002002		22	48	19	35	
TSM2002003		27	60	21	35	
TSM2002004		32	78	24	35	
TSM2002005		40	89	27	50	
TSM2002006		50	120	30	70	
TSM2002007		60	128	50	80	
TSM2002008	SK 50	16	40	17	100	M 24
TSM2002009		22	48	19	100	
TSM2002010		27	60	21	100	
TSM2002011		32	78	24	100	
TSM2002012		40	89	27	100	
TSM2002013		50	120	30	100	
TSM2002014	SK 50	16	40	17	160	M 24
TSM2002015		22	48	19	160	
TSM2002016		27	60	21	160	
TSM2002017		32	78	24	160	
TSM2002018		40	89	27	160	
TSM2002019		50	120	30	160	

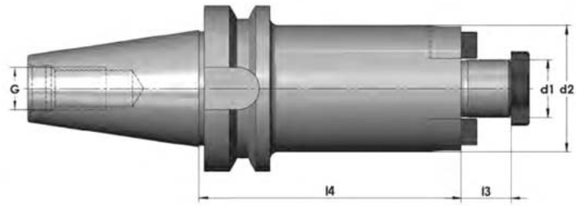
FACE MILLING HEAD – HIGH FEED

With maximum Nr of teeth for the highest performance

BT 40 / BT 50 ARBOR



* Special dimensions on request



Code No.	Taper	d1	d2	l3	l4	G
TSM3001001	BT 40	16	40	17	45	M 16
TSM3001002		22	48	19	45	
TSM3001003		27	60	21	45	
TSM3001004		32	78	24	45	
TSM3001005		40	89	27	50	
TSM3001006	BT 40	16	40	17	100	M 16
TSM3001007		22	48	19	100	
TSM3001008		27	60	21	100	
TSM3001009		32	78	24	100	
TSM3002001	BT 50	16	40	17	55	M 24
TSM3002002		22	48	19	55	
TSM3002003		27	60	21	55	
TSM3002004		32	78	24	55	
TSM3002005		40	89	27	55	
TSM3002006		50	120	30	55	
TSM3002007	BT 50	16	40	17	100	M 24
TSM3002008		22	48	19	100	
TSM3002009		27	60	21	100	
TSM3002010		32	78	24	100	
TSM3002011		40	89	27	100	

CUTTING GEOMETRY

Detail	Ref.	Group	Cutting Mat.	Rz (µm)	Ap recom. (mm)	Ap max. (mm)
GENERAL MACHINING	ØD: 32, 40, 50; DPM200411	N	PCD-B	2 - 8	2 - 5	6 - 8
	ØD: 63, 80, 100, 125; DPM200412	C	PCD-B	2 - 8	2 - 5	6 - 8
GL MACHINING + CHIPBREAKER	ØD: 32, 40, 50; DPM200413	N	PCD-B	2 - 8	2 - 5	6 - 8
	ØD: 63, 80, 100, 125; DPM200414	C	PCD-B	2 - 8	2 - 5	6 - 8
FINISHING	ØD: 32, 40, 50; DPM200415	N	PCD-B	≤2	1 - 2	4 - 6
	ØD: 63, 80, 100, 125; DPM200416	C	PCD-B	≤2	1 - 2	4 - 6
DEFINED SURFACES	ØD: 32, 40, 50; DPM200417	N	PCD-B	8 - 25	1 - 2	2
	ØD: 63, 80, 100, 125; DPM200418	C	PCD-B	8 - 25	1 - 2	2

FACE MILLING HEAD – HIGH FEED

With maximum Nr of teeth for the highest performance

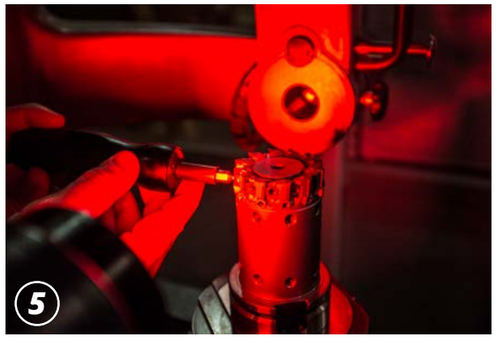
ASSEMBLY INSTRUCTIONS

Clean the insert pocket with compresed air.

Loosen the adjustment wedge to the minimum height adjustment position

Mount the same edge number (marked *) for all cutting edges.

Tighten clamping wedge with enough presure to stand the insert well positioned.



Adjust axial position of the cutting edges by screwing the adjustmet wedge to reach the proper height.

Tighten clamping wedge to 1,2 Nm torque to ensure clamping effectiveness.

RECOMMENDED CUTTING DATA

Group	Materials		Monoblock HSK-A63 Ø32	Ø40	Ø50	Ø63	Ø80	Ø100	Ø125	Arbour Ø40	Ø50	Ø63	Ø80	Ø100	Ø125
N	**N.1** Copper alloy / Brass / lead alloyed Bronze / lead Bronze ↗ cut	n (min⁻¹) max	19.800	15.900	12.700	10.100	8.000	6.300	5.100	15.900	12.700	10.100	8.000	6.300	5.100
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1
	N.2 Copper alloy / Brass / Bronze → cut	n (min⁻¹) max	23.800	22.000	20.000	18.600	16.000	13.300		22.000	20.000	18.600	16.000	13.300	
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2		0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1		0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	
	N.3 Copper alloy / Bronze / Alu / Manganese / Phosphorus bronze ↘ cut	n (min⁻¹) max	36.000	33.000	30.000	23.800	19.000	15.300		33.000	30.000	23.800	19.000	15.300	
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2		0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1		0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	
	N.4 Wrought aluminum alloy	n (min⁻¹) max	36.000	33.000	30.000	23.800	19.000	15.300		33.000	30.000	23.800	19.000	15.300	
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2		0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1		0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	
	N.5 Cast aluminum alloy / Magnesium alloy Si - content ↑ 12 %	n (min⁻¹) max	19.800	15.900	12.700	10.100	8.000	6.300	5.100	15.900	12.700	10.100	8.000	6.300	5.100
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1
	N.6 Cast aluminum alloy / Magnesium alloy Si - content ↓ 12 %	n (min⁻¹) max	36.000	33.000	30.000	23.800	19.000	15.300		33.000	30.000	23.800	19.000	15.300	
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2		0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1		0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	
C	**C.1** Composite plastics / CFRP / GFRP Plastic matrix (thermosetting)	n (min⁻¹) max	5.000	4.000	3.200	2.500	2.000	1.600	1.250	4.000	3.200	2.500	2.000	1.600	1.250
		f_z (mm) ap ≤ 1.0	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4
		f_z (mm) ap 2.0-5.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2
	C.2 Composite plastics / CFRP / GFRP Plastic matrix (thermoplastics)	n (min⁻¹) max	5.000	4.000	3.200	2.500	2.000	1.600	1.250	4.000	3.200	2.500	2.000	1.600	1.250
		f_z (mm) ap ≤ 1.0	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4	0.1 – 0.4
		f_z (mm) ap 2.0-5.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2
	C.3 Carbon fiber reinforced Carbon matrix	n (min⁻¹) max	3.000	2.400	1.900	1.500	1.200	950	760	2.400	1.900	1.500	1.200	950	760
		f_z (mm) ap ≤ 1.0	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2	0.1 – 0.2
		f_z (mm) ap 2.0-5.0	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1	0.05 – 0.1

PREZISS GROUP MATERIAL

MATERIAL GROUP	PREZISS # GROUP	MATERIAL	MATERIAL EXAMPLE DIN	MATERIAL EXAMPLE W-Nr	STRENGH (N/mm2)	HARDNESS HB
P	P.1	Non alloyed steels: structural, cast, case hardened steels	St37-2 ; 9SMn28 ; St44-2	1.0037 ; 1.0715 ; 1.0044	≤ 500	
	P.2	Non alloyed steels ; Low alloyed steels	St52-2 ; C55 ; 16MnCr5	1.0050 ; 1.0525 ; 1,7131	500-900	
	P.3	Lead alloys	9SMnPb28	1.0718	< 500	
	P.4	Non alloyed / Low alloyed steels Heat resistant structural ; Heat treated ; Nitride ; Tools steel	42CrMo4 ; CK60	1.7225 ; 1.1221	> 900	
	P.5	High alloyed steels	X6CrMo4 ; X165CrMoV12	1.2341 ; 1.2601	> 900	
M	M.1	Stainless steel - Austenitic	X2CrNi189 ; X5CrNiMo1810	1.4306 ; 1.4401	≤ 600	
	M.2	Stainless steel	X8CrNb17 ; X10CrNiMoTi1810	1.4511 ; 1.4571	< 900	
	M.3	Stainless / Heat resisting steel	X10CrAl7 ; X8CrS-38-18	1.4713 ; 1.4862	> 900	
S	S.1	Special alloys: Inconel ; Nimonic	Inconel 718 ; Nimonic 80A	2.4668 ; 2.4631		250
	S.2	Titanium & titanium alloys	TiAl5Sn2	3.7114	400	
H	H.1	Hardened steels ↓ 45 HRC			1400	
	H.2	Hardened steels ↑ 45 HRC			1800	
K	K.1	Grey cast iron	GG-25 ; GG-35	0.6025 ; 0.6035		180
	K.2	Alloyed gray cast iron	GG-NiCr202	0.6660		250
	K.3	Spheroidal graphite cast iron - ferritic	GGG-40	0.7040	≤ 600	130
	K.4	Spheroidal graphite cast iron - ferritic - perlitic	GGG-50 ; GGG-55 ; GTW-55	0.7050 ; 0.7055 ; 0.8055		230
	K.5	Spheroidal graphite cast iron – perlitic Malleable cast iron	GGG-60 ; GTS-65 GGG-80	0.7060 ; 0.8165	> 600	250
	K.6	Alloyed spheroidal graphite cast iron	GGG-NiCr20-2	0.7661		200
	K.7	Vermicular cast iron	GGV Ti<0,2 ; GGV Ti>0,2			300
N	N.1	Copper alloy / Brass / lead alloyed Bronze / lead Bronze ↗ cut	CuZn36Pb3 ; G-CuPb15Sn	2.1182 ; 2.1182		90
	N.2	Copper alloy / Brass / Bronze → cut	CuZn40Al1 ; E-Cu57	2.0550 ; 2.0060		100
	N.3	Copper alloy / Bronze / Alu / Manganese / Phosphorus bronze ↘ cut				
	N.4	Wrought aluminum alloy	AlMg1 ; AlMnCu	3.3315 ; 3.0517		60
	N.5	Cast aluminum alloy / Magnesium alloy Si - content ↑ 10 %	GD-AlSi12 ; G-AlSi10Mg	3.2382 ; 3.2383		100
	N.6	Cast aluminum alloy / Magnesium alloy Si - content ↓ 10 %	G-AlSi9Mg ; G-AlSi7Mg	3.2373 ; 3.2371		75
C	C.1	Composite plastics / CFRP / GFRP Plastic matrix (thermosetting)	HTA, IMS			
	C.2	Composite plastics / CFRP / GFRP Plastic matrix (thermoplastics)	GMT-PP, PEEK			
	C.3	Carbon fiber reinforced Carbon matrix	CF222, CF225, CF226, CF227, CF260			

GEAR BOX MACHINING:

- K_MILL head:ø 125 mm Z=22 ref.: DPM2004306
- Material: N5. Aluminum - Si >10% Si
- n= 6.500 r.p.m.
- Vc= 2.500 m/min
- Fz= 0.06 mm
- Feed rate= 8.000 mm/min
- Tool holder enlarged L=300 mm

VALVE BODY:

- K_MILL head:ø 63 mm Z=14 ref.: DPM2004004
- Material: N5. Aluminum - Si >0%
- n= 15.500 r.p.m.
- Vc= 3.070 m/min
- Fz= 0.15 mm
- Feed rate= 32.550 mm/min
- Standard HSK 63 A taper

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