

Series	612/613		614		615/616	
	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)
Aluminium cast iron Si < 8%	55-80	0.01-0.10	90-150	0.01-0.10	90-150	0.01-0.10
Aluminium cast iron Si > 8%	55-90	0.01-0.10	55-90	0.01-0.10	55-90	0.01-0.10
Steel < 1000 N/mm ²	40-60	0.009-0.04	40-60	0.009-0.04	40-60	0.009-0.04
Steel 1000-1400 N/mm ²	15-40	0.006-0.015	15-40	0.006-0.015	15-40	0.006-0.015
Stainless Steel	35-50	0.007-0.030	35-50	0.007-0.030	35-50	0.007-0.030
Ni-Cr Alloy	15-30	0.01-0.08	15-30	0.01-0.08	15-30	0.01-0.08
GG	50-65	0.007-0.030	50-65	0.007-0.030	50-65	0.007-0.030
GGG	30-50	0.007-0.030	30-50	0.007-0.030	30-50	0.007-0.030
Copper	65-80	0.01-0.10	65-80	0.01-0.10	65-80	0.01-0.10
Brass	40-55	0.009-0.040	40-55	0.009-0.040	40-55	0.009-0.040
Titanium	30-50	0.006-0.030	30-50	0.006-0.030	30-50	0.006-0.030
Plastic	30-60	0.015-0.1	30-60	0.015-0.1	30-60	0.015-0.1

Series	632K		632X		633	
	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)
Aluminium cast iron Si < 8%	90-105	0.002-0.1	90-130	0.05-0.15	55-80	0.05-0.15
Aluminium cast iron Si > 8%	55-90	0.002-0.1	55-110	0.05-0.1	60-90	0.05-0.1
Steel < 1000 N/mm ²	40-60	0.002-0.07	55-80	0.03-0.25	55-80	0.03-0.26
Steel 1000-1400 N/mm ²	15-40	0.007-0.015	60-90	0.03-0.23	60-90	0.03-0.26
Stainless Steel	40-60	0.003-0.055	40-60	0.003-0.08	40-60	0.003-0.08
Ni-Cr Alloy	15-25	0.003-0.055	15-30	0.01-0.08	15-30	0.03-0.08
GG	50-65	0.002-0.05	90-130	0.03-0.29	90-105	0.03-0.29
GGG	55-90	0.03-0.29	70-80	0.03-0.29	55-80	0.03-0.29
Copper	65-80	0.002-0.05	60-100	0.03-0.06	60-80	0.03-0.06
Brass	40-55	0.002-0.07	60-100	0.03-0.06	60-80	0.03-0.06
Titanium	30-50	0.002-0.05	30-60	0.002-0.05	30-60	0.002-0.05
Plastic	30-60	0.002-0.14	30-70	0.002-0.14	30-55	0.002-0.14

Series	636 XXX 08		636 XXX 12		637 XXX 08	
	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)
Aluminium cast iron Si < 8%	30-50	0.04-0.06	30-50	0.04-0.06	30-50	0.04-0.06
Aluminium cast iron Si > 8%	25-30	0.01-0.05	25-30	0.01-0.05	25-30	0.01-0.05
Steel < 1000 N/mm ²	40-50	0.03-0.05	40-50	0.03-0.05	40-50	0.03-0.05
Steel 1000-1400 N/mm ²	25-40	0.01-0.03	25-40	0.01-0.03	25-40	0.01-0.03
Stainless Steel	15-25	0.01-0.03	15-25	0.01-0.03	15-25	0.01-0.03
Ni-Cr Alloy	15-20	0.01-0.02	15-20	0.01-0.02	15-20	0.01-0.02
GG	40-50	0.03-0.06	40-50	0.03-0.06	40-50	0.03-0.06
GGG	30-40	0.03-0.05	30-40	0.03-0.05	30-40	0.03-0.05
Copper	40-50	0.01-0.08	40-50	0.01-0.08	40-50	0.01-0.08
Brass	40-50	0.01-0.08	40-50	0.01-0.08	40-50	0.01-0.08
Titanium	10-25	0.005-0.01	10-25	0.005-0.01	10-25	0.005-0.01
Plastic	25-40	0.01-0.03	25-40	0.01-0.03	25-40	0.01-0.03

629		630		631		632	
Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)
65-80	0.003-0.055	90-105	0.002-0.1	90-105	0.002-0.1	90-105	0.002-0.1
60-65	0.003-0.055	55-90	0.002-0.1	55-90	0.002-0.1	55-90	0.002-0.1
40-60	0.002-0.07	40-60	0.002-0.07	40-60	0.002-0.07	40-60	0.002-0.07
15-30	0.007-0.015	15-30	0.007-0.015	15-30	0.007-0.015	15-30	0.007-0.015
40-60	0.003-0.055	40-60	0.003-0.055	40-60	0.003-0.055	40-60	0.003-0.055
15-25	0.003-0.055	15-25	0.003-0.055	15-25	0.003-0.055	15-25	0.003-0.055
50-65	0.002-0.05	50-65	0.002-0.05	50-65	0.002-0.05	50-65	0.002-0.05
30-50	0.007-0.030	30-50	0.007-0.030	30-50	0.007-0.030	30-50	0.007-0.030
40-55	0.003-0.055	65-80	0.002-0.05	65-80	0.002-0.05	65-80	0.002-0.05
65-80	0.003-0.055	40-55	0.002-0.07	40-55	0.002-0.07	40-55	0.002-0.07
35-55	0.003-0.055	30-50	0.002-0.05	30-50	0.002-0.05	30-50	0.002-0.05
30-60	0.002-0.14	30-60	0.002-0.14	30-60	0.002-0.14	30-60	0.002-0.14

634		635 XXX 04		635 XXX 08		635 XXX 12	
Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)
55-80	0.05-0.15	90-110	0.03-0.25	80-100	0.03-0.25	60-80	0.01-0.20
60-90	0.05-0.1	80-100	0.02-0.15	70-90	0.02-0.15	55-75	0.008-0.10
55-80	0.03-0.26	80-100	0.03-0.20	70-90	0.03-0.25	35-50	0.02-0.06
60-90	0.03-0.26	70-100	0.03-0.20	60-80	0.03-0.23	15-30	0.005-0.04
40-60	0.003-0.08	50-60	0.01-0.05	40-60	0.01-0.05	15-30	0.01-0.04
15-30	0.03-0.08	15-30	0.01-0.08	20-35	0.01-0.08	15-30	0.005-0.06
90-105	0.03-0.29	90-130	0.03-0.29	90-130	0.03-0.29	30-60	0.02-0.05
55-80	0.03-0.29	70-100	0.03-0.29	70-100	0.03-0.29	10-25	0.01-0.04
60-80	0.03-0.06	60-100	0.03-0.06	60-100	0.03-0.06	50-90	0.03-0.06
60-80	0.03-0.06	60-100	0.03-0.06	60-100	0.03-0.06	50-90	0.03-0.06
30-60	0.002-0.05	40-60	0.002-0.05	30-60	0.002-0.05	30-60	0.002-0.05
30-55	0.002-0.14	40-70	0.002-0.14	30-70	0.002-0.14	30-70	0.002-0.14

637 XXX 12		638		639	
Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)	Vc (m/min) (Min.-Max.)	Feed (mm/rev) (Min.-Max.)
30-50	0.04-0.06	65-55	0.003-0.055	65-55	0.003-0.055
25-30	0.01-0.05	55-75	0.008-0.10	55-75	0.008-0.10
40-50	0.03-0.05	40-60	0.02-0.05	40-60	0.003-0.055
25-40	0.01-0.03	35-50	0.01-0.04	35-50	0.01-0.04
15-25	0.01-0.03	35-50	0.01-0.04	40-60	0.003-0.055
15-20	0.01-0.02	12-30	0.01-0.02	12-30	0.01-0.02
40-50	0.03-0.06	55-80	0.04-0.05	55-80	0.04-0.05
30-40	0.03-0.05	40-60	0.04-0.05	40-60	0.04-0.05
40-50	0.01-0.08	65-80	0.03-0.09	65-80	0.003-0.055
40-50	0.01-0.08	55-90	0.03-0.09	40-90	0.003-0.055
10-25	0.005-0.01	30-60	0.005-0.01	33-55	0.003-0.055
25-40	0.01-0.03	30-55	0.002-0.14	30-55	0.002-0.14