

ALFRA CUTTERS - RPM-CHART



For HSS and HSS-Co Cutter

For TCT Cutter



Material	Unalloyed steel up to 700 N/mm ²	Alloyed steel up to 1000 N/mm ²	Alu- alloy
Vc=m/min	30	20	30
Lubricants	Cutting oil	Cutting oil	Cutting oil
Ø mm Ø inch	rpm	rpm	rpm

Material	Unalloyed steel up to 700 N/mm ²	Alloyed steel up to 1000 N/mm ²	Alu- alloy
Vc=m/min	50	35	60
Lubricants	Cutting oil	Cutting oil	Cutting oil
Ø mm Ø inch	rpm	rpm	rpm

Not suitable for automatic feed!

12	¹⁵ / ₃₂	796	531	796
13	³³ / ₆₄	735	490	735
14	³⁵ / ₆₄	682	455	682
15	¹⁹ / ₃₂	637	425	637
16	⁵ / ₈	597	398	597
17	⁴³ / ₆₄	562	375	562
18	⁴⁵ / ₆₄	531	354	531
19	³ / ₄	503	335	503
20	²⁵ / ₃₂	478	318	478
21	⁵³ / ₆₄	455	303	455
22	⁷ / ₈	434	290	434
23	²⁹ / ₃₂	415	277	415
24	¹⁵ / ₁₆	398	265	398
25	⁶³ / ₆₄	382	255	382
26	1 ¹ / ₃₂	367	245	367
27	1 ¹ / ₁₆	354	236	354
28	1 ³ / ₃₂	341	227	341
29	1 ⁹ / ₆₄	329	220	329
30	1 ³ / ₁₆	318	212	318
31	1 ⁷ / ₃₂	308	205	308
32	1 ¹⁷ / ₆₄	299	199	299
33	1 ¹⁹ / ₆₄	290	193	290
34	1 ¹¹ / ₃₂	281	187	281
35	1 ³ / ₈	273	182	273
36	1 ²⁷ / ₆₄	265	177	265
37	1 ²⁹ / ₆₄	258	172	258
38	1 ¹ / ₂	251	168	251
39	1 ¹⁷ / ₃₂	245	163	245
40	1 ³⁷ / ₆₄	239	159	239
41	1 ³⁹ / ₆₄	233	155	233
42	1 ²¹ / ₃₂	227	152	227
43	1 ¹¹ / ₁₆	222	148	222
44	1 ⁴⁷ / ₆₄	217	145	217
45	1 ²⁵ / ₃₂	212	142	212
46	1 ¹³ / ₁₆	208	138	208
47	1 ⁵⁵ / ₆₄	203	136	203
48	1 ⁵⁷ / ₆₄	199	133	199
49	1 ¹⁵ / ₁₆	195	130	195
50	1 ³¹ / ₃₂	191	127	191
60	2 ³ / ₈	159	106	159

Not suitable for automatic feed!

18	⁴⁵ / ₆₄	885	619	1062
19	³ / ₄	838	587	1006
20	²⁵ / ₃₂	796	557	955
21	⁵³ / ₆₄	758	531	910
22	⁷ / ₈	724	507	869
23	²⁹ / ₃₂	692	485	831
24	¹⁵ / ₁₆	663	464	796
25	⁶³ / ₆₄	637	446	764
26	1 ¹ / ₃₂	612	429	735
27	1 ¹ / ₁₆	590	413	708
28	1 ³ / ₃₂	569	398	682
29	1 ⁹ / ₆₄	549	384	659
30	1 ³ / ₁₆	531	372	637
31	1 ⁷ / ₃₂	514	360	616
32	1 ¹⁷ / ₆₄	498	348	597
33	1 ¹⁹ / ₆₄	483	338	579
34	1 ¹¹ / ₃₂	468	328	562
35	1 ³ / ₈	455	318	546
36	1 ²⁷ / ₆₄	442	310	531
37	1 ²⁹ / ₆₄	430	301	531
38	1 ¹ / ₂	419	293	503
39	1 ¹⁷ / ₃₂	408	286	490
40	1 ³⁷ / ₆₄	398	279	478
41	1 ³⁹ / ₆₄	388	272	466
42	1 ²¹ / ₃₂	379	265	455
43	1 ¹¹ / ₁₆	370	259	444
44	1 ⁴⁷ / ₆₄	362	253	434
45	1 ²⁵ / ₃₂	354	248	425
46	1 ¹³ / ₁₆	346	242	415
47	1 ⁵⁵ / ₆₄	339	237	407
48	1 ⁵⁷ / ₆₄	332	232	398
49	1 ¹⁵ / ₁₆	325	227	390
50	1 ³¹ / ₃₂	318	223	382
55	2 ⁵ / ₃₂	290	203	347
60	2 ³ / ₈	265	186	318
65	2 ⁹ / ₁₆	245	171	294
70	2 ³ / ₄	227	159	273
75	2 ⁶¹ / ₆₄	212	149	255
80	3 ⁵ / ₃₂	199	139	239
85	3 ¹¹ / ₃₂	187	131	225
90	3 ³⁵ / ₆₄	177	124	212
95	3 ⁴⁷ / ₆₄	168	117	201
100	3 ¹⁵ / ₁₆	159	111	191

While drilling Hardox, we recommend the use of our ASP 30/ASP 60 cutters. Please use while drilling Hardox, pure cutting oil and reduce the rotation speed by 10%. Consult the column „alloyed steel“ until 1.000 N/mm². Please, use only magnet drilling machines with a high adhesion force or pillar drilling machines or milling machines.