

## 702402 (Deburring countersink)



Material Group		Vc (m/min)	fn (mm/rev)				
			ø10.0 -15.0	ø20.0 -25.0	ø30.0 -35.0	ø40.0 -45.0	ø50.0
<b>P</b>	11	28 (25-30)	0.11 (0.10-0.12)	0.17 (0.15-0.18)	0.20 (0.18-0.22)	0.22 (0.20-0.24)	0.23 (0.21-0.25)
	12						
	13	18 (15-20)	0.09 (0.08-0.10)	0.13 (0.12-0.14)	0.16 (0.15-0.17)	0.18 (0.17-0.19)	0.19 (0.18-0.20)
	14						
<b>H</b>	15	8 (5-10)	0.06 (0.05-0.07)	0.08 (0.07-0.09)	0.10 (0.09-0.11)	0.12 (0.11-0.13)	0.13 (0.12-0.14)
	16						
<b>M</b>	21	7 (6-8)	0.06 (0.05-0.07)	0.08 (0.07-0.09)	0.10 (0.09-0.11)	0.12 (0.11-0.13)	0.13 (0.12-0.14)
	22						
	23						
<b>K</b>	31	20 (15-25)	0.11 (0.10-0.12)	0.17 (0.15-0.18)	0.20 (0.18-0.22)	0.22 (0.20-0.24)	0.23 (0.21-0.25)
	32						
	33	10 (8-12)	0.09 (0.08-0.10)	0.13 (0.12-0.14)	0.16 (0.15-0.17)	0.18 (0.17-0.19)	0.19 (0.18-0.20)
	34						
<b>S</b>	41	11 (10-12)	0.11 (0.10-0.12)	0.17 (0.15-0.18)	0.20 (0.18-0.22)	0.22 (0.20-0.24)	0.23 (0.21-0.25)
	42						
	51	10 (8-12)	0.09 (0.08-0.10)	0.13 (0.12-0.14)	0.16 (0.15-0.17)	0.18 (0.17-0.19)	0.19 (0.18-0.20)
	52						
<b>N</b>	61	23 (20-25)	0.06 (0.05-0.07)	0.08 (0.07-0.09)	0.10 (0.09-0.11)	0.12 (0.11-0.13)	0.13 (0.12-0.14)
	62						
	63						
	64						
	71	28 (25-30)	0.11 (0.10-0.12)	0.17 (0.15-0.18)	0.20 (0.18-0.22)	0.22 (0.20-0.24)	0.23 (0.21-0.25)
	72						
73	20 (18-22)	0.09 (0.08-0.10)	0.13 (0.12-0.14)	0.16 (0.15-0.17)	0.18 (0.17-0.19)	0.19 (0.18-0.20)	
74							
<b>O</b>	81	25 (20-30)	0.11 (0.10-0.12)	0.17 (0.15-0.18)	0.20 (0.18-0.22)	0.22 (0.20-0.24)	0.23 (0.21-0.25)
	82						