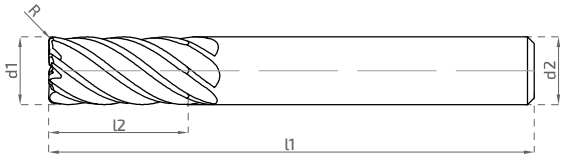


Falcon Standart Series (Z7) - HPC / Normal Cutting Edge

S	Order Code	Code	d1h10	d2h6	ØxD	l1	l2	Corner	W.Order No
	81100	160.7.0800.0640.R0030.0160.0000.0000.00.S08D1T01.01	8	8	2xD	64	16	R 0.30	**81101**
	81102	160.7.0800.0640.R0050.0200.0000.0000.00.S08D1T01.01	8	8	2,5xD	64	20	R 0.50	**81103**
	81104	160.7.0800.0640.R0050.0160.0000.0000.00.S08D1T01.01	8	8	2xD	64	16	R 0.50	**81105**
	81106	160.7.0800.0640.R0030.0200.0000.0000.00.S08D1T01.01	8	8	2,5xD	64	20	R 0.30	**81107**
	81108	160.7.1000.0730.R0050.0200.0000.0000.00.S10D1T01.01	10	10	2xD	73	20	R 0.50	**81109**
	81110	160.7.1000.0730.R0100.0250.0000.0000.00.S10D1T01.01	10	10	2,5xD	73	25	R 1.00	**81111**
	81112	160.7.1000.0730.R0100.0200.0000.0000.00.S10D1T01.01	10	10	2xD	73	20	R 1.00	**81113**
	81114	160.7.1000.0730.R0050.0250.0000.0000.00.S10D1T01.01	10	10	2,5xD	73	25	R 0.50	**81115**
	81116	160.7.1200.0840.R0050.0240.0000.0000.00.S12D1T01.01	12	12	2xD	84	24	R 0.50	**81117**
	81118	160.7.1200.0840.R0100.0300.0000.0000.00.S12D1T01.01	12	12	2,5xD	84	30	R 1.00	**81119**
	81120	160.7.1200.0840.R0100.0240.0000.0000.00.S12D1T01.01	12	12	2xD	84	24	R 1.00	**81121**
	81122	160.7.1200.0840.R0050.0300.0000.0000.00.S12D1T01.01	12	12	2,5xD	84	30	R 0.50	**81123**
	81124	160.7.1600.0930.R0050.0320.0000.0000.00.S16D1T01.01	16	16	2xD	93	32	R 0.50	**81125**
	81126	160.7.1600.0930.R0100.0400.0000.0000.00.S16D1T01.01	16	16	2,5xD	93	40	R 1.00	**81127**
	81128	160.7.1600.0930.R0100.0320.0000.0000.00.S16D1T01.01	16	16	2xD	93	32	R 1.00	**81129**
	81130	160.7.1600.0930.R0050.0400.0000.0000.00.S16D1T01.01	16	16	2,5xD	93	40	R 0.50	**81131**

Falcon Long Series (Z7) - HPC / Chip Splitter

S	Order Code	Code	d1h10	d2h6	ØxD	l1	l2	Corner	W.Order No
	81132	160CS.7.0800.0640.R0030.0240.0000.0000.00.S08D1T01.01	8	8	3xD	64	24	R 0.30	**81133**
	81134	160CS.7.0800.0640.R0050.0240.0000.0000.00.S08D1T01.01	8	8	3xD	64	24	R 0.50	**81135**
	81136	160CS.7.1000.0730.R0050.0300.0000.0000.00.S10D1T01.01	10	10	3xD	73	30	R 0.50	**81137**
	81138	160CS.7.1000.0730.R0100.0300.0000.0000.00.S10D1T01.01	10	10	3xD	73	30	R 1.00	**81139**
	81140	160CS.7.1200.0840.R0050.0360.0000.0000.00.S12D1T01.01	12	12	3xD	84	36	R 0.50	**81141**
	81142	160CS.7.1200.0840.R0100.0360.0000.0000.00.S12D1T01.01	12	12	3xD	84	36	R 1.00	**81143**
	81144	160CS.7.1600.1100.R0050.0480.0000.0000.00.S16D1T01.01	16	16	3xD	110	48	R 0.50	**81145**
	81146	160CS.7.1600.1100.R0100.0480.0000.0000.00.S16D1T01.01	16	16	3xD	110	48	R 1.00	**81147**

Cutting Parameters - Trochoidal

	Material	Trochoidal & HPC ap=2xØ-2,5xØ / ae=0.03 - 0.06 x Ø Vc (m/min)	Trochoidal & HPC ap=3xØ / ae=0.03 - 0.06 x Ø Vc (m/min)
Steel	Unalloyed Steel	130-160	130-150
	Steel	125-145	125-140
	Tempered Steel	120-140	120-135
	Cold Work Tool Steel	110-130	110-125
	Hot Work Tool Steel	100-120	100-115
Stainless Steel	AISI 304 - 416 - 420	130-150	130-145
	AISI 316 - 440	130-150	130-145
	17-4 PH 15-5 PH	110-140	110-130
	Chrome-Cobalt alloy	110-135	110-130
	Duplex F51	110-130	110-125
	Super Duplex F55	110-130	110-125
Cast Iron	Gray cast	110-130	110-125
	Alloyed cast	110-130	110-125
	Precision cast	100-120	95-115
Titanium	HRSA Hastelloy	60-90	60-80
	HRSA inconel 625	60-90	60-80
	HRSA inconel 718	60-90	60-80
	HRSA Nimonic	60-90	60-80
	Titanium	110-130	100-120
	Titanium Alloys	110-120	100-120

Feed Per Tooth (mm/tooth)

Ø	ae=0.06xØ	ae=0.03xØ	ae=0.015xØ
8	0,071-0,11	0,08-0,12	0,045-0,08
10	0,081-0,14	0,091-0,15	0,055-0,1
12	0,098-0,16	0,1-0,18	0,065-0,12
16	0,135-0,21	0,15-0,23	0,08-0,16

Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRc	○
Hardened Steel >54 HRc	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	●
Titanium	●

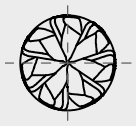
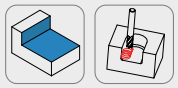
● Recommended ◑ Acceptable ○ Not Recommended

* Marked products can be delivered quickly from stock.

HPC HIGH PERFORMANCE CUTTING

Gen-Z
Falcon 160
High Performance Machining

Z7



≤52 HRc | +TiSiN | FORM HB DIN 6535 | FORM HA DIN 6535