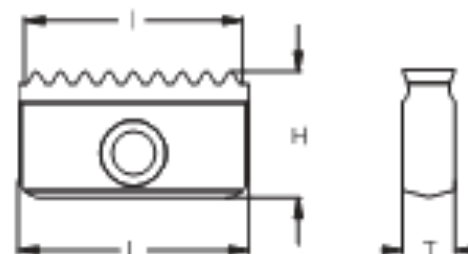
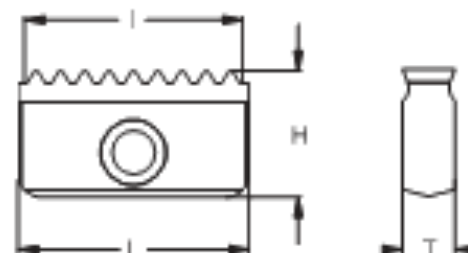


## GEOMETRY AND CUTTING CONDITIONS



|        |    |  | Description   | Pitch | Tech. Code    | P                         |                           |                            | M                         |                           | K          |            | N   | S   | H          |
|--------|----|--|---------------|-------|---------------|---------------------------|---------------------------|----------------------------|---------------------------|---------------------------|------------|------------|-----|-----|------------|
|        |    |  |               |       |               | <500<br>N/mm <sup>2</sup> | <850<br>N/mm <sup>2</sup> | <1200<br>N/mm <sup>2</sup> | <600<br>N/mm <sup>2</sup> | <850<br>N/mm <sup>2</sup> | <240<br>HB | <300<br>HB | Alu | HTA | <60<br>HRC |
| METRIC | BH |  | 14I_1.0ISO-FC | 1.0   | B9II1ISO141   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 21I_1.0ISO-FC |       | B9II1ISO211   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 14I_1.5ISO-FC | 1.5   | B9II1ISO141,5 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 21I_1.5ISO-FC |       | B9II1ISO211,5 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 30I_1.5ISO-FC |       | B9II1ISO301,5 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 14I_2.0ISO-FC | 2.0   | B9II1ISO142   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 21I_2.0ISO-FC |       | B9II1ISO212   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 30I_2.0ISO-FC |       | B9II1ISO302   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 40I_2.0ISO-FC |       | B9II1ISO402   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 14I_2.5ISO-FC | 2.5   | B9II1ISO142,5 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 21I_3.0ISO-FC | 3.0   | B9II1ISO213   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 30I_3.0ISO-FC |       | B9II1ISO303   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 40I_3.0ISO-FC |       | B9II1ISO403   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 21I_3.0ISO-FC | 3.5   | B9II1ISO213,5 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 30I_4.0ISO-FC | 4.0   | B9II1ISO304   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|        |    |  | 40I_4.0ISO-FC |       | B9II1ISO404   | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |

## GEOMETRY AND CUTTING CONDITIONS



|    |    |  | Description | Pitch | Tech. Code  | P                         |                           |                            | M                         |                           | K          |            | N   | S   | H          |
|----|----|--|-------------|-------|-------------|---------------------------|---------------------------|----------------------------|---------------------------|---------------------------|------------|------------|-----|-----|------------|
|    |    |  |             |       |             | <500<br>N/mm <sup>2</sup> | <850<br>N/mm <sup>2</sup> | <1200<br>N/mm <sup>2</sup> | <600<br>N/mm <sup>2</sup> | <850<br>N/mm <sup>2</sup> | <240<br>HB | <300<br>HB | Alu | HTA | <60<br>HRC |
| UN | BH |  | 14I_32UN-FC | 32    | B9II1UN1432 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_28UN-FC | 28    | B9II1UN1428 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_24UN-FC | 24    | B9II1UN1424 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_20UN-FC | 20    | B9II1UN1420 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 21I_20UN-FC |       | B9II1UN2120 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 30I_20UN-FC |       | B9II1UN3020 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_18UN-FC | 18    | B9II1UN1418 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 21I_18UN-FC |       | B9II1UN2118 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 30I_18UN-FC |       | B9II1UN3018 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_16UN-FC | 16    | B9II1UN1416 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 21I_16UN-FC |       | B9II1UN2116 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 30I_16UN-FC |       | B9II1UN3016 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 40I_16UN-FC |       | B9II1UN4016 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_14UN-FC | 14    | B9II1UN1414 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 21I_14UN-FC |       | B9II1UN2114 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_12UN-FC | 12    | B9II1UN1412 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 21I_12UN-FC |       | B9II1UN2112 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 30I_12UN-FC |       | B9II1UN3012 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 40I_12UN-FC |       | B9II1UN4012 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 14I_10UN-FC | 10    | B9II1UN1410 | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 21I_8UN-FC  | 8     | B9II1UN218  | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 30I_8UN-FC  |       | B9II1UN308  | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |
|    |    |  | 40I_8UN-FC  |       | B9II1UN408  | 180                       | 130                       | 80                         | 130                       | 80                        | 200        | 110        | 250 | 40  | 30         |