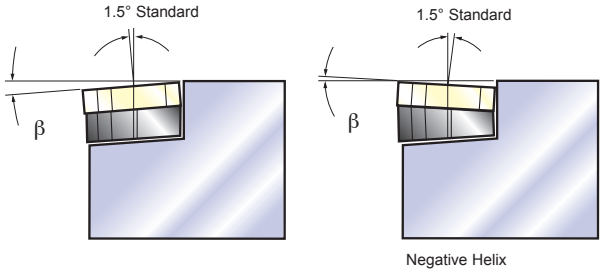
STELLRAM

5 Select Anvil

Note: The 1.5° angle is Standard with all toolholders



Insert size		Toolholder	ß Helix A			
			4.5°	3.5°	2.5°	1.5°
mm	Inch		Anvil Part N			
16	3/8"	EX RH / IN LH	YE33P	YE32P	YE31P	YE3
		EX LH / IN RH	YI33P	YI32P	YI31P	YI3
22	1/2"	EX RH / IN LH	YE43P	YE42P	YE41P	YE4
		EX LH / IN RH	YI43P	YI42P	YI41P	YI4
22U	1/2"	EX RH / IN LH	YE4U3P	YE4U2P	YE4U1P	YE4U
		EX LH / IN RH	YI4U3P	YI4U2P	YI4U1P	YI4U
27	5/8"	EX RH / IN LH	YE53P	YE52P	YE51P	YE5
		EX LH / IN RH	YI53P	YI52P	YI51P	YI5
27U	5/8"	EX RH / IN LH	YE5U3P	YE5U2P	YE5U1P	YE5U
		EX LH / IN RH	YI5U3P	YI5U2P	YI5U1P	YI5U

See page C243

6 Select Cutting Speed

Cutting Speed v_c

ISO	Materials	Rm and Hardness	PVD SP4066 m/min min. - ma
P	Unalloyed Steel	<600 N/mm² <180 HBN	230 - 485
		<950 N/mm² <280 HBN	150 - 315
	Alloyed Steel	700-950 N/mm² 200-280 HBN	135 - 290
		950-1200 N/mm² 280-355 HBN	115 -240
		1200-1400 N/mm² 355-415 HBN	75 - 165
M	Stainless Steel	Austenitic + Ferritic 300 series	155 - 330
		Martensitic 400 series	160 - 340
	PH Stainless	Refractory P.H.	80 - 175

See page C205

7 Select number and depth of passes

I.S.O Metric (ISO) 60°, External (mm)

Number of Passes	0,5	0,75	0,8	1,0	1,25	1,5	1,75
							R
1	0,102	0,178	0,178	0,178	0,178	0,229	0,229
2	0,102	0,152	0,152	0,178	0,178	0,203	0,203
3	0,076	0,102	0,127	0,127	0,152	0,178	0,152
4	0,076	0,076	0,076	0,102	0,127	0,152	0,152
5	**0,356**	**0,508**	**0,533**	0,076	0,102	0,127	0,127
6				**0,660**	0,076	0,076	0,102
7					**0,813**	**0,965**	0,102
8							0,076
9							**1,143**
10							
11							
12							
13							

See pages C251 – C259