

Verspanings parameters *Cutting Data*

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	70	2	0.010	1,5	1,5
	4.0	70	2	0.015	2,0	2,0
	6.0	70	2	0.020	3,0	3,0
	8.0	70	2	0.025	4,0	4,0
	10.0	70	2	0.030	5,0	5,0
	12.0	70	2	0.035	6,0	6,0
	16.0	70	2	0.045	8,0	8,0
P2.2 Heat Treatable steel < 1100N/mm²	3.0	60	2	0.010	1,5	1,5
	4.0	60	2	0.015	2,0	2,0
	6.0	60	2	0.020	3,0	3,0
	8.0	60	2	0.025	4,0	4,0
	10.0	60	2	0.030	5,0	5,0
	12.0	60	2	0.035	6,0	6,0
	16.0	60	2	0.045	8,0	8,0
M2.1 Stainless steel < 1600N/mm²	3.0	40	2	0.008	1,5	1,5
	4.0	40	2	0.010	2,0	2,0
	6.0	40	2	0.015	3,0	3,0
	8.0	40	2	0.018	4,0	4,0
	10.0	40	2	0.020	5,0	5,0
	12.0	40	2	0.025	6,0	6,0
	16.0	40	2	0.035	8,0	8,0
N1.1 Aluminium wrought alloys	3.0	175	2	0.010	1,5	1,5
	4.0	175	2	0.020	2,0	2,0
	6.0	175	2	0.030	3,0	3,0
	8.0	175	2	0.040	4,0	4,0
	10.0	175	2	0.050	5,0	5,0
	12.0	175	2	0.060	6,0	6,0
	16.0	175	2	0.080	8,0	8,0
N1.4 Aluminium cast alloys 6-12% Si	3.0	175	2	0.010	1,5	1,5
	4.0	175	2	0.020	2,0	2,0
	6.0	175	2	0.030	3,0	3,0
	8.0	175	2	0.040	4,0	4,0
	10.0	175	2	0.050	5,0	5,0
	12.0	175	2	0.060	6,0	6,0
	16.0	175	2	0.080	8,0	8,0
K1.2 Cast iron	3.0	70	2	0.010	1,5	1,5
	4.0	70	2	0.015	2,0	2,0
	6.0	70	2	0.020	3,0	3,0
	8.0	70	2	0.025	4,0	4,0
	10.0	70	2	0.030	5,0	5,0
	12.0	70	2	0.035	6,0	6,0
	16.0	70	2	0.045	8,0	8,0



Contour $A_p < 0,5 \times D$
en $A_e < 0,5 \times D$

