Verspanings parameters
Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	4.0	150	4	0.020	2	2
	6.0	150	4	0.030	3	3
	8.0	150	4	0.040	4	4
	10.0	150	4	0.050	5	5
	12.0	150	4	0.060	6	6
	16.0	150	4	0.080	8	8
P2.2 Heat Treatable steel <1300N/mm²	4.0	120	4	0.020	2	2
	6.0	120	4	0.030	3	3
	8.0	120	4	0.040	4	4
	10.0	120	4	0.050	5	5
	12.0	120	4	0.060	6	6
	16.0	120	4	0.080	8	8
P3.2 High Alloy steels < 800N/mm²	4.0	80	4	0.020	2	2
	6.0	80	4	0.030	3	3
	8.0	80	4	0.040	4	4
	10.0	80	4	0.050	5	5
	12.0	80	4	0.060	6	6
	16.0	80	4	0.080	8	8
M2.1 Stainless steel < 1600N/mm²	4.0	40	4	0.010	2	2
	6.0	40	4	0.015	3	3
	8.0	40	4	0.018	4	4
	10.0	40	4	0.020	5	5
	12.0	40	4	0.025	6	6
	16.0	40	4	0.035	8	8
K1.2 Cast iron	4.0	150	4	0.015	2	2
	6.0	150	4	0.020	3	3
	8.0	150	4	0.025	4	4
	10.0	150	4	0.030	5	5
	12.0	150	4	0.035	6	6
	16.0	150	4	0.045	8	8

Contour Ap<0,5xD
en Ae<0,5xD