

# Verspanings parameters *Cutting Data*

| Mat.                                                              | ØD   | R   | Vc<br>M/min | Z | fz<br>mm | ap<br>mm | ae<br>mm |
|-------------------------------------------------------------------|------|-----|-------------|---|----------|----------|----------|
| <b>P1.1</b><br><br><b>Steel</b><br>< 800N/mm²                     | 8.0  | 0.5 | 150         | 4 | 0.030    | 0.5      | 0.5      |
|                                                                   | 8.0  | 1.0 | 150         | 4 | 0.030    | 1.0      | 1.0      |
|                                                                   | 10.0 | 1.5 | 150         | 4 | 0.040    | 1.5      | 1.5      |
|                                                                   | 10.0 | 2.0 | 150         | 4 | 0.040    | 2.0      | 2.0      |
|                                                                   | 12.0 | 3.0 | 150         | 4 | 0.050    | 3.0      | 3.0      |
|                                                                   | 12.0 | 4.0 | 150         | 4 | 0.050    | 4.0      | 4.0      |
|                                                                   | 16.0 | 5.0 | 150         | 4 | 0.080    | 5.0      | 5.0      |
| <b>P2.2</b><br><br><b>Heat<br/>Treatable steel</b><br>< 1100N/mm² | 8.0  | 0.5 | 120         | 4 | 0.030    | 0.5      | 0.5      |
|                                                                   | 8.0  | 1.0 | 120         | 4 | 0.030    | 1.0      | 1.0      |
|                                                                   | 10.0 | 1.5 | 120         | 4 | 0.040    | 1.5      | 1.5      |
|                                                                   | 10.0 | 2.0 | 120         | 4 | 0.040    | 2.0      | 2.0      |
|                                                                   | 12.0 | 3.0 | 120         | 4 | 0.050    | 3.0      | 3.0      |
|                                                                   | 12.0 | 4.0 | 120         | 4 | 0.050    | 4.0      | 4.0      |
|                                                                   | 16.0 | 5.0 | 120         | 4 | 0.080    | 5.0      | 5.0      |
| <b>P3.2</b><br><br><b>High Alloy steels</b><br>< 1600N/mm²        | 8.0  | 0.5 | 80          | 4 | 0.030    | 0.5      | 0.5      |
|                                                                   | 8.0  | 1.0 | 80          | 4 | 0.030    | 1.0      | 1.0      |
|                                                                   | 10.0 | 1.5 | 80          | 4 | 0.040    | 1.5      | 1.5      |
|                                                                   | 10.0 | 2.0 | 80          | 4 | 0.040    | 2.0      | 2.0      |
|                                                                   | 12.0 | 3.0 | 80          | 4 | 0.050    | 3.0      | 3.0      |
|                                                                   | 12.0 | 4.0 | 80          | 4 | 0.050    | 4.0      | 4.0      |
|                                                                   | 16.0 | 5.0 | 80          | 4 | 0.080    | 5.0      | 5.0      |
| <b>M2.1</b><br><br><b>Stainless steel</b><br>< 1600N/mm²          | 8.0  | 0.5 | 40          | 4 | 0.030    | 0.5      | 0.5      |
|                                                                   | 8.0  | 1.0 | 40          | 4 | 0.030    | 1.0      | 1.0      |
|                                                                   | 10.0 | 1.5 | 40          | 4 | 0.040    | 1.5      | 1.5      |
|                                                                   | 10.0 | 2.0 | 40          | 4 | 0.040    | 2.0      | 2.0      |
|                                                                   | 12.0 | 3.0 | 40          | 4 | 0.050    | 3.0      | 3.0      |
|                                                                   | 12.0 | 4.0 | 40          | 4 | 0.050    | 4.0      | 4.0      |
|                                                                   | 16.0 | 5.0 | 40          | 4 | 0.080    | 5.0      | 5.0      |
| <b>K1.2</b><br><br><b>Cast iron</b>                               | 8.0  | 0.5 | 150         | 4 | 0.030    | 0.5      | 0.5      |
|                                                                   | 8.0  | 1.0 | 150         | 4 | 0.030    | 1.0      | 1.0      |
|                                                                   | 10.0 | 1.5 | 150         | 4 | 0.040    | 1.5      | 1.5      |
|                                                                   | 10.0 | 2.0 | 150         | 4 | 0.040    | 2.0      | 2.0      |
|                                                                   | 12.0 | 3.0 | 150         | 4 | 0.050    | 3.0      | 3.0      |
|                                                                   | 12.0 | 4.0 | 150         | 4 | 0.050    | 4.0      | 4.0      |
|                                                                   | 16.0 | 5.0 | 150         | 4 | 0.080    | 5.0      | 5.0      |



**Contour** Ap = max. r  
en Ae = max. r

