Verspanings parameters
Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
P1.1 Steel < 800N/mm²	3.0	180	4	0.015	3	3
	4.0	180	4	0.020	4	4
	5.0	180	4	0.030	5	5
	6.0	180	4	0.030	6	6
	8.0	180	4	0.040	8	8
	10.0	180	4	0.065	10	10
	12.0	180	4	0.070	12	12
	16.0	180	4	0.090	16	16
	20.0	180	4	0.110	20	20
	25.0	180	4	0.150	25	25
P2.2 Heat Treatable steel < 1100N/mm²	3.0	140	4	0.010	3	3
	4.0	140	4	0.015	4	4
	5.0	140	4	0.020	5	5
	6.0	140	4	0.025	6	6
	8.0	140	4	0.030	8	8
	10.0	140	4	0.050	10	10
	12.0	140	4	0.060	12	12
	16.0	140	4	0.070	16	16
	20.0	140	4	0.080	20	20
	25.0	140	4	0.090	25	25
P3.2 High Alloy steels < 1600N/mm²	3.0	60	4	0.010	3	3
	4.0	60	4	0.020	4	4
	5.0	60	4	0.025	5	5
	6.0	60	4	0.030	6	6
	8.0	60	4	0.040	8	8
	10.0	60	4	0.060	10	10
	12.0	60	4	0.070	12	12
	16.0	60	4	0.085	16	16
	20.0	60	4	0.100	20	20
	25.0	60	4	0.120	25	25
P4.2 Cold working tool steel 12% Chrom	3.0	80	4	0.010	3	3
	4.0	80	4	0.015	4	4
	5.0	80	4	0.020	5	5
	6.0	80	4	0.025	6	6
	8.0	80	4	0.030	8	8
	10.0	80	4	0.050	10	10
	12.0	80	4	0.060	12	12
	16.0	80	4	0.065	16	16
	20.0	80	4	0.085	20	20
	25.0	80	4	0.095	25	25
M2.1 Stainless steel Austenitic 303-304-316	3.0	80	4	0.008	3	3
	4.0	80	4	0.010	4	4
	5.0	80	4	0.015	5	5
	6.0	80	4	0.020	6	6
	8.0	80	4	0.025	8	8
	10.0	80	4	0.030	10	10
	12.0	80	4	0.040	12	12
	16.0	80	4	0.050	16	16
	20.0	80	4	0.070	20	20
	25.0	80	4	0.100	25	25
K1.2 Cast iron	3.0	150	4	0.015	3	3
	4.0	150	4	0.020	4	4
	5.0	150	4	0.025	5	5
	6.0	150	4	0.030	6	6
	8.0	150	4	0.050	8	8
	10.0	150	4	0.070	10	10
	12.0	150	4	0.080	12	12
	16.0	150	4	0.090	16	16
	20.0	150	4	0.100	20	20
	25.0	150	4	0.150	25	25

Correctie
Correction

Ae	Ap	Vc	fz
Ae= <0,4xD	1xD	20%	20%
Ae= <0,4xD	1,5xD	10%	10%
Ae= <0,05xD	2xD	20%	100%

Slotting Ap1xD
en Ae1xD

Contour Ap<1,5xD
en Ae<0,4xD

Finish Ap<2xD
en Ae 0,05xD