

| Mat.                              | ØD   | Vc<br>M/min | Z | ap<br>mm | fz mm<br>Ae 1xD | fz mm<br>Ae 0,6xD | drilling<br>fz<br>mm |
|-----------------------------------|------|-------------|---|----------|-----------------|-------------------|----------------------|
| N1.1                              | 6.0  | 550         | 3 | 12       | 0.05            | 0.09              | 0.05                 |
|                                   | 8.0  | 550         | 3 | 16       | 0.06            | 0.11              | 0.06                 |
|                                   | 10.0 | 550         | 3 | 20       | 0.07            | 0.13              | 0.07                 |
|                                   | 12.0 | 550         | 3 | 24       | 0.08            | 0.15              | 0.08                 |
|                                   | 16.0 | 550         | 3 | 32       | 0.12            | 0.16              | 0.12                 |
|                                   | 20.0 | 550         | 3 | 40       | 0.18            | 0.22              | 0.18                 |
| Aluminium<br>wrought alloys       |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
| N1.4                              | 6.0  | 500         | 3 | 12       | 0.05            | 0.09              | 0.05                 |
|                                   | 8.0  | 500         | 3 | 16       | 0.06            | 0.11              | 0.06                 |
|                                   | 10.0 | 500         | 3 | 20       | 0.07            | 0.13              | 0.07                 |
|                                   | 12.0 | 500         | 3 | 24       | 0.08            | 0.15              | 0.08                 |
|                                   | 16.0 | 500         | 3 | 32       | 0.12            | 0.16              | 0.12                 |
|                                   | 20.0 | 500         | 3 | 40       | 0.18            | 0.22              | 0.18                 |
| Aluminium<br>cast alloys 6-12% Si |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
| N1.5                              | 6.0  | 400         | 3 | 12       | 0.05            | 0.09              | 0.05                 |
|                                   | 8.0  | 400         | 3 | 16       | 0.06            | 0.11              | 0.06                 |
|                                   | 10.0 | 400         | 3 | 20       | 0.07            | 0.13              | 0.07                 |
|                                   | 12.0 | 400         | 3 | 24       | 0.08            | 0.15              | 0.08                 |
|                                   | 16.0 | 400         | 3 | 32       | 0.12            | 0.16              | 0.12                 |
|                                   | 20.0 | 400         | 3 | 40       | 0.18            | 0.22              | 0.18                 |
| Aluminium<br>cast alloys < 12% Si |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
| N2.1                              | 6.0  | 300         | 3 | 12       | 0.05            | 0.09              | 0.05                 |
|                                   | 8.0  | 300         | 3 | 16       | 0.06            | 0.11              | 0.06                 |
|                                   | 10.0 | 300         | 3 | 20       | 0.07            | 0.13              | 0.07                 |
|                                   | 12.0 | 300         | 3 | 24       | 0.08            | 0.15              | 0.08                 |
|                                   | 16.0 | 300         | 3 | 32       | 0.12            | 0.16              | 0.12                 |
|                                   | 20.0 | 300         | 3 | 40       | 0.18            | 0.22              | 0.18                 |
| Copper                            |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
| N2.5                              | 6.0  | 180         | 3 | 12       | 0.05            | 0.09              | 0.05                 |
|                                   | 8.0  | 180         | 3 | 16       | 0.06            | 0.11              | 0.06                 |
|                                   | 10.0 | 180         | 3 | 20       | 0.07            | 0.13              | 0.07                 |
|                                   | 12.0 | 180         | 3 | 24       | 0.08            | 0.15              | 0.08                 |
|                                   | 16.0 | 180         | 3 | 32       | 0.12            | 0.16              | 0.12                 |
|                                   | 20.0 | 180         | 3 | 40       | 0.18            | 0.22              | 0.18                 |
| Ampco                             |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |
|                                   |      |             |   |          |                 |                   |                      |

## Verspanings parameters *Cutting Data*



**Drilling** Ap1xD



**Slotting** Ap1xD  
en Ae1xD



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

