

Mat.	∅D	Vc M/min	Z	fz mm	ap mm	ae mm
<b>P1.1</b> Steel < 800N/mm <sup>2</sup>	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
<b>P2.2</b> Heat Treatable steel < 1300N/mm <sup>2</sup>	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
<b>P3.2</b> High Alloy steels < 800N/mm <sup>2</sup>	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
<b>M2.1</b> Stainless steel < 1600N/mm <sup>2</sup>	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
<b>K1.2</b> 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

## Verspanings parameters *Cutting Data*



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

