

Verspanings parameters Cutting Data

Mat.	∅D	Vc M/min	Z	fz mm	ap mm	ae mm
S1.1 Pure Titanium Ti99,5 / Ti Grade 1	3.0	100	4	0.015	3	3
	4.0	100	4	0.020	4	4
	5.0	100	4	0.025	5	5
	6.0	100	4	0.030	6	6
	8.0	100	4	0.035	8	8
	10.0	100	4	0.045	10	10
	12.0	100	4	0.055	12	12
	16.0	100	4	0.080	8	16
S1.2 Titanium alloys Ti Grade 3 & 4	3.0	90	4	0.010	3	3
	4.0	90	4	0.015	4	4
	5.0	90	4	0.020	5	5
	6.0	90	4	0.025	6	6
	8.0	90	4	0.030	8	8
	10.0	90	4	0.040	10	10
	12.0	90	4	0.050	12	12
	16.0	90	4	0.065	8	16
S1.3 Titanium alloys TiAl6V4 / Grade 5	3.0	70	4	0.007	3	3
	4.0	70	4	0.010	4	4
	5.0	70	4	0.015	5	5
	6.0	70	4	0.020	6	6
	8.0	70	4	0.025	8	8
	10.0	70	4	0.035	10	10
	12.0	70	4	0.040	12	12
	16.0	70	4	0.050	8	16
S2.2 Inconel 625	3.0	50	4	0.010	1,5	3
	4.0	50	4	0.015	2	4
	5.0	50	4	0.020	2,5	5
	6.0	50	4	0.025	3	6
	8.0	50	4	0.030	4	8
	10.0	50	4	0.035	5	10
	12.0	50	4	0.040	6	12
	16.0	50	4	0.050	8	16
S2.3 Inconel 718	3.0	40	4	0.005	1,5	3
	4.0	40	4	0.008	2	4
	5.0	40	4	0.012	2,5	5
	6.0	40	4	0.015	3	6
	8.0	40	4	0.020	4	8
	10.0	40	4	0.025	5	10
	12.0	40	4	0.030	6	12
	16.0	40	4	0.040	8	16
M1.2 Stainless steel 303-304-316	3.0	100	5	0,012	1,5	1,5
	4.0	100	5	0,015	2	2
	5.0	100	5	0,020	2,5	2,5
	6.0	100	5	0,025	3	3
	8.0	100	5	0,030	4	4
	10.0	100	5	0,035	5	5
	12.0	100	5	0,040	6	6
	16.0	100	5	0,050	8	8
20.0	100	5	0,07	10	10	

Correctie Correction

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



Slotting Ap1xD
en Ae1xD



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



Finish Ap<2xD
en Ae 0,05xD

