

Verspanings parameters

Cutting Data

Mat.	ØD	Vc M/min	Z	fz mm	ap mm	ae mm
N1.1 Aluminium wrought alloys	6.0	500	6	0.025	18	0.3
	8.0	500	6	0.035	24	0.4
	10.0	500	6	0.045	30	0.5
	12.0	500	6	0.050	36	0.6
	16.0	500	6	0.060	48	0.8
	20.0	500	6	0.070	60	1.0
N1.4 Aluminium cast alloys	6.0	300	6	0.015	6	0.3
	8.0	300	6	0.020	8	0.4
	10.0	300	6	0.025	10	0.5
	12.0	300	6	0.030	12	0.6
	16.0	300	6	0.050	16	0.8
	20.0	300	6	0.060	20	1.0
N1.5 Aluminium cast alloys	6.0	240	6	0.015	6	0.3
	8.0	240	6	0.020	8	0.4
	10.0	240	6	0.025	10	0.5
	12.0	240	6	0.030	12	0.6
	16.0	240	6	0.050	16	0.8
	20.0	240	6	0.060	20	1.0
N2.1 Copper	6.0	150	6	0.015	6	0.3
	8.0	150	6	0.020	8	0.4
	10.0	150	6	0.025	10	0.5
	12.0	150	6	0.030	12	0.6
	16.0	150	6	0.050	16	0.8
	20.0	150	6	0.060	20	1.0
N2.2 Brass	6.0	240	6	0.015	6	0.3
	8.0	240	6	0.020	8	0.4
	10.0	240	6	0.025	10	0.5
	12.0	240	6	0.030	12	0.6
	16.0	240	6	0.050	16	0.8
	20.0	240	6	0.060	20	1.0
N2.3 Bronze	6.0	150	6	0.015	6	0.3
	8.0	150	6	0.020	8	0.4
	10.0	150	6	0.025	10	0.5
	12.0	150	6	0.030	12	0.6
	16.0	150	6	0.050	16	0.8
	20.0	150	6	0.060	20	1.0
N2.5 Ampco	6.0	100	6	0.015	6	0.3
	8.0	100	6	0.020	8	0.4
	10.0	100	6	0.025	10	0.5
	12.0	100	6	0.030	12	0.6
	16.0	100	6	0.050	16	0.8
	20.0	100	6	0.060	20	1.0



Finish $A_p < 3 \times D$
en $A_e 0,05 \times D$