

Mat.	∅D	Vc M/min	Z	fz mm	ap mm	ae mm
<b>N1.1</b> Aluminium wrought alloys	6.0	500	6	0.020	16	0.3
	8.0	500	6	0.030	19	0.4
	10.0	500	6	0.040	25	0.5
	12.0	500	6	0.045	30	0.6
	16.0	500	6	0.055	40	0.8
	20.0	500	6	0.065	50	1.0
<b>N1.4</b> Aluminium cast alloys	6.0	300	6	0.015	16	0.3
	8.0	300	6	0.020	19	0.4
	10.0	300	6	0.025	25	0.5
	12.0	300	6	0.030	30	0.6
	16.0	300	6	0.045	40	0.8
	20.0	300	6	0.055	50	1.0
<b>N1.5</b> Aluminium cast alloys	6.0	240	6	0.015	16	0.3
	8.0	240	6	0.020	19	0.4
	10.0	240	6	0.025	25	0.5
	12.0	240	6	0.030	30	0.6
	16.0	240	6	0.045	40	0.8
	20.0	240	6	0.055	50	1.0
<b>N2.1</b> Copper	6.0	150	6	0.015	16	0.3
	8.0	150	6	0.020	19	0.4
	10.0	150	6	0.025	25	0.5
	12.0	150	6	0.030	30	0.6
	16.0	150	6	0.045	40	0.8
	20.0	150	6	0.055	50	1.0
<b>N2.2</b> Brass	6.0	240	6	0.015	16	0.3
	8.0	240	6	0.020	19	0.4
	10.0	240	6	0.025	25	0.5
	12.0	240	6	0.030	30	0.6
	16.0	240	6	0.045	40	0.8
	20.0	240	6	0.055	50	1.0
<b>N2.3</b> Bronze	6.0	150	6	0.015	16	0.3
	8.0	150	6	0.020	19	0.4
	10.0	150	6	0.025	25	0.5
	12.0	150	6	0.030	30	0.6
	16.0	150	6	0.045	40	0.8
	20.0	150	6	0.055	50	1.0
<b>N2.5</b> Ampco	6.0	100	6	0.015	16	0.3
	8.0	100	6	0.020	19	0.4
	10.0	100	6	0.025	25	0.5
	12.0	100	6	0.030	30	0.6
	16.0	100	6	0.045	40	0.8
	20.0	100	6	0.055	50	1.0

## Verspanings parameters *Cutting Data*



Finish  $A_p < 2xD$   
en  $A_e 0,05xD$