

MCA212R

	Material Group ISO 513	N1			N2 N3			N4			N5		
	Material	Alluminium ≤ 12% Si - Copper Alloy			Alluminium > 12% Si - Copper Alloy			Brass and bronze			Plastics		
	ap x ae	0.5D x D			0.5D x D			0.5D x D			0.5D x D		
	Vc (m/min)	200-600			200-400			150-350			600-1000w		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
	2	50000	0.022	2240	47770	0.019	1820	39810	0.016	1250	50000	0.022	2240
	3	42460	0.028	2400	31850	0.024	1530	26540	0.020	1050	50000	0.028	2820
	4	31850	0.038	2390	23890	0.032	1520	19900	0.026	1050	50000	0.038	3750
	5	25480	0.047	2400	19110	0.040	1530	15920	0.033	1050	50000	0.047	4700
	6	21230	0.056	2390	15920	0.048	1520	13270	0.039	1050	42460	0.056	4780

< D3 ap x ae 0.25D x D

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	Material	Alluminium ≤ 12% Si - Copper Alloy			Alluminium > 12% Si - Copper Alloy			Brass and bronze			Plastics		
	ap x ae	1.5D x 0.3D			1.5D x 0.3D			1.5D x 0.3D			1.5D x 0.3D		
	Vc (m/min)	300-600			250-450			200-400			600-1000		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
	2	50000	0.027	2690	50000	0.023	2280	47770	0.019	1800	50000	0.027	2690
	3	47770	0.034	3240	37150	0.029	2140	31850	0.024	1510	50000	0.034	3390
	4	35830	0.045	3230	27870	0.038	2130	23890	0.032	1510	50000	0.045	4500
	5	28660	0.056	3240	22290	0.048	2140	19110	0.040	1510	50000	0.056	5640
	6	23890	0.068	3230	18580	0.057	2140	15920	0.047	1510	42460	0.068	5740

< D3 ap x ae D x 0.5D