

CUTTING PARAMETERS

G2410-G2411

SIDE MILLING	Material Group ISO 513	P1P2K1			P3P4M1M2K2			P5M3K3			N1N2N3N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	1.5D x 0.1D			1.5D x 0.1D			1.5D x 0.1D			1.5D x 0.1D		
	Vc (m/min)	70-90			45-65			30-50			80-120		
	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)
	mm	rpm	mm/rev	mm/min	rpm	mm/rev	mm/min	rpm	mm/rev	mm/min	rpm	mm/rev	mm/min
	2	12740	0.006	320	8760	0.005	190	6370	0.005	120	15920	0.008	520
	3	8490	0.009	310	5840	0.008	180	4250	0.007	110	10620	0.012	500
	4	6370	0.012	300	4380	0.010	170	3180	0.009	110	7960	0.015	480
	5	5100	0.014	290	3500	0.012	170	2550	0.011	110	6370	0.019	480
6	4250	0.017	290	2920	0.015	170	2120	0.013	110	5310	0.022	470	
8	3180	0.023	290	2190	0.019	170	1590	0.017	110	3980	0.029	470	
10	2550	0.029	290	1750	0.024	170	1270	0.022	110	3180	0.037	480	
12	2120	0.036	310	1460	0.031	180	1060	0.027	110	2650	0.047	500	

G2412-G2413

 SIDE MILLING	Material Group ISO 513	P1P2K1			P3P4M1M2K2			P5M3K3			N1N2N3N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	1.5D x 0.1D			1.5D x 0.1D			1.5D x 0.1D			1.5D x 0.1D		
	Vc (m/min)	55-75			40-60			20-40			70-90		
	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)
	8	2590	0.020	210	1990	0.017	140	1190	0.015	70	3180	0.026	330
	10	2070	0.026	210	1590	0.022	140	960	0.019	70	2550	0.033	340
	12	1730	0.032	220	1330	0.027	140	800	0.024	80	2120	0.042	350
	14	1480	0.038	220	1140	0.032	150	680	0.028	80	1820	0.049	360
16	1290	0.043	220	1000	0.037	150	600	0.032	80	1590	0.056	360	
20	1040	0.065	270	800	0.055	180	480	0.049	90	1270	0.085	430	