

CUTTING PARAMETERS

G2CS2R

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	0.5D x D			0.5D x D			0.5D x D			0.5D x D		
	Vc (m/min)	80-100			50-70			30-50			100-120		
	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)
	1	28660	0.004	230	19110	0.003	130	12740	0.003	80	35030	0.005	360
	2	14330	0.008	230	9550	0.007	130	6370	0.006	80	17520	0.010	360
	3	9550	0.012	230	6370	0.010	130	4250	0.009	80	11680	0.016	360
	4	7170	0.016	230	4780	0.014	130	3180	0.012	80	8760	0.021	360
	5	5730	0.020	230	3820	0.017	130	2550	0.015	80	7010	0.026	360

< D3 mm: ap = 0.2D

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	1.5D x 0.5D			1.5D x 0.5D			1.5D x 0.5D			1.5D x 0.5D		
	Vc (m/min)	80-100			50-70			30-50			100-120		
	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)
	1	28660	0.005	280	19110	0.004	160	12740	0.004	90	35030	0.006	440
	2	14330	0.010	280	9550	0.008	160	6370	0.007	90	17520	0.012	440
	3	9550	0.014	280	6370	0.012	160	4250	0.011	90	11680	0.019	440
	4	7170	0.019	280	4780	0.016	160	3180	0.014	90	8760	0.025	440
	5	5730	0.024	280	3820	0.020	160	2550	0.018	90	7010	0.031	440

< D3 mm: ae = 0.2D

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	D x D			D x D			0.5D x D			D x D		
	Vc (m/min)	70-90			40-60			25-35			80-100		
	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)
	1	25480	0.002	120	15920	0.002	60	9550	0.002	30	28660	0.003	180
	2	12740	0.005	120	7960	0.004	60	4780	0.004	30	14330	0.006	180
	3	8490	0.007	120	5310	0.006	60	3180	0.005	30	9550	0.009	180
	4	6370	0.010	120	3980	0.008	60	2390	0.007	30	7170	0.012	180
	5	5100	0.012	120	3180	0.010	60	1910	0.009	30	5730	0.016	180

< D3 mm: ap = 0.5D