CUTTING PARAMETERS

G2CSHM

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3					
	Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 40 HRC					
	ap x ae	**1.5D x 0.1D**			**1.5D x 0.1D**			**1.5D x 0.1D**					
	Vc (m/min)	**100-120**			**70-90**			**50-70**					
SIDE MILLING	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)			
	6	5840	0.016	560	4250	0.014	350	3180	0.012	230			
	8	4380	0.020	530	3180	0.017	320	2390	0.015	220			
	10	3500	0.025	530	2550	0.021	330	1910	0.019	210			
	12	2920	0.030	530	2120	0.026	320	1590	0.023	210			
	14	2500	0.035	530	1820	0.030	320	1360	0.026	210			
	16	2190	0.040	530	1590	0.034	320	1190	0.030	210			
	20	1750	0.050	530	1270	0.043	320	960	0.038	220			