

CUTTING PARAMETERS

MEXCL2

 SLOTTING	Material Group ISO 513	P2 P3 P4 K1 K2			P4 P5 K3			P6 K4			H1 H4 H5		
	Hardness/Rm	< 1000 N/mm ²			< 35 HRC			35 - 45 HRC			45 - 55 HRC		
	ap x ae	0.3D x D			0.3D x D			0.2D x D			0.05D x D		
	Vc (m/min)	70-110			50-90			30-70			20-40		
	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	28700	0.005	290	22300	0.005	200	15900	0.004	125	9600	0.004	65
	1.5	19100	0.006	230	14900	0.005	160	10600	0.005	100	6400	0.004	55
	2	14300	0.009	260	11100	0.008	180	8000	0.007	115	4800	0.006	60
	3	9600	0.012	230	7400	0.011	160	5300	0.010	100	3200	0.008	55
	4	7200	0.018	260	5600	0.016	180	4000	0.014	115	2400	0.013	60
	5	5700	0.024	270	4500	0.022	190	3200	0.019	125	1900	0.017	65
	6	4800	0.029	280	3700	0.026	190	2700	0.023	125	1600	0.020	65
	8	3600	0.035	250	2800	0.032	180	2000	0.028	110	1200	0.025	60
	10	2900	0.041	240	2200	0.037	160	1600	0.033	105	1000	0.029	55
	12	2400	0.050	240	1900	0.045	170	1300	0.040	105	800	0.035	55

< D3: ap = 0.4 mm max