MHMB206

COPYING	Material Group ISO 513		P3 P4 P5 K2 K3			P6 K4 H1 H4 H5			H2			H3		
	Hardness/Rm		< 45 HRC			45 - 55 HRC			55 - 60 HRC			60 - 65 HRC		
	ap x ae		**0.05D x 0.2D**			**0.05D x 0.2D**			**0.05D x 0.2D**			**0.05D x 0.2D**		
	Vc (m/min)		**80-120**			**60-100**			**50-70**			**30-50**		
	D (mm)	D (eff.) (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	0.4	**0.17**	40000	0.010	800	40000	0.009	720	40000	0.008	640	31850	0.007	445
	0.5	**0.22**	40000	0.012	960	40000	0.011	860	38220	0.010	735	25480	0.008	430
	0.6	**0.26**	40000	0.015	1200	40000	0.014	1080	31850	0.012	765	21230	0.011	445
	0.8	**0.35**	39810	0.020	1590	31850	0.018	1150	23890	0.016	765	15920	0.014	445

α	n (rpm)	Vf (mm/min)
15°	x 1.1	x 1.1