

CUTTING PARAMETERS

UH612

SIDE MILLING

Material Group ISO 513	P3P4P5K2K3					P6K4H1H4H5					H2			H3		
Hardness/Rm	< 45 HRC					45 - 55 HRC					55 - 60 HRC			60 - 65 HRC		
ap x ae	1.5D x 0.05D					1.5D x 0.05D					1.5D x 0.05D			1.5D x 0.05D		
Vc (m/min)	90-130					70-110					50-70			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)				
3	11680	0.007	500	9550	0.006	370	6370	0.006	220	3180	0.005	100				
4	8760	0.010	540	7170	0.009	390	4780	0.008	230	2390	0.007	100				
5	7010	0.012	510	5730	0.011	380	3820	0.010	220	1910	0.009	100				
6	5840	0.015	540	4780	0.014	390	3180	0.012	230	1590	0.011	100				
8	4380	0.023	620	3580	0.021	450	2390	0.019	270	1190	0.016	120				
10	3500	0.029	600	2870	0.026	440	1910	0.023	260	960	0.020	120				
12	2920	0.035	610	2390	0.031	450	1590	0.028	260	800	0.024	120				
14	2500	0.041	610	2050	0.037	450	1360	0.033	270	680	0.029	120				
16	2190	0.048	630	1790	0.043	460	1190	0.038	270	600	0.034	120				
18	1950	0.056	660	1590	0.050	480	1060	0.045	290	530	0.039	120				
20	1750	0.066	700	1430	0.060	510	960	0.053	310	480	0.046	130				