

CUTTING PARAMETERS

UHM206

	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	ap x D					ap x D					ap x D			ap x D		
	Vc (m/min)	80-120					60-100					50-70			30-50		
	D (mm)	ap (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)	n (rpm)	fn (mm/rev)	Vf (mm/min)
	0.3	0.02	40000	0.004	320	40000	0.004	290	40000	0.003	255	40000	0.003	225	40000	0.003	225
	0.4	0.02	40000	0.006	480	40000	0.005	430	40000	0.005	385	31850	0.004	270	31850	0.004	270
	0.5	0.03	40000	0.007	560	40000	0.006	500	38220	0.006	430	25480	0.005	250	25480	0.005	250
	0.6	0.03	40000	0.008	640	40000	0.007	580	31850	0.006	410	21230	0.006	240	21230	0.006	240
	0.8	0.04	39810	0.010	800	31850	0.009	570	23890	0.008	380	15920	0.007	225	15920	0.007	225
	1	0.05	31850	0.012	760	25480	0.011	550	19110	0.010	365	12740	0.008	215	12740	0.008	215
	1.5	0.08	21230	0.025	1060	16990	0.023	760	12740	0.020	510	8490	0.018	295	8490	0.018	295
	2	0.10	15920	0.030	960	12740	0.027	690	9550	0.024	460	6370	0.021	270	6370	0.021	270