CUTTING PARAMETERS

G2CS4

SIDE MILLING

Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
Hardness/Rm	< 700 N/mm²			700-1000 N/mm²			< 40 HRC					
ap x ae	**1.5D x 0.2D**			**1.5D x 0.2D**			**1.5D x 0.2D**			**1.5D x 0.2D**		
Vc (m/min)	**80-100**			**50-70**			**30-50**			**100-120**		
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	28660	0.004	400	19110	0.003	230	12740	0.003	130	35030	0.005	640
2	14330	0.007	400	9550	0.006	230	6370	0.005	130	17520	0.009	640
3	9550	0.010	380	6370	0.009	220	4250	0.008	130	11680	0.013	610
4	7170	0.013	370	4780	0.011	210	3180	0.010	120	8760	0.017	590
5	5730	0.016	370	3820	0.014	210	2550	0.012	120	7010	0.021	580
6	4780	0.019	360	3180	0.016	210	2120	0.014	120	5840	0.025	580
8	3580	0.025	360	2390	0.021	200	1590	0.019	120	4380	0.033	570
10	2870	0.032	370	1910	0.027	210	1270	0.024	120	3500	0.042	580
12	2390	0.040	380	1590	0.034	220	1060	0.030	130	2920	0.052	610
14	2050	0.047	390	1360	0.040	220	910	0.035	130	2500	0.061	610
16	1790	0.054	390	1190	0.046	220	800	0.041	130	2190	0.070	610
18	1590	0.060	380	1060	0.051	220	710	0.045	130	1950	0.078	610
20	1430	0.065	370	960	0.055	210	640	0.049	120	1750	0.085	590
22	1300	0.073	380	870	0.062	220	580	0.055	130	1590	0.095	600
25	1150	0.083	380	760	0.071	210	510	0.062	130	1400	0.108	600

< D3 mm: ae = 0.1D