CUTTING PARAMETERS

G2WSH3

	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	**0.5D x D**			**0.5D x D**			**0.5D x D**			**0.5D x D**		
	Vc (m/min)	**80-100**			**50-70**			**30-50**			**80-120**		
SLOTTING	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	9550	0.009	270	6370	0.008	150	4250	0.007	90	10620	0.012	390
	4	7170	0.013	270	4780	0.011	150	3180	0.009	90	7960	0.016	390
	5	5730	0.016	270	3820	0.013	150	2550	0.012	90	6370	0.020	390
	6	4780	0.019	270	3180	0.016	150	2120	0.014	90	5310	0.024	390
	8	3580	0.025	270	2390	0.021	150	1590	0.019	90	3980	0.033	390
	10	2870	0.031	270	1910	0.027	150	1270	0.023	90	3180	0.041	390
	12	2390	0.040	290	1590	0.034	160	1060	0.030	100	2650	0.052	410
	14	2050	0.046	280	1360	0.039	160	910	0.035	90	2270	0.060	410
	16	1790	0.056	300	1190	0.048	170	800	0.042	100	1990	0.073	440
	18	1590	0.065	310	1060	0.055	180	710	0.049	100	1770	0.085	450
	20	1430	0.075	320	960	0.064	180	640	0.056	110	1590	0.098	470

< D3 mm: ap = 0.2D

	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 0.3D**			**1.5D x 0.3D**			**1.5D x 0.3D**			**1.5D x 0.3D**		
	Vc (m/min)	**90-110**			**60-80**			**40-60**			**110-120**		
SIDE MILLING	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	10620	0.011	360	7430	0.010	210	5310	0.008	130	12740	0.015	560
	4	7960	0.015	360	5570	0.013	210	3980	0.011	130	9550	0.020	560
	5	6370	0.019	360	4460	0.016	210	3180	0.014	130	7640	0.024	560
	6	5310	0.023	360	3720	0.019	210	2650	0.017	130	6370	0.029	560
	8	3980	0.030	360	2790	0.026	210	1990	0.023	130	4780	0.039	560
	10	3180	0.038	360	2230	0.032	210	1590	0.028	130	3820	0.049	560
	12	2650	0.048	380	1860	0.041	230	1330	0.036	140	3180	0.062	600
	14	2270	0.056	380	1590	0.047	230	1140	0.042	140	2730	0.072	590
	16	1990	0.068	400	1390	0.057	240	1000	0.051	150	2390	0.088	630
	18	1770	0.078	410	1240	0.066	250	880	0.059	150	2120	0.101	640
	20	1590	0.090	430	1110	0.077	250	800	0.068	160	1910	0.117	670

< D3 mm: ae = 0.1D