

CUTTING PARAMETERS

GB405

 SIDE MILLING	Material Group ISO 513	P1 K1			P2 M1 K2			P3 M2			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 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)	50-70			40-50			20-40			80-100		
	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	19110	0.003	250	14330	0.003	160	9550	0.002	90	28660	0.004	480
	2	9550	0.006	250	7170	0.006	160	4780	0.005	90	14330	0.008	480
	3	6370	0.010	250	4780	0.008	160	3180	0.007	90	9550	0.013	480
	4	4780	0.013	250	3580	0.011	160	2390	0.010	90	7170	0.017	480
	5	3820	0.016	250	2870	0.014	160	1910	0.012	90	5730	0.021	480
	6	3180	0.020	260	2390	0.017	160	1590	0.015	100	4780	0.026	500
	8	2390	0.026	250	1790	0.022	160	1190	0.019	90	3580	0.034	480
	10	1910	0.031	240	1430	0.026	150	960	0.023	90	2870	0.040	460
	12	1590	0.036	230	1190	0.031	150	800	0.027	90	2390	0.047	450

< D3 mm: ae = 0.1D