

Material
Cast iron GG(G)

M	d ₂ [mm]	v _c [m/min]	f [mm]	L _K [mm]	n [min ⁻¹]	v _f [mm/min]
M 4	3.30	100	0.050	7.4	9645	480
M 5	4.20	100	0.065	9.4	7580	495
M 6	5.00	100	0.075	11.7	6365	475
M 8	6.80	100	0.100	14.7	4680	470
M 10	8.50	100	0.125	19.3	3745	470
M 12	10.20	100	0.150	22.2	3120	470
M 16	14.00	100	0.210	27.8	2275	480

Material
Cast aluminium

M 4	3.30	250	0.060	7.4	24115	1445
M 5	4.20	250	0.075	9.4	18950	1420
M 6	5.00	250	0.090	11.7	15915	1430
M 8	6.80	250	0.120	14.7	11705	1405
M 10	8.50	250	0.150	19.3	9360	1405
M 12	10.20	250	0.180	22.2	7800	1405
M 16	14.00	250	0.250	27.8	5685	1420

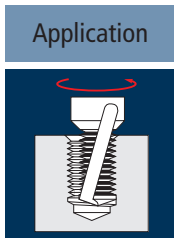
Material
Wrought aluminium alloys Si < 6%

M 4	3.30	200	0.060	7.4	19290	1155
M 5	4.20	200	0.075	9.4	15160	1135
M 6	5.00	200	0.090	11.7	12735	1145
M 8	6.80	200	0.120	14.7	9360	1125
M 10	8.50	200	0.150	19.3	7490	1125
M 12	10.20	200	0.180	22.2	6240	1125
M 16	14.00	200	0.250	27.8	4545	1135

Material
Short-chipping brass CuZn

M 4	3.30	250	0.060	7.4	24115	1445
M 5	4.20	250	0.075	9.4	18950	1420
M 6	5.00	250	0.090	11.7	15915	1430
M 8	6.80	250	0.120	14.7	11705	1405
M 10	8.50	250	0.150	19.3	9360	1405
M 12	10.20	250	0.180	22.2	7800	1405
M 16	14.00	250	0.250	27.8	5685	1420

Cutting data for TiCN-coated tools



Material
Cast iron GG(G)

M	D1 [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fc} [mm/min]	v _f [mm/min]
M 4	3.20	0.70	2	100	0.025	9945	99	495
M 5	4.00	0.80	2	100	0.030	7960	96	480
M 6	4.75	1.00	2	100	0.035	6700	98	470
M 8	6.35	1.25	2	100	0.050	5015	103	500
M 10	7.95	1.50	2	100	0.060	4005	98	480
M 12	9.95	1.75	2	100	0.075	3200	82	480
M 16	13.20	2.00	2	100	0.100	2410	84	480

Material
Cast aluminium

M 4	3.20	0.70	2	250	0.030	24870	298	1490
M 5	4.00	0.80	2	250	0.035	19895	279	1395
M 6	4.75	1.00	2	250	0.045	16755	315	1510
M 8	6.35	1.25	2	250	0.060	12530	310	1505
M 10	7.95	1.50	2	250	0.070	10010	287	1400
M 12	9.95	1.75	2	250	0.090	8000	246	1440
M 16	13.20	2.00	2	250	0.120	6030	253	1445

Material
Wrought aluminium alloys Si < 6%

M 4	3.20	0.70	2	200	0.030	19895	239	1195
M 5	4.00	0.80	2	200	0.035	15915	223	1115
M 6	4.75	1.00	2	200	0.045	13405	251	1205
M 8	6.35	1.25	2	200	0.060	10025	249	1205
M 10	7.95	1.50	2	200	0.070	8010	230	1120
M 12	9.95	1.75	2	200	0.090	6400	196	1150
M 16	13.20	2.00	2	200	0.120	4825	203	1160

Material
Short-chipping brass CuZn

M 4	3.20	0.70	2	250	0.030	24870	298	1490
M 5	4.00	0.80	2	250	0.035	19895	279	1395
M 6	4.75	1.00	2	250	0.045	16755	315	1510
M 8	6.35	1.25	2	250	0.060	12530	310	1505
M 10	7.95	1.50	2	250	0.070	10010	287	1400
M 12	9.95	1.75	2	250	0.090	8000	246	1440
M 16	13.20	2.00	2	250	0.120	6030	253	1445

Cutting data for TiCN-coated tools