

Application	Material	d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
	Wrought aluminium Construction aluminium 	6.00	3	300	0.025	32.000	0.080	15915	1195
		8.00	3	300	0.030	42.000	0.100	11935	1075
		10.00	3	350	0.030	53.000	0.120	11140	1005
		12.00	3	350	0.030	63.000	0.120	9285	835
		16.00	3	400	0.035	84.000	0.150	7960	835
		20.00	3	400	0.035	105.000	0.150	6365	670
	Cast aluminium 	6.00	3	270	0.025	32.000	0.080	14325	1075
		8.00	3	270	0.030	42.000	0.100	10745	965
		10.00	3	315	0.030	53.000	0.120	10025	900
		12.00	3	315	0.030	63.000	0.120	8355	750
		16.00	3	360	0.035	84.000	0.150	7160	750
		20.00	3	360	0.035	105.000	0.150	5730	600
	Wrought aluminium Construction aluminium 	6.00	3	200	0.020	32.000	0.030	10610	635
		8.00	3	200	0.025	42.000	0.050	7960	595
		10.00	3	250	0.025	53.000	0.050	7960	595
		12.00	3	250	0.025	63.000	0.050	6630	495
		16.00	3	300	0.030	84.000	0.050	5970	535
		20.00	3	300	0.030	105.000	0.050	4775	430
	Cast aluminium 	6.00	3	180	0.020	32.000	0.030	9550	575
		8.00	3	180	0.025	42.000	0.050	7160	535
		10.00	3	225	0.025	53.000	0.050	7160	535
		12.00	3	225	0.025	63.000	0.050	5970	450
		16.00	3	270	0.030	84.000	0.050	5370	485
		20.00	3	270	0.030	105.000	0.050	4295	385
	Wrought aluminium Construction aluminium 	6.00	3	200	0.025	32.000	0.060	10610	795
		8.00	3	200	0.030	42.000	0.060	7960	715
		10.00	3	250	0.030	53.000	0.080	7960	715
		12.00	3	250	0.030	63.000	0.080	6630	595
		16.00	3	300	0.035	84.000	0.100	5970	625
		20.00	3	300	0.035	105.000	0.100	4775	500
	Unalloyed copper 	6.00	3	120	0.025	32.000	0.060	6365	475
		8.00	3	120	0.030	42.000	0.060	4775	430
		10.00	3	150	0.030	53.000	0.080	4775	430
		12.00	3	150	0.030	63.000	0.080	3980	360
		16.00	3	180	0.035	84.000	0.100	3580	375
		20.00	3	180	0.035	105.000	0.100	2865	300
	Wrought aluminium Construction aluminium 	6.00	3	150	0.020	32.000	0.030	7960	475
		8.00	3	150	0.025	42.000	0.030	5970	450
		10.00	3	200	0.025	53.000	0.040	6365	475
		12.00	3	200	0.025	63.000	0.040	5305	400
		16.00	3	250	0.030	84.000	0.050	4975	450
		20.00	3	250	0.030	105.000	0.050	3980	360
	Unalloyed copper 	6.00	3	90	0.020	32.000	0.030	4775	285
		8.00	3	90	0.025	42.000	0.030	3580	270
		10.00	3	120	0.025	53.000	0.040	3820	285
		12.00	3	120	0.025	63.000	0.040	3185	240
		16.00	3	150	0.030	84.000	0.050	2985	270
		20.00	3	150	0.030	105.000	0.050	2385	215