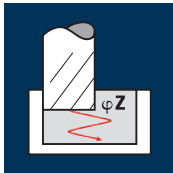
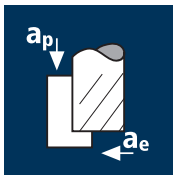


Application



Material

Wrought aluminium
Construction aluminium

Cast aluminium

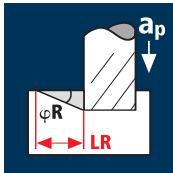
Unalloyed copper

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	Z [°]
6.00	3	450	0.064	9.000	3.600	23875	4585	148.5	15°
8.00	3	450	0.080	12.000	4.800	17905	4295	247.5	15°
10.00	3	450	0.096	15.000	6.000	14325	4125	371.3	15°
12.00	3	450	0.112	18.000	7.200	11935	4010	519.8	15°
16.00	3	450	0.128	24.000	9.600	8950	3440	792.1	15°
20.00	3	450	0.144	30.000	12.000	7160	3095	1113.8	15°
25.00	3	450	0.160	37.500	15.000	5730	2750	1547.0	15°

6.00	3	405	0.064	9.000	3.600	21485	4125	133.7	15°
8.00	3	405	0.080	12.000	4.800	16115	3865	222.8	15°
10.00	3	405	0.096	15.000	6.000	12890	3715	334.1	15°
12.00	3	405	0.112	18.000	7.200	10745	3610	467.8	15°
16.00	3	405	0.128	24.000	9.600	8055	3095	712.9	15°
20.00	3	405	0.144	30.000	12.000	6445	2785	1002.4	15°
25.00	3	405	0.160	37.500	15.000	5155	2475	1392.3	15°

6.00	3	360	0.058	9.000	3.600	19100	3300	106.9	9°
8.00	3	360	0.072	12.000	4.800	14325	3095	178.2	9°
10.00	3	360	0.086	15.000	6.000	11460	2970	267.3	9°
12.00	3	360	0.101	18.000	7.200	9550	2890	374.2	9°
16.00	3	360	0.115	24.000	9.600	7160	2475	570.3	9°
20.00	3	360	0.130	30.000	12.000	5730	2230	802.0	9°
25.00	3	360	0.144	37.500	15.000	4585	1980	1113.8	9°

Application



Material

Wrought aluminium
Construction aluminium

Cast aluminium

Unalloyed copper

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	R [°]	LR [mm]
6.00	3	315	0.051	9.000	6.000	16710	2565	138.6	15°	33.6
8.00	3	315	0.064	12.000	8.000	12535	2405	231.0	15°	44.8
10.00	3	315	0.077	15.000	10.000	10025	2310	346.5	15°	56.0
12.00	3	315	0.090	18.000	12.000	8355	2245	485.1	15°	67.2
16.00	3	315	0.102	24.000	16.000	6265	1925	739.3	15°	89.6
20.00	3	315	0.115	30.000	20.000	5015	1735	1039.6	15°	112.0
25.00	3	315	0.128	37.500	25.000	4010	1540	1443.9	15°	140.0

6.00	3	285	0.051	9.000	6.000	15120	2320	125.4	15°	33.6
8.00	3	285	0.064	12.000	8.000	11340	2175	209.0	15°	44.8
10.00	3	285	0.077	15.000	10.000	9070	2090	313.5	15°	56.0
12.00	3	285	0.090	18.000	12.000	7560	2030	438.9	15°	67.2
16.00	3	285	0.102	24.000	16.000	5670	1740	668.8	15°	89.6
20.00	3	285	0.115	30.000	20.000	4535	1570	940.6	15°	112.0
25.00	3	285	0.128	37.500	25.000	3630	1395	1306.3	15°	140.0

6.00	3	216	0.040	9.000	6.000	11460	1385	74.8	9°	56.8
8.00	3	216	0.050	12.000	8.000	8595	1300	124.7	9°	75.8
10.00	3	216	0.060	15.000	10.000	6875	1245	187.1	9°	94.7
12.00	3	216	0.071	18.000	12.000	5730	1215	262.0	9°	113.6
16.00	3	216	0.081	24.000	16.000	4295	1040	399.2	9°	151.5
20.00	3	216	0.091	30.000	20.000	3440	935	561.4	9°	189.4
25.00	3	216	0.101	37.500	25.000	2750	830	779.7	9°	236.8

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