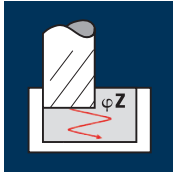
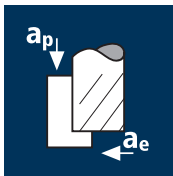




## Application



## Material

Wrought aluminium  
Construction aluminium

Cast aluminium

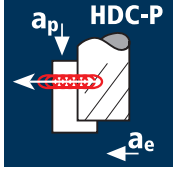
Unalloyed copper

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>c</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]	q <sub>Z</sub> [°]
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°

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°

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°

## Application



## Material

Wrought aluminium  
Construction aluminium

Cast aluminium

Unalloyed copper

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>c</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]
6.00	3	300	0.104	19.000	1.800	15915	4965	169.8
8.00	3	350	0.134	28.000	2.400	13925	5600	376.2
10.00	3	400	0.181	34.000	3.000	12730	6915	705.2
12.00	3	400	0.259	40.000	3.600	10610	8245	1187.2
16.00	3	500	0.300	48.000	4.800	9945	8950	2062.6
20.00	3	500	0.340	56.000	6.000	7960	8115	2727.3

6.00	3	270	0.104	19.000	1.800	14325	4470	152.8
8.00	3	315	0.134	28.000	2.400	12535	5040	338.6
10.00	3	360	0.181	34.000	3.000	11460	6220	634.7
12.00	3	360	0.259	40.000	3.600	9550	7420	1068.5
16.00	3	450	0.300	48.000	4.800	8950	8055	1856.4
20.00	3	450	0.340	56.000	6.000	7160	7305	2454.6

6.00	3	240	0.083	19.000	1.800	12730	3180	108.7
8.00	3	280	0.107	28.000	2.400	11140	3585	240.8
10.00	3	320	0.145	34.000	3.000	10185	4425	451.3
12.00	3	320	0.207	40.000	3.600	8490	5275	759.8
16.00	3	400	0.240	48.000	4.800	7960	5730	1320.1
20.00	3	400	0.272	56.000	6.000	6365	5195	1745.5

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