

Material

Cast iron
GG(G)

M	d ₁ [mm]	v _c [m/min]	f _z [mm]	L _K [mm]	n [min ⁻¹]	v _f [mm/min]
M4	3.30	100	0.0500	9.5	9645	482
M5	4.20	100	0.0650	11.8	7580	493
M6	5.00	100	0.0750	14.7	6365	477
M8	6.80	100	0.1000	19.7	4680	468
M10	8.50	100	0.1250	23.8	3745	468
M12	10.20	100	0.1500	27.4	3120	468
M16	14.00	100	0.2100	37.8	2275	478

Cast aluminium

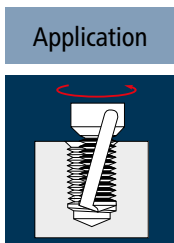
M4	3.30	250	0.0600	9.5	24115	1447
M5	4.20	250	0.0750	11.8	18945	1421
M6	5.00	250	0.0900	14.7	15915	1432
M8	6.80	250	0.1200	19.7	11705	1405
M10	8.50	250	0.1500	23.8	9360	1404
M12	10.20	250	0.1800	27.4	7800	1404
M16	14.00	250	0.2500	37.8	5685	1421

Wrought aluminium alloys
Si < 6%
hardened

M4	3.30	200	0.0600	9.5	19290	1157
M5	4.20	200	0.0750	11.8	15160	1137
M6	5.00	200	0.0900	14.7	12730	1146
M8	6.80	200	0.1200	19.7	9360	1123
M10	8.50	200	0.1500	23.8	7490	1124
M12	10.20	200	0.1800	27.4	6240	1123
M16	14.00	200	0.2500	37.8	4545	1136

Short-chipping brass
[CuZn]

M4	3.30	250	0.0600	9.5	24115	1447
M5	4.20	250	0.0750	11.8	18945	1421
M6	5.00	250	0.0900	14.7	15915	1432
M8	6.80	250	0.1200	19.7	11705	1405
M10	8.50	250	0.1500	23.8	9360	1404
M12	10.20	250	0.1800	27.4	7800	1404
M16	14.00	250	0.2500	37.8	5685	1421



Material

Cast iron
GG(G)

M	D ₁ [mm]	P [mm]	z	v _c [m/min]	f _z [mm]	n [min ⁻¹]	v _{fz} [mm/min]	v _f [mm/min]
M4	3.20	0.70	2	100	0.0200	9945	80	398
M5	4.00	0.80	2	100	0.0250	7960	80	398
M6	4.75	1.00	2	100	0.0300	6700	84	402
M8	6.35	1.25	2	100	0.0400	5015	83	401
M10	7.95	1.50	2	100	0.0550	4005	90	441
M12	9.95	1.75	2	100	0.0650	3200	71	416
M16	13.20	2.00	2	100	0.0900	2410	76	434

Cast aluminium

M4	3.20	0.70	2	250	0.0250	24870	249	1244
M5	4.00	0.80	2	250	0.0300	19895	239	1194
M6	4.75	1.00	2	250	0.0350	16755	244	1173
M8	6.35	1.25	2	250	0.0500	12530	258	1253
M10	7.95	1.50	2	250	0.0600	10010	246	1201
M12	9.95	1.75	2	250	0.0750	8000	205	1200
M16	13.20	2.00	2	250	0.1000	6030	211	1206

Wrought aluminium alloys
Si < 6%
hardened

M4	3.20	0.70	2	200	0.0250	19895	199	995
M5	4.00	0.80	2	200	0.0300	15915	191	955
M6	4.75	1.00	2	200	0.0350	13405	196	938
M8	6.35	1.25	2	200	0.0500	10025	207	1003
M10	7.95	1.50	2	200	0.0600	8010	197	961
M12	9.95	1.75	2	200	0.0750	6400	164	960
M16	13.20	2.00	2	200	0.1000	4825	169	965

Short-chipping brass
[CuZn]

M4	3.20	0.70	2	250	0.0250	24870	249	1244
M5	4.00	0.80	2	250	0.0300	19895	239	1194
M6	4.75	1.00	2	250	0.0350	16755	244	1173
M8	6.35	1.25	2	250	0.0500	12530	258	1253
M10	7.95	1.50	2	250	0.0600	10010	246	1201
M12	9.95	1.75	2	250	0.0750	8000	205	1200
M16	13.20	2.00	2	250	0.1000	6030	211	1206