

G2310-G2311

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	0.5D x D			0.5D x D			0.5D x D			0.5D x D		
	Vc (m/min)	60-80			35-55			25-35			80-100		
	D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	2	11150	0.006	190	7170	0.005	100	4780	0.004	60	14330	0.007	310
	3	7430	0.008	190	4780	0.007	100	3180	0.006	60	9550	0.011	310
	4	5570	0.011	190	3580	0.010	100	2390	0.008	60	7170	0.015	310
	5	4460	0.014	190	2870	0.012	100	1910	0.011	60	5730	0.018	310
	6	3720	0.017	190	2390	0.014	100	1590	0.013	60	4780	0.022	310
8	2790	0.023	190	1790	0.019	100	1190	0.017	60	3580	0.029	310	
10	2230	0.028	190	1430	0.024	100	960	0.021	60	2870	0.037	310	
12	1860	0.036	200	1190	0.031	110	800	0.027	60	2390	0.047	340	

< D3 mm: ap = 0.2D

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	1.5D x 0.3D			1.5D x 0.3D			1.5D x 0.3D			1.5D x 0.3D		
	Vc (m/min)	70-90			45-65			30-50			80-120		
	D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	2	12740	0.007	270	8760	0.006	160	6370	0.005	100	15920	0.009	440
	3	8490	0.011	270	5840	0.009	160	4250	0.008	100	10620	0.014	440
	4	6370	0.014	270	4380	0.012	160	3180	0.011	100	7960	0.018	440
	5	5100	0.018	270	3500	0.015	160	2550	0.013	100	6370	0.023	440
	6	4250	0.021	270	2920	0.018	160	2120	0.016	100	5310	0.027	440
8	3180	0.028	270	2190	0.024	160	1590	0.021	100	3980	0.037	440	
10	2550	0.035	270	1750	0.030	160	1270	0.026	100	3180	0.046	440	
12	2120	0.045	290	1460	0.038	170	1060	0.034	110	2650	0.059	470	

< D3 mm: ae = 0.1D

G2312

	Material Group ISO 513	P1 P2 K1			P3 P4 M1 M2 K2			P5 M3 K3			N1 N2 N3 N4		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 40 HRC					
	ap x ae	1.5D x 0.2D			1.5D x 0.2D			1.5D x 0.2D			1.5D x 0.2D		
	Vc (m/min)	55-75			40-60			20-40			70-90		
	D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	8	2590	0.020	160	1990	0.017	100	1190	0.015	50	3180	0.026	250
	10	2070	0.025	160	1590	0.021	100	960	0.019	50	2550	0.033	250
	12	1730	0.032	170	1330	0.027	110	800	0.024	60	2120	0.042	260
	14	1480	0.037	160	1140	0.031	110	680	0.028	60	1820	0.048	260
	16	1290	0.045	170	1000	0.038	110	600	0.034	60	1590	0.059	280