



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

EL612 SERIES

1 FLUTE - **SLOT**TING

Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						3.0	4.0	5.0	6.0	7.0	8.0	10.0
N	21-22	Aluminum-wrought alloy	1.0D	0.5D (~Ø3:0.2D)	Vc	188	226	220	207	220	214	220
					fz	0.055	0.053	0.054	0.055	0.055	0.053	0.054
					RPM	19947	17985	14006	10982	10004	8515	7003
					FEED	1097	953	756	604	550	451	378
	23-24	Aluminum-cast, alloyed	1.0D	0.5D (~Ø3:0.2D)	Vc	122	147	143	135	143	139	143
					fz	0.055	0.053	0.054	0.055	0.055	0.053	0.054
					RPM	12945	11698	9104	7162	6503	5531	4552
					FEED	712	620	492	394	358	293	246

