Cutting data System DA

ISO	Material	Hardness Brinell	Insert size DA31 Feed/tooth f_z	Insert size DA32 Feed/tooth f_z	Cutting speed v_c (ft/min)
P	unalloyed steel	125	0.001 - 0.012	0.002 - 0.016	850-1250
	unalloyed steel	190	0.001 - 0.012	0.002 - 0.016	790-1150
	low alloyed steel	200	0.001 - 0.012	0.002 - 0.016	660-1050
	low alloyed steel	300	0.001 - 0.012	0.001 - 0.012	460-820
	high alloyed steel	200	0.001 - 0.012	0.001 - 0.012	360-690
M	Stainless steel martenistic	240	0.001 - 0.012	0.001 - 0.012	430-660
	Stainless steel austenitic	180	0.001 - 0.006	0.001 - 0.008	360-620
K	Malleable cast iron ferritic	130	0.001 - 0.012	0.002 - 0.012	490-820
	Malleable cast iron perlitic	230	0.001 - 0.006	0.002 - 0.015	430-750
	Spheroidal graphite cast iron ferritic/perlitic	180	0.001 - 0.006	0.002 - 0.015	390-660
	Spheroidal graphite cast iron perlitic	260	0.001 - 0.006	0.002 - 0.008	330-620
	Grey cast iron	160	0.001 - 0.012	0.002 - 0.016	490-820
S	Super alloy Ni/Co based	350	0.001 - 0.004	0.001 - 0.008	100-230
	Alloy Titanium based alloy	350	0.001 - 0.004	0.001 - 0.008	100-230
N	Al-alloys	90	0.001 - 0.016	0.002 - 0.02	1640-3940

When 45° milling the feed per tooth f_z could be increased by factor 1.4!

N

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