



135303 ( 1 Flute Router)

MATERIAL GROUP		Type of cut		Size (mm)								
				2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	
<b>N</b>	71	Aluminium and Aluminium alloys		$v_c$ (m/min)	145	170	190	190	190	195	190	190
	$n$			23000	18000	15000	12000	10000	8000	6000	5000	
	$f_z$			0.065	0.094	0.12	0.15	0.18	0.244	0.333	0.44	
	$f$ (mm/min)			1500	1700	1800	1800	1800	1900	2000	2200	
<b>O</b>	81	Thermoplastics, Thermosetting plastics, Acrylics		$v_c$ (m/min)	200	235	250	235	255	250	250	255
	$n$			32000	25000	20000	15000	13500	10000	8000	6700	
	$f_z$			0.069	0.098	0.12	0.147	0.17	0.24	0.3	0.343	
	$f$ (mm/min)			2200	2400	2400	2200	2300	2400	2400	2300	

