



MATERIAL GROUP	HARDNESS HRC		Size (mm)										
			0.6	0.7	0.8	0.9	1.0	1.1	1.2	1.3	1.4	1.5	
P	13 14	30-45	v_c (m/min)	55	60	70	75	80	85	90	95	100	110
			n	30000	27000	27000	26500	25000	24500	24000	23500	23000	23000
			f_z	0.009	0.009	0.01	0.011	0.011	0.011	0.012	0.012	0.013	0.013
			f (mm/min)	510	490	560	560	560	540	570	550	590	600
H	15 16	45-55	v_c (m/min)	55	60	70	75	80	85	90	95	100	110
			n	30000	27000	27000	26500	25000	24500	24000	23500	23000	23000
			f_z	0.008	0.008	0.008	0.008	0.007	0.007	0.007	0.007	0.008	0.008
			f (mm/min)	360	330	330	320	340	340	350	320	360	370
K	31 32 33 34		v_c (m/min)	55	60	70	75	80	85	90	95	100	110
			n	30000	27000	27000	26500	25000	24500	24000	23500	23000	23000
			f_z	0.009	0.009	0.01	0.011	0.011	0.011	0.012	0.012	0.013	0.013
			f (mm/min)	510	490	560	560	560	540	570	550	590	600
<p>< HRc45</p> <p>$a_p: < \varnothing 1.0\text{mm} = 0.05 \times D$</p> <p>$a_p: \geq \varnothing 1.0\text{mm} = 0.075 \times D$</p> <p>$a_e: 0.15 \times D$</p>			<p>> HRc45</p> <p>$a_p: 0.05 \times D$</p> <p>$a_e: < \varnothing 1.0\text{mm} = 0.1 \times D$</p> <p>$a_e: \geq \varnothing 1.0\text{mm} = 0.15 \times D$</p>										