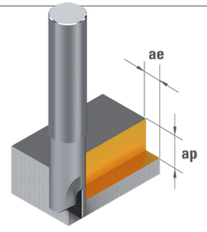
DIXI 70630 PCD

$$n\ [rpm] = \frac{Vc\ [m/min] \times 1000}{\pi \times D_1\ [mm]}$$

$$Vf\ [mm/min] = n\ [rpm] \times fz\ [mm] \times Z$$

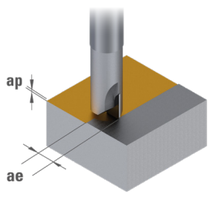
ROUTING

		VDI 3323		n tr/min	ae (mm)	ap (mm)
N	Plastic	29		**10** - 25'000	0.05 - 0.10	<1×ØD1

Feed per tooth fz [mm]

Ø D_1 3 - 6	Ø D_1 8 - 12
0.027 - 0.045	0.060 - 0.090

FACE MILLING

		VDI 3323		n tr/min	ae (mm)	ap (mm)
N	Plastic	29		**10** - 25'000	<1×ØD1	0.05 - 0.10

Feed per tooth fz [mm]

Ø D_1 3 - 6	Ø D_1 8 - 12
0.024 - 0.041	0.054 - 0.081

Values based on use of cutting oil. The cutting parameters are very strongly influenced by external parameters, such as tool and workpiece stability, etc.
The cutting conditions must be adapted to the operating conditions !