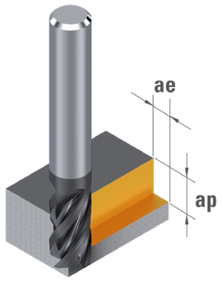
DIXI 7215

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

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

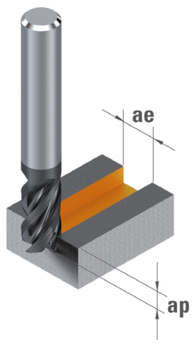
ROUTING

		VDI 3323		DIXI 7215 Vc [m/min]	DIXI 715 - FC Vc [m/min]	ae (mm)	ap (mm)
N	Wrought aluminium alloy < 12% Si	21 - 22		**475**	**620**	<0.4×ØD1	<1×L1
N	Cast aluminium alloy >12% Si	23 - 25		**200**	**260**	<1×ØD1	<1.3×ØD1
N	Copper alloy good machinability with Pb	26		**200**	**260**	<0.4×ØD1	<1×L1
N	Copper alloy with difficult machinability	27 - 28		**140**	**180**	<0.4×ØD1	<1×L1
N	Gold, silver	-		**200**	**325**	<0.4×ØD1	<1×L1

Feed per tooth fz [mm]

Ø D_1 4.00 - 6.00	Ø D_1 8.00 - 10.00	Ø D_1 12.00 - 16.00
0.058 - 0.086	0.115 - 0.140	0.170 - 0.230
0.048 - 0.072	0.095 - 0.120	0.140 - 0.190
0.048 - 0.072	0.095 - 0.120	0.140 - 0.190
0.038 - 0.058	0.075 - 0.100	0.120 - 0.150
0.038 - 0.058	0.075 - 0.100	0.120 - 0.150

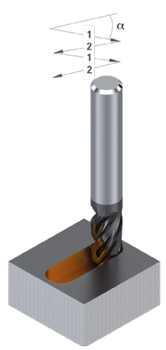
SLOTTING

		VDI 3323		DIXI 7215 Vc [m/min]	DIXI 715 - FC Vc [m/min]	ae (mm)	ap (mm)
N	Wrought aluminium alloy < 12% Si	21 - 22		**380**	**490**	1×ØD1	<1.5×ØD1
N	Cast aluminium alloy >12% Si	23 - 25		**160**	**210**	1×ØD1	<1.3×ØD1
N	Copper alloy good machinability with Pb	26		**160**	**210**	1×ØD1	<1.5×ØD1
N	Copper alloy with difficult machinability	27 - 28		**110**	**150**	1×ØD1	<1×ØD1
N	Gold, silver	-		**200**	**260**	1×ØD1	<1×ØD1

Feed per tooth fz [mm]

Ø D_1 4.00 - 6.00	Ø D_1 8.00 - 10.00	Ø D_1 12.00 - 16.00
0.044 - 0.064	0.085 - 0.110	0.130 - 0.170
0.036 - 0.054	0.070 - 0.090	0.110 - 0.140
0.036 - 0.054	0.070 - 0.090	0.110 - 0.140
0.029 - 0.044	0.055 - 0.080	0.090 - 0.110
0.029 - 0.044	0.055 - 0.080	0.090 - 0.110

RAMPING

		VDI 3323		DIXI 7215 Vc [m/min]	DIXI 715 - FC Vc [m/min]	max. depth (mm)	Ramp angle α
N	Wrought aluminium alloy < 12% Si	21 - 22		**380**	**490**	<1×ØD1	<1.5×ØD1
N	Cast aluminium alloy >12% Si	23 - 25		**160**	**210**	<1×ØD1	<1.3×ØD1
N	Copper alloy good machinability with Pb	26		**160**	**210**	<1×ØD1	<1.5×ØD1
N	Copper alloy with difficult machinability	27 - 28		**110**	**150**	<1×ØD1	<1×ØD1
N	Gold, silver	-		**200**	**260**	<1×ØD1	<1×ØD1

Feed per tooth fz [mm]

Ø D_1 4.00 - 6.00	Ø D_1 8.00 - 10.00	Ø D_1 12.00 - 16.00
0.044 - 0.064	0.085 - 0.110	0.130 - 0.170
0.036 - 0.054	0.070 - 0.090	0.110 - 0.140
0.036 - 0.054	0.070 - 0.090	0.110 - 0.140
0.029 - 0.044	0.055 - 0.080	0.090 - 0.110
0.029 - 0.044	0.055 - 0.080	0.090 - 0.110

Values based on cutting oil use. 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 !