

CHART (FLUTING)

		Feedrate V_f [mm/min]																	
		30	40	50	60	70	80	90	100	120	140	160	180	200	220	240	260	280	300
Depth of cut a_e [mm]	2.4	1.2	1.6	2.0	2.4	2.8	3.2	3.6	4.0	4.8	5.6	6.4	7.2	8.0	8.8	9.6	10.4	11.2	12.0
	2.6	1.3	1.7	2.2	2.6	3.0	3.5	3.9	4.3	5.2	6.1	6.9	7.8	8.7	9.5	10.4	11.3	12.1	13.0
	2.8	1.4	1.9	2.3	2.8	3.3	3.7	4.2	4.7	5.6	6.5	7.5	8.4	9.3	10.3	11.2	12.1	13.1	14.0
	3.0	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	6.0	7.0	8.0	9.0	10.0	11.0	12.0	13.0	14.0	15.0
	3.2	1.6	2.1	2.7	3.2	3.7	4.3	4.8	5.3	6.4	7.5	8.5	9.6	10.7	11.7	12.8	13.9	14.9	16.0
	3.4	1.7	2.3	2.8	3.4	4.0	4.5	5.1	5.7	6.8	7.9	9.1	10.2	11.3	12.5	13.6	14.7	15.9	17.0
	3.6	1.8	2.4	3.0	3.6	4.2	4.8	5.4	6.0	7.2	8.4	9.6	10.8	12.0	13.2	14.4	15.6	16.8	18.0
	3.8	1.9	2.5	3.2	3.8	4.4	5.1	5.7	6.3	7.6	8.9	10.1	11.4	12.7	13.9	15.2	16.5	17.7	19.0
	4.0	2.0	2.7	3.3	4.0	4.7	5.3	6.0	6.7	8.0	9.3	10.7	12.0	13.3	14.7	16.0	17.3	18.7	20.0
	4.2	2.1	2.8	3.5	4.2	4.9	5.6	6.3	7.0	8.4	9.8	11.2	12.6	14.0	15.4	16.8	18.2	19.6	21.0
	4.4	2.2	2.9	3.7	4.4	5.1	5.9	6.6	7.3	8.8	10.3	11.7	13.2	14.7	16.1	17.6	19.1	20.5	22.0
	4.6	2.3	3.1	3.8	4.6	5.4	6.1	6.9	7.7	9.2	10.7	12.3	13.8	15.3	16.9	18.4	19.9	21.5	23.0
	4.8	2.4	3.2	4.0	4.8	5.6	6.4	7.2	8.0	9.6	11.2	12.8	14.4	16.0	17.6	19.2	20.8	22.4	24.0
	5.0	2.5	3.3	4.2	5.0	5.8	6.7	7.5	8.3	10.0	11.7	13.3	15.0	16.7	18.3	20.0	21.7	23.3	25.0
	5.2	2.6	3.5	4.3	5.2	6.1	6.9	7.8	8.7	10.4	12.1	13.9	15.6	17.3	19.1	20.8	22.5	24.3	26.0
	5.4	2.7	3.6	4.5	5.4	6.3	7.2	8.1	9.0	10.8	12.6	14.4	16.2	18.0	19.8	21.6	23.4	25.2	27.0
	5.6	2.8	3.7	4.7	5.6	6.5	7.5	8.4	9.3	11.2	13.1	14.9	16.8	18.7	20.5	22.4	24.3	26.1	28.0
5.8	2.9	3.9	4.8	5.8	6.8	7.7	8.7	9.7	11.6	13.5	15.5	17.4	19.3	21.3	23.2	25.1	27.1	29.0	
6.0	3.0	4.0	5.0	6.0	7.0	8.0	9.0	10.0	12.0	14.0	16.0	18.0	20.0	22.0	24.0	26.0	28.0	30.0	
6.5	3.3	4.3	5.4	6.5	7.6	8.7	9.8	10.8	13.0	15.2	17.3	19.5	21.7	23.8	26.0	28.2	30.3	32.5	

Stock removal by time measure Q_w [mm³/mm•s]

V_f = Feedrate

a_e = Depth of cut

Q_w = Stock removal
by time measure

$$V_f = \frac{Q_w \cdot 60}{a_e}$$

$$Q_w = \frac{a_e \cdot V_f}{60}$$



ACTION SUPER ABRASIVE SA