
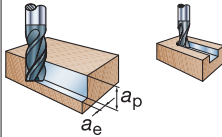
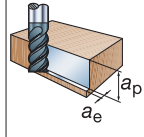
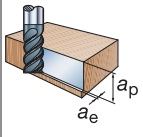
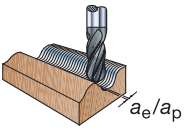

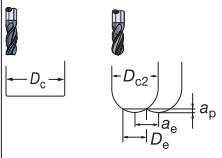
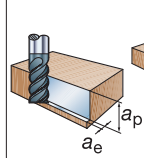
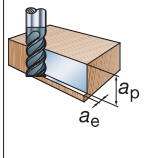
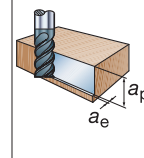
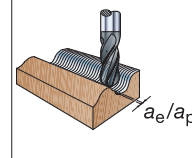


CoroMill® Plura cutting data

Speed recommendations

 GC1620 GC1630 H10F						
			$a_p \times a_e > D_c$	$a_p \times a_e < D_c$	$a_e \leq 0.05 \times D_c$	$a_e \leq 0.05 \times D_c$ or D_{c2} $a_p \leq 0.05 \times D_c$ or D_{c2}
ISO	CMC	HB	v_c m/min	v_c m/min	v_c m/min	v_c m/min
P	01.1	125	155	200	375	690
	01.2	150	135	185	340	630
	01.4	200	120	140	255	470
	02.2	250	100	130	245	450
	02.2	300	90	120	220	410
	03.22	400	75	95	180	335
03.22	450	65	85	160	300	
M	05.11	200	60	90	165	300
	05.21	200	60	75	145	270
	05.51	230	45	55	110	200

Feed recommendations

 GC1620 GC1630 H10F						
		D_c or D_{c2} mm	f_z mm/tooth	f_z mm/tooth	f_z mm/tooth	f_z mm/tooth
Metric		0.5	Plura Guide			
$n = \frac{1000 \times v_c}{\pi \times D_c}$ rpm	mm/min	1	0.002	0.002	0.013	0.023
		2	0.004	0.003	0.032	0.056
$v_f = n \times f_z \times z_n$	mm	3	0.006	0.007	0.039	0.07
		3.175	0.006	0.008	0.040	0.072
$D_e = 2 \times \sqrt{a_p \times (D_{c2} - a_p)}$	mm	4	0.008	0.014	0.045	0.08
		4.76	0.010	0.019	0.046	0.078
Note: In the formula for n the parameters v_c and D_c can be replaced with v_e and D_{c2} .	mm	5	0.011	0.021	0.046	0.078
		6	0.014	0.03	0.055	0.099
	mm	6.35	0.015	0.031	0.056	0.102
		8	0.020	0.033	0.063	0.114
	mm	9.525	0.025	0.050	0.069	0.124
		10	0.027	0.055	0.071	0.127
	mm	12	0.036	0.071	0.077	0.139

Plura Guide



First choice: Use Plura Guide. Order number C-2948-063