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	Material	Strength (N/mm²)	Dimension	Ø0.5x10	Ø0.610	Ø0.8x10	Ø0.8x12	Ø1x15	Ø1x30	Ø1.2x15	Ø1.5x15	Ø1.5x30	Ø1.8x15
			Infeed in mm	ae= 0.01xD ap= 0.01xD	ae= 0.015xD ap= 0.015xD	ae= 0.035xD ap= 0.035xD	ae= 0.02xD ap= 0.02xD	ae= 0.02xD ap= 0.02xD	ae= 0.01xD ap= 0.01xD	ae= 0.035xD ap= 0.035xD	ae= 0.05xD ap= 0.05xD	ae= 0.01xD ap= 0.01xD	ae= 0.07xD ap= 0.07xD
			Application										
N			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz
			Vc (m/min)										
1.1	Aluminium, alloyed	<500	500	0.012	0.017	0.017	0.017	0.028	0.017	0.028	0.03	0.025	0.035
1.2	Aluminium, alloyed	<600	480	0.012	0.017	0.017	0.017	0.028	0.017	0.028	0.03	0.025	0.035
2.1-2.3	Aluminium, casted	<600	450	0.011	0.016	0.016	0.016	0.026	0.016	0.026	0.027	0.022	0.032
3.1-3.3	Cooper, alloyed	<650	220	0.01	0.015	0.015	0.015	0.024	0.015	0.024	0.024	0.019	0.029
4.1	Magnesium, alloyed	<250	500	0.012	0.017	0.017	0.017	0.028	0.017	0.028	0.03	0.025	0.035
5.1	Thermoplastic	<100	400	0.011	0.016	0.016	0.016	0.026	0.016	0.026	0.027	0.022	0.032
5.2	Duroplastic	<150	350	0.01	0.015	0.015	0.015	0.024	0.015	0.024	0.024	0.019	0.029

	Material	Strength (N/mm²)	Dimension	Ø1.8x20	Ø2x12	Ø2x40	Ø2.5x15	Ø2.5x30	Ø3x15	Ø3x45
			Infeed in mm	ae= 0.05xD ap= 0.05xD	ae= 0.09xD ap= 0.09xD	ae= 0.01xD ap= 0.01xD	ae= 0.09xD ap= 0.09xD	ae= 0.035xD ap= 0.035xD	ae= 0.09xD ap= 0.09xD	ae= 0.02xD ap= 0.02xD
			Application							
			Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz
N			Vc (m/min)							
1.1	Aluminium, alloyed	<500	500	0.03	0.035	0.025	0.035	0.03	0.04	0.03
1.2	Aluminium, alloyed	<600	480	0.03	0.035	0.025	0.035	0.03	0.04	0.03
2.1-2.3	Aluminium, casted	<600	450	0.027	0.032	0.022	0.032	0.027	0.035	0.025
3.1-3.3	Cooper, alloyed	<650	220	0.024	0.029	0.019	0.029	0.024	0.03	0.02
4.1	Magnesium, alloyed	<250	500	0.03	0.035	0.025	0.035	0.03	0.04	0.03
5.1	Thermoplastic	<100	400	0.027	0.032	0.022	0.032	0.027	0.035	0.025
5.2	Duroplastic	<150	350	0.024	0.029	0.019	0.029	0.024	0.03	0.02