



Material Group	vc (m/min)	fn (mm/rev)					
		ø4.3 -6.3	ø7.0 -10.0	ø10.4 -15.0	ø16.5 -23.0	ø25.0 -31.0	
<b>P</b>	11	28	0.08	0.10	0.15	0.18	0.23
	12	(25-30)	(0.06-0.10)	(0.08-0.12)	(0.13-0.17)	(0.16-0.20)	(0.22-0.25)
	13	18	0.06	0.08	0.12	0.15	0.18
	14	(15-20)	(0.04-0.08)	(0.06-0.10)	(0.10-0.14)	(0.13-0.17)	(0.16-0.20)
<b>H</b>	15	8	0.05	0.06	0.10	0.12	0.14
	16	(5-10)	(0.04-0.06)	(0.04-0.08)	(0.08-0.12)	(0.10-0.14)	(0.12-0.16)
<b>M</b>	21	7	0.05	0.06	0.10	0.12	0.14
	22	(6-8)	(0.04-0.06)	(0.04-0.08)	(0.08-0.12)	(0.10-0.14)	(0.12-0.16)
	23						
<b>K</b>	31	20	0.08	0.10	0.15	0.18	0.23
	32	(15-25)	(0.06-0.10)	(0.08-0.12)	(0.13-0.17)	(0.16-0.20)	(0.22-0.25)
	33	10	0.06	0.08	0.12	0.15	0.18
	34	(8-12)	(0.04-0.08)	(0.06-0.10)	(0.10-0.14)	(0.13-0.17)	(0.16-0.20)
<b>S</b>	41	11	0.08	0.10	0.15	0.18	0.23
	42	(10-12)	(0.06-0.10)	(0.08-0.12)	(0.13-0.17)	(0.16-0.20)	(0.22-0.25)
	51	10	0.06	0.08	0.12	0.15	0.18
	52	(8-12)	(0.04-0.08)	(0.06-0.10)	(0.10-0.14)	(0.13-0.17)	(0.16-0.20)
<b>N</b>	61	23	0.05	0.06	0.10	0.12	0.14
	62	(20-25)	(0.04-0.06)	(0.04-0.08)	(0.08-0.12)	(0.10-0.14)	(0.12-0.16)
	63						
	71	28	0.10	0.12	0.16	0.20	0.22
	72	(25-30)	(0.08-0.12)	(0.10-0.14)	(0.14-0.18)	(0.18-0.22)	(0.20-0.24)
	73	20	0.08	0.10	0.15	0.18	0.23
		(18-22)	(0.06-0.10)	(0.08-0.12)	(0.13-0.17)	(0.16-0.20)	(0.22-0.25)
<b>O</b>	81	25	0.05	0.06	0.10	0.12	0.14
	82	(20-30)	(0.04-0.06)	(0.04-0.08)	(0.08-0.12)	(0.10-0.14)	(0.12-0.16)