

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						3.0	4.0	5.0	6.0	8.0	10.0	12.0
N	29.3	CFRP	0.35D	2.0D	Vc	200	200	200	200	200	200	200
					fz	-	-	-	-	-	-	-
					RPM	21221	15915	12732	10610	7958	6366	5305
					FEED	1270	1430	1910	2225	2623	3053	3393
		GFRP	0.35D	2.0D	Vc	100	100	100	100	100	100	100
					fz	-	-	-	-	-	-	-
					RPM	10610	7958	6366	5305	3979	3183	2653
					FEED	635	715	955	1113	1311	1526	1697

$V_c = \text{m/min.}$   
 $f_z = \text{mm/tooth}$   
 $\text{RPM} = \text{rev./min.}$   
 $\text{FEED} = \text{mm/min.}$

