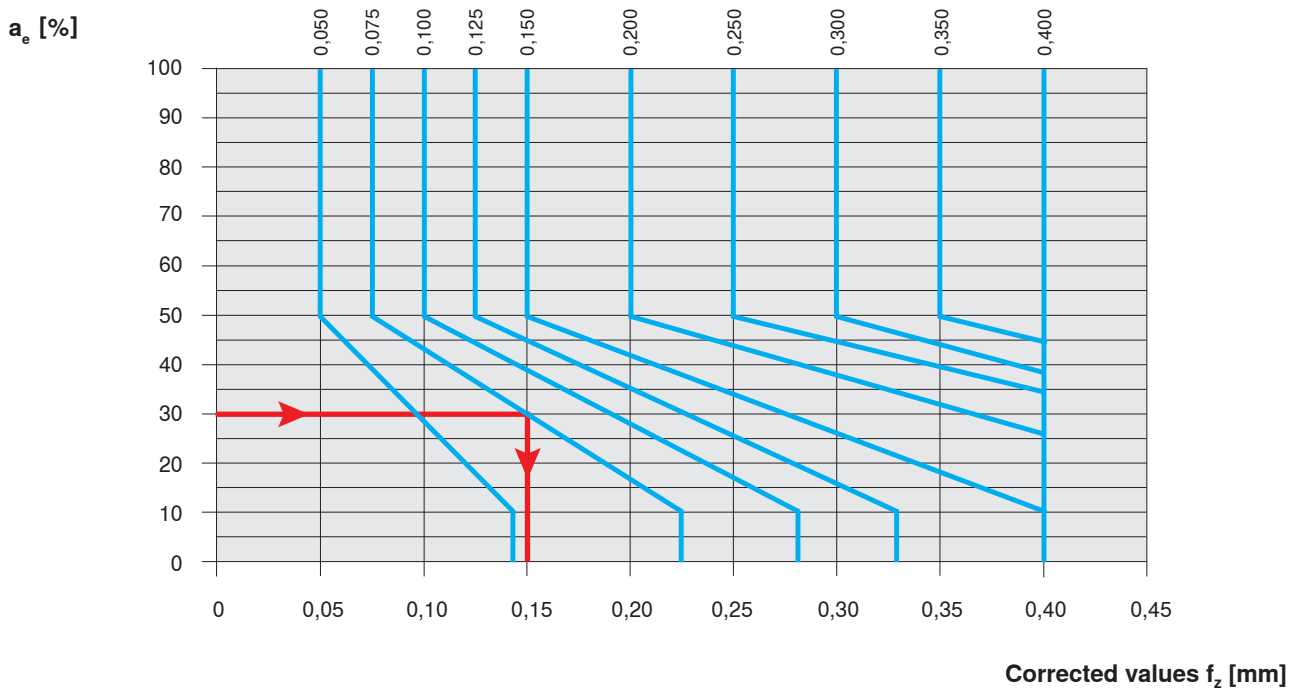


Starting values  $f_z$  [mm] from starting parameter diagram



These parameters apply for cutting width ( $a_e$ ) below 50%

**Example:**

Starting value [ $f_z$ ] = 0.075 mm

$a_e$  = 30%

Corrected value [ $f_z$ ] = 0.15 mm