

MCA212R			
MATERIAL GROUPS		15 16	
HRC			
N/mm ²			
Vc [m/min]		130~380	
Ø mm.	n	Vf	
3	13000	900	
4	13000	1200	
5	13000	1300	
6	13000	1500	
8	10000	1800	
10	10000	2200	
12	10000	2700	
S ap x ae		0.5DxD	
SM ap x ae		Dx0.5*D	

*≤Ø10 ae=0.25D

↓ Z axis : Vf = -50%

MDCSA3 - MDA310* - MDA311** - MDA312**			
MATERIAL GROUPS		15 16	
HRC			
N/mm ²			
Vc [m/min]		150~250	
Ø mm.	n	Vf	
3	21200	950	
4	16000	960	
5	12800	960	
6	10600	960	
8	8000	960	
10	6400	1150	
12	5300	1200	
16	4000	1200	
20	3200	1200	
S ap x ae		0.5DxD	
SM ap x ae		1.5Dx0.2D	

*MDA310 n & Vf = -30%; ae = 0.1D

**MDA311, MDA312 n & Vf = -50%; ap = 0.1D

↓ Z axis : Vf = -50%

