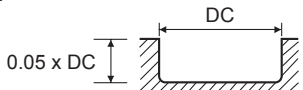
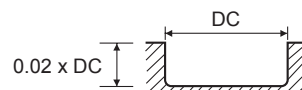


CUTTING DATA

100350 (2 Flute Miniature)													
VDI MATERIAL GROUP		MATERIAL	HRc		Size (mm)								
					0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.5	2.0
P	10-11	High alloy Steel, Tool Steel	35-45	v _c (m/min)	40	55	70	85	100	120	130	145	165
				n	42460	43790	44585	45115	39805	38215	34500	30785	26270
				f _z	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013
				f (mm/min)	170	175	265	360	475	610	620	675	680
H	38	Hardened Steel	40-50	v _c (m/min)	40	55	70	85	100	120	130	145	165
				n	42460	43790	44585	45115	39805	38215	34500	30785	26270
				f _z	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013
				f (mm/min)	170	175	265	360	475	610	620	675	680
		Hardened Steel	50-55	v _c (m/min)	40	50	65	75	75	80	85	100	110
				n	42460	39805	41400	39805	29855	25475	22555	21230	17515
				f _z	0.001	0.002	0.003	0.004	0.005	0.007	0.008	0.01	0.012
				f (mm/min)	85	155	245	315	295	355	360	425	420
		Hardened Steel	55-65	v _c (m/min)	30	40	50	55	65	65	75	80	90
				n	31845	31845	31845	29190	25875	20700	19900	16985	14330
				f _z	0.001	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.009
				f (mm/min)	60	60	125	175	205	205	235	235	255
	39	Hardened Steel	65-70	v _c (m/min)	25	30	40	45	50	50	55	60	70
				n	26535	23885	25475	23885	19900	15920	14595	12735	11145
				f _z	0.001	0.001	0.002	0.002	0.003	0.004	0.005	0.006	0.007
				f (mm/min)	50	45	100	95	115	125	145	150	155
		Chilled Cast Iron		v _c (m/min)	45	65	80	95	125	150	160	175	210
				n	47770	51750	50955	50425	49760	47770	42460	37155	33435
				f _z	0.002	0.002	0.004	0.005	0.006	0.008	0.009	0.011	0.013
				f (mm/min)	190	205	405	500	595	760	760	815	865
	40	Hardened Cast Iron		v _c (m/min)	40	55	70	85	100	120	130	145	165
				n	42460	43790	44585	45115	39805	38215	34500	30785	26270
				f _z	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013
				f (mm/min)	170	175	265	360	475	610	620	675	680
	41	Hardened Cast Iron		v _c (m/min)	40	55	70	85	100	120	130	145	165
				n	42460	43790	44585	45115	39805	38215	34500	30785	26270
				f _z	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013
				f (mm/min)	170	175	265	360	475	610	620	675	680
MATERIAL GROUP P, H38, H40-41					MATERIAL GROUP H39								
													

Recommended cutting depths are **maximum** depths, and **speeds and feeds are a starting point** based on these depths.
 All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.
For long series and long necked tools it may be necessary to reduce feed rate by up to 50%.

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed per tooth (mm)
 f - feed rate (mm/min)
 a_p - axial depth of cut
 a_e - radial depth of cut