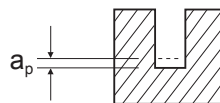


CUTTING DATA

100450 (2 Flute Rib Processing)											
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)							
				0.1 LU=0.3	0.2 LU=1.0	0.3 LU=2.0	0.4 LU=3.0	0.5 LU=4.0	0.6 LU=4.0	0.8 LU=6.0	
P	10-11	High alloy Steel, Tool Steel	35-45	a_p (mm)	0.006	0.01	0.01	0.016	0.018	0.021	0.024
				v_c (m/min)	15	31	44	45	46	52	54
				n	47770	49360	46700	35800	29200	27600	21490
				f_z	0.0025	0.0035	0.004	0.006	0.007	0.008	0.011
				f (mm/min)	240	345	375	430	410	440	470
H	38	Hardened Steel	45-55	a_p (mm)	0.007	0.007	0.009	0.011	0.013	0.014	0.017
				v_c (m/min)	15	31	41	41	39	40	40
				n	47770	49360	43520	32640	24840	21230	15920
				f_z	0.002	0.003	0.003	0.005	0.006	0.007	0.009
				f (mm/min)	190	295	260	320	295	295	285
	39	Hardened Steel	55-70	a_p (mm)	0.005	0.005	0.007	0.008	0.008	0.009	0.01
				v_c (m/min)	15	31	26	27	25	26	27
				n	47770	49360	27600	21490	15920	13800	10740
				f_z	0.001	0.002	0.003	0.004	0.005	0.006	0.007
				f (mm/min)	95	195	165	170	160	165	150
	40	Chilled Cast Iron		a_p (mm)	0.006	0.01	0.01	0.016	0.018	0.021	0.024
				v_c (m/min)	15	31	44	45	46	52	54
				n	47770	49360	46700	35800	29200	27600	21490
				f_z	0.0025	0.0035	0.004	0.006	0.007	0.008	0.011
				f (mm/min)	240	345	375	430	410	440	470
	41	Hardened Cast Iron		a_p (mm)	0.007	0.007	0.009	0.011	0.013	0.014	0.017
				v_c (m/min)	15	31	41	41	39	40	40
				n	47770	49360	43520	32640	24840	21230	15920
				f_z	0.002	0.003	0.003	0.005	0.006	0.007	0.009
				f (mm/min)	190	295	260	320	295	295	285



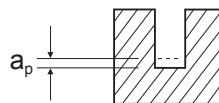
► The data given is based on LU length shown. Please adjust machining conditions according to length.

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

CUTTING DATA

100450 (2 Flute Rib Processing)										
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)						
				1.0 LU=10.0	1.2 LU=10.0	1.5 LU=12.0	2.0 LU=14.0	3.0 LU=18.0	4.0 LU=30.0	
P	10-11	High alloy Steel, Tool Steel	35-45	a_p (mm)	0.02	0.047	0.047	0.08	0.13	0.17
				v_c (m/min)	49	52	53	53	53	54
				n	15600	13800	11250	8435	5620	4295
				f_z	0.014	0.017	0.024	0.027	0.063	0.064
				f (mm/min)	435	465	540	455	705	550
H	38	Hardened Steel	45-55	a_p (mm)	0.014	0.028	0.033	0.057	0.095	0.12
				v_c (m/min)	34	35	36	40	41	41
				n	10800	9280	7640	6365	4350	3260
				f_z	0.012	0.014	0.018	0.022	0.056	0.056
				f (mm/min)	260	260	275	280	485	365
	39	Hardened Steel	55-70	a_p (mm)	0.008	0.017	0.02	0.034	0.057	0.076
				v_c (m/min)	22	23	23	26	26	26
				n	7000	6100	4880	4140	2760	2070
				f_z	0.007	0.008	0.011	0.013	0.035	0.035
				f (mm/min)	95	95	105	105	190	145
	40	Chilled Cast Iron		a_p (mm)	0.02	0.047	0.047	0.08	0.13	0.17
				v_c (m/min)	49	52	53	53	53	54
				n	15600	13800	11250	8435	5620	4295
				f_z	0.014	0.017	0.024	0.027	0.063	0.064
				f (mm/min)	435	465	540	455	705	550
	41	Hardened Cast Iron		a_p (mm)	0.014	0.028	0.033	0.057	0.095	0.12
				v_c (m/min)	34	35	36	40	41	41
				n	10800	9280	7640	6365	4350	3260
				f_z	0.012	0.014	0.018	0.022	0.056	0.056
				f (mm/min)	260	260	275	280	485	365



► The data given is based on LU length shown. Please adjust machining conditions according to length.

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