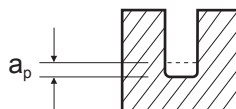


CUTTING DATA

101850, 102350 (2 Flute Crn Rad Rib Processing)											
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)							
				0.5 LU=1.5	0.6 LU=2.0	0.8 LU=2.5	1.0 LU=6.0	1.2 LU=4.4	1.5 LU=8.0	2.0 LU=12.0	
P	10-11	High alloy Steel, Tool Steel	35-45	a_p (mm)	0.0203	0.0179	0.0238	0.0193	0.0473	0.0609	0.0805
				v_c (m/min)	46	52	53	49	52	63	53
				n	29295	27600	21095	15605	13800	13375	8435
				f_z	0.028	0.032	0.045	0.057	0.067	0.094	0.107
				f (mm/min)	7555	1765	1895	1775	1845	2515	1805
H	38	Hardened Steel	45-55	a_p (mm)	0.013	0.0145	0.0143	0.0138	0.0285	0.0332	0.0575
				v_c (m/min)	39	40	40	35	36	36	40
				n	24840	21230	15920	11145	9550	7640	6365
				f_z	0.024	0.026	0.037	0.048	0.055	0.07	0.089
				f (mm/min)	1190	1100	1175	1070	1050	1070	1130
	39	Hardened Steel	55-70	a_p (mm)	0.0077	0.0087	0.0083	0.0102	0.0171	0.0199	0.0345
				v_c (m/min)	25	26	26	22	23	23	26
				n	15920	13800	10350	7005	6100	4880	4140
				f_z	0.015	0.016	0.022	0.03	0.035	0.044	0.053
				f (mm/min)	475	440	455	420	425	430	435
	40	Chilled Cast Iron		a_p (mm)	0.0203	0.0179	0.0238	0.0193	0.0473	0.0609	0.0805
				v_c (m/min)	46	52	53	49	52	63	53
				n	29295	27600	21095	15605	13800	13375	8435
				f_z	0.028	0.032	0.045	0.057	0.067	0.094	0.107
				f (mm/min)	7555	1765	1895	1775	1845	2515	1805
	41	Hardened Cast Iron		a_p (mm)	0.013	0.0145	0.0143	0.0138	0.0285	0.0332	0.0575
				v_c (m/min)	39	40	40	35	36	36	40
				n	24840	21230	15920	11145	9550	7640	6365
				f_z	0.024	0.026	0.037	0.048	0.055	0.07	0.089
				f (mm/min)	1190	1100	1175	1070	1050	1070	1130



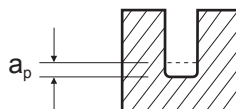
► The data given is based on LU length shown. Please adjust machining conditions according to length.

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

101850, 102350 (2 Flute Crn Rad Rib Processing)										
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)						
				3.0 LU=8.0	4.0 LU=16.0	6.0 LU=20.0	8.0 LU=25.0	10.0 LU=32.0	12.0 LU=38.0	
P	10-11	High alloy Steel, Tool Steel	35-45	a_p (mm)	0.08	0.09	0.1	0.1	0.14	0.18
				v_c (m/min)	65	70	85	100	109	120
				n	6900	5570	4510	3980	3470	3200
				f_z	0.114	0.12	0.16	0.19	0.22	0.26
				f (mm/min)	1570	1335	1440	1510	1530	1650
H	38	Hardened Steel	45-55	a_p (mm)	0.05	0.06	0.07	0.07	0.08	0.08
				v_c (m/min)	45	50	65	80	90	100
				n	4775	3980	3450	3185	2865	2650
				f_z	0.08	0.09	0.12	0.14	0.16	0.19
				f (mm/min)	760	715	825	890	915	1000
	39	Hardened Steel	55-70	a_p (mm)	0.03	0.04	0.05	0.05	0.06	0.06
				v_c (m/min)	30	35	45	60	65	75
				n	3185	2785	2385	2385	2070	1990
				f_z	0.06	0.07	0.09	0.12	0.14	0.16
				f (mm/min)	380	390	430	570	580	635
	40	Chilled Cast Iron		a_p (mm)	0.08	0.09	0.1	0.1	0.14	0.18
				v_c (m/min)	65	70	85	100	109	120
				n	6900	5570	4510	3980	3470	3200
				f_z	0.114	0.12	0.16	0.19	0.22	0.26
				f (mm/min)	1570	1335	1440	1510	1530	1650
	41	Hardened Cast Iron		a_p (mm)	0.05	0.06	0.07	0.07	0.08	0.08
				v_c (m/min)	45	50	65	80	90	100
				n	4775	3980	3450	3185	2865	2650
				f_z	0.08	0.09	0.12	0.14	0.16	0.19
				f (mm/min)	760	715	825	890	915	1000



► 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