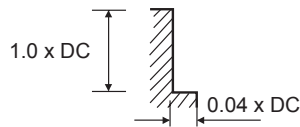


## CUTTING DATA

102950 (6 Flute 45° Long Length)													
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)									
				6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	
<b>P</b>	10-11	High alloy Steel, Tool Steel	35-45	$v_c$ (m/min)	95	95	95	95	95	95	95	95	100
				$n$	5040	3780	3025	2520	2160	1890	1680	1510	1270
				$f_z$	0.035	0.046	0.055	0.062	0.07	0.079	0.08	0.091	0.096
				$f$ (mm/min)	1055	1040	995	935	905	895	1075	1100	975
<b>H</b>	38	Hardened Steel	40-55	$v_c$ (m/min)	95	95	95	95	95	95	95	95	100
				$n$	5040	3780	3025	2520	2160	1890	1680	1510	1270
				$f_z$	0.035	0.046	0.055	0.062	0.07	0.079	0.08	0.091	0.096
				$f$ (mm/min)	1055	1040	995	935	905	895	1075	1100	975
	39	Hardened Steel	55-65	$v_c$ (m/min)	70	70	70	70	70	70	70	70	75
				$n$	3715	2785	2225	1855	1590	1390	1235	1115	955
				$f_z$	0.031	0.042	0.05	0.056	0.066	0.072	0.073	0.079	0.087
				$f$ (mm/min)	690	700	665	620	630	600	720	700	665
	40	Hardened Steel	65-70	$v_c$ (m/min)	50	50	50	50	50	50	50	50	55
				$n$	2650	1990	1590	1325	1135	995	885	795	700
				$f_z$	0.028	0.037	0.045	0.05	0.051	0.064	0.066	0.071	0.079
				$f$ (mm/min)	445	440	430	395	345	380	465	450	440
	41	Chilled Cast Iron		$v_c$ (m/min)	120	120	120	120	120	120	120	120	125
				$n$	6365	4775	3820	3185	2730	2385	2120	1910	1590
				$f_z$	0.039	0.052	0.063	0.07	0.081	0.09	0.095	0.099	0.11
				$f$ (mm/min)	1490	1490	1440	1335	1325	1290	1610	1510	1400
	41	Hardened Cast Iron		$v_c$ (m/min)	95	95	95	95	95	95	95	95	100
				$n$	5040	3780	3025	2520	2160	1890	1680	1510	1270
				$f_z$	0.035	0.046	0.055	0.062	0.07	0.079	0.08	0.091	0.096
				$f$ (mm/min)	1055	1040	995	935	905	895	1075	1100	975



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