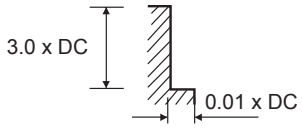
CUTTING DATA

103950 (6 Flute 45° Extra Length)

VDI MATERIAL GROUP		MATERIAL	HRc		Size (mm)						
					6.0	**8.0**	**10.0**	**12.0**	**16.0**	**20.0**	**25.0**
P	10-11	High alloy Steel, Tool Steel	**35-45**	v_c (m/min)	60	60	60	60	60	60	60
				n	3185	2385	1910	1590	1190	955	760
				f_z	0.03	0.04	0.05	0.061	0.071	0.08	0.08
				f (mm/min)	570	570	570	580	505	610	485
H	38	Hardened Steel	**40-55**	v_c (m/min)	60	60	60	60	60	60	60
				n	3185	2385	1910	1590	1190	955	760
				f_z	0.03	0.04	0.05	0.061	0.071	0.08	0.08
				f (mm/min)	570	570	570	580	505	610	485
	39	Hardened Steel	**55-70**	v_c (m/min)	50	50	50	50	50	50	50
				n	2650	1990	1590	1325	995	795	635
				f_z	0.03	0.04	0.05	0.06	0.07	0.08	0.08
				f (mm/min)	475	475	475	475	415	510	405
	40	Chilled Cast Iron		v_c (m/min)	60	60	60	60	60	60	60
				n	3185	2385	1910	1590	1190	955	760
				f_z	0.04	0.05	0.06	0.07	0.081	0.086	0.089
				f (mm/min)	760	715	685	665	580	655	540
	41	Hardened Cast Iron		v_c (m/min)	60	60	60	60	60	60	60
				n	3185	2385	1910	1590	1190	955	760
				f_z	0.03	0.04	0.05	0.061	0.071	0.08	0.08
				f (mm/min)	570	570	570	580	505	610	485



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