

CUTTING DATA

106365 (6 Flute 45° Helix)										
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)						
				6.0	8.0	10.0	12.0	16.0	20.0	
P	1-5	Non-alloy Steel	<25	v_c (m/min)	110	111	111	112	111	111
				n	5800	4400	3500	2970	2200	1760
				f_z	0.03	0.079	0.099	0.099	0.1	0.1
				f (mm/min)	2100	2100	2100	1765	1325	1060
	6-9	Low alloy Steel	25-35	v_c (m/min)	77	78	76	79	78	77
				n	4080	3100	2400	2100	1550	1220
				f_z	0.059	0.078	0.099	0.097	0.099	0.099
				f (mm/min)	1440	1450	1430	1220	920	730
	10-11	High alloy Steel, Tool Steel	35-45	v_c (m/min)	77	78	76	79	78	77
				n	4080	3100	2400	2100	1550	1220
				f_z	0.059	0.078	0.099	0.097	0.099	0.099
				f (mm/min)	1440	1450	1430	1220	920	730
K	15-20	Cast Iron	v_c (m/min)	110	111	111	112	111	111	
			n	5800	4400	3500	2970	2200	1760	
			f_z	0.03	0.079	0.099	0.099	0.1	0.1	
			f (mm/min)	2100	2100	2100	1765	1325	1060	
H	38	Hardened Steel	45-55	v_c (m/min)	31	31	33	33	34	33
				n	1640	1230	1050	875	675	525
				f_z	0.022	0.03	0.035	0.036	0.034	0.037
				f (mm/min)	215	220	220	190	135	115
	40	Chilled Cast Iron	v_c (m/min)	77	78	76	79	78	77	
			n	4080	3100	2400	2100	1550	1220	
			f_z	0.059	0.078	0.099	0.097	0.099	0.099	
			f (mm/min)	1440	1450	1430	1220	920	730	
	41	Hardened Cast Iron	v_c (m/min)	31	31	33	33	34	33	
			n	1640	1230	1050	875	675	525	
			f_z	0.022	0.03	0.035	0.036	0.034	0.037	
			f (mm/min)	215	220	220	190	135	115	

<p>MATERIAL GROUP P1-5, K</p>	<p>MATERIAL GROUP P6-11, H40</p>	<p>MATERIAL GROUP H38, H41</p>
-------------------------------	----------------------------------	--------------------------------

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