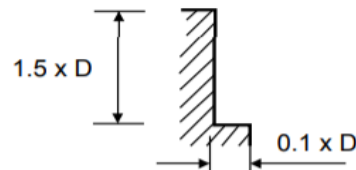


HSS-E 4 & 6 FLUTE COATED (107121, 108121)



MATERIAL GROUP	HRc		SIZE (MM)													
			2	3	4	5	6	8	10	12	14	16	18	20	22	25
P	≤20	Vc (M/MIN)	30	30	30	30	30	30	30	30	30	30	30	30	30	30
		n	4500	3200	2200	1800	1600	1100	900	800	700	560	500	450	450	400
		Fz	0.003	0.006	0.011	0.017	0.023	0.036	0.044	0.056	0.057	0.071	0.08	0.089	0.059	0.06
		F(MM/MIN)	55	80	100	125	145	160	160	180	160	160	160	160	160	145
	20 - 30	Vc (M/MIN)	25	25	25	25	25	25	25	25	25	25	25	25	25	25
		n	4000	2500	1800	1600	1200	900	800	630	560	450	400	400	350	310
		Fz	0.003	0.006	0.009	0.014	0.019	0.029	0.038	0.048	0.054	0.058	0.066	0.066	0.05	0.048
		F(MM/MIN)	45	60	65	90	90	105	120	120	120	105	105	105	105	90
	30 - 40	Vc (M/MIN)	15	15	15	15	15	15	15	15	15	15	15	15	15	15
		n	2200	1600	1100	900	800	560	450	400	350	280	250	220	220	180
		Fz	0.002	0.005	0.01	0.014	0.019	0.029	0.036	0.047	0.054	0.058	0.065	0.074	0.049	0.046
		F(MM/MIN)	20	30	45	50	60	65	65	75	75	65	65	65	65	50
N	Vc (M/MIN)	75	105	100	100	105	100	95	95	95	100	100	100	95	95	
	n	12000	11000	8000	6300	5600	4000	3100	2500	2200	2000	1800	1600	1400	1200	
	Fz	0.005	0.009	0.014	0.019	0.021	0.036	0.048	0.057	0.06	0.066	0.074	0.075	0.054	0.058	
	F(MM/MIN)	240	380	440	470	470	580	600	570	530	100	100	100	95	95	

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
HRc	Hardness of metal



All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

To calculate RPM from cutting speed:
$$n = \frac{v_c \cdot 1000}{\pi \cdot \phi}$$

To calculate cutting speed from RPM:
$$v_c = \frac{n \cdot \pi \cdot \phi}{1000}$$