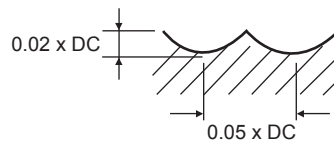


CUTTING DATA

107350 (3 Flute B/N centre match)													
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)									
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	10-11	High alloy Steel, Tool Steel	35-45	v_c (m/min)	300	305	315	340	340	340	340	340	340
				n	31845	24280	20060	18045	13535	10825	9020	6765	5410
				f_z	0.09	0.107	0.121	0.159	0.181	0.202	0.225	0.229	0.222
				f (mm/min)	8595	7795	7280	8605	7350	6560	6090	4645	3600
H	38	Hardened Steel	40-50	v_c (m/min)	255	255	265	285	285	285	285	285	285
				n	27070	20300	16875	15125	11345	9075	7560	5670	4535
				f_z	0.072	0.09	0.108	0.136	0.155	0.168	0.187	0.19	0.192
				f (mm/min)	5845	5480	5465	6170	5275	4575	4240	3230	2610
		Hardened Steel	50-55	v_c (m/min)	185	185	195	230	230	230	230	230	230
				n	19635	14725	12420	12205	9155	7325	6100	4575	3660
				f_z	0.072	0.087	0.099	0.123	0.144	0.156	0.173	0.18	0.18
				f (mm/min)	4240	3840	3685	4505	3955	3425	3165	2470	1975
	39	Hardened Steel	55-65	v_c (m/min)	175	180	185	210	210	210	210	210	210
				n	18575	14330	11780	11145	8360	6685	5570	4180	3340
				f_z	0.072	0.086	0.099	0.115	0.134	0.144	0.145	0.144	0.145
				f (mm/min)	4010	3695	3500	3845	3360	2885	2420	1805	1455
		Hardened Steel	65-70	v_c (m/min)	120	120	125	145	145	145	145	145	145
				n	12735	9550	7960	7695	5770	4615	3845	2885	2305
				f_z	0.072	0.087	0.099	0.108	0.125	0.144	0.144	0.144	0.144
				f (mm/min)	2750	2490	2365	2490	2165	1995	1660	1245	995
	40	Chilled Cast Iron	v_c (m/min)	300	305	315	340	340	340	340	340	340	
			n	31845	24280	20060	18045	13535	10825	9020	6765	5410	
			f_z	0.09	0.107	0.121	0.159	0.181	0.202	0.225	0.229	0.222	
			f (mm/min)	8595	7795	7280	8605	7350	6560	6090	4645	3600	
41	Hardened Cast Iron	v_c (m/min)	255	255	265	285	285	285	285	285	285		
		n	27070	20300	16875	15125	11345	9075	7560	5670	4535		
		f_z	0.072	0.09	0.108	0.136	0.155	0.168	0.187	0.19	0.192		
		f (mm/min)	5845	5480	5465	6170	5275	4575	4240	3230	2610		



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