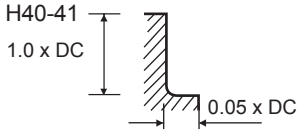
CUTTING DATA

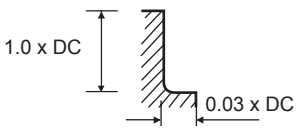
108350 (6 Flute 45° Corner Radius)

VDI MATERIAL GROUP		MATERIAL	HRc		Size (mm)					
					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)	106	108	106	106	108	110
				n	5620	4295	3375	2810	2150	1750
				f_z	0.036	0.049	0.058	0.065	0.083	0.095
				f (mm/min)	1215	1260	1175	1095	1070	995
H	38	Hardened Steel	**40-50**	v_c (m/min)	106	108	106	106	108	110
				n	5620	4295	3375	2810	2150	1750
				f_z	0.036	0.049	0.058	0.065	0.083	0.095
				f (mm/min)	1215	1260	1175	1095	1070	995
		Hardened Steel	**50-55**	v_c (m/min)	95	97	94	95	97	98
				n	5040	3860	2990	2520	1930	1560
				f_z	0.035	0.046	0.055	0.062	0.079	0.091
				f (mm/min)	1055	1065	985	935	915	850
	39	Hardened Steel	**55-65**	v_c (m/min)	83	83	82	83	83	87
				n	4400	3300	2610	2200	1650	1385
				f_z	0.033	0.044	0.053	0.059	0.076	0.072
				f (mm/min)	870	870	830	780	750	595
		Hardened Steel	**65-70**	v_c (m/min)	48	48	49	50	48	45
				n	2545	1910	1560	1325	955	715
				f_z	0.028	0.037	0.045	0.05	0.064	0.071
				f (mm/min)	430	425	420	395	365	305
	40	Chilled Cast Iron		v_c (m/min)	106	108	106	106	108	110
				n	5620	4295	3375	2810	2150	1750
				f_z	0.036	0.049	0.058	0.065	0.083	0.095
				f (mm/min)	1215	1260	1175	1095	1070	995
	41	Hardened Cast Iron		v_c (m/min)	95	97	94	95	97	98
				n	5040	3860	2990	2520	1930	1560
				f_z	0.035	0.046	0.055	0.062	0.079	0.091
				f (mm/min)	1055	1065	985	935	915	850

MATERIAL GROUP
P10-11, H38, H40-41



MATERIAL GROUP
H39



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