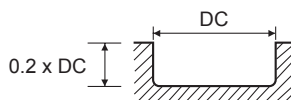


CUTTING DATA

108365 (2 Flute Corner Radius)												
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)								
					2.0	3.0	4.0	5.0	6.0	8.0	10.0	16.0
P	1-5	Non-alloy Steel	<25	v_c (m/min)	113	125	135	144	149	151	158	155
				n	17900	13200	10700	9150	7900	6000	5000	3100
				f_z	0.007	0.011	0.016	0.023	0.032	0.045	0.054	0.058
				f (mm/min)	250	290	340	420	500	540	540	360
	6-9	Low alloy Steel	25-35	v_c (m/min)	73	81	86	91	95	96	103	106
				n	11600	8500	6800	5700	5000	3800	3200	2100
				f_z	0.005	0.008	0.012	0.017	0.025	0.033	0.038	0.041
				f (mm/min)	115	135	160	195	250	250	250	170
	10-11	High alloy Steel, Tool Steel	35-45	v_c (m/min)	113	125	135	144	149	151	158	155
				n	17900	13200	10700	9150	7900	6000	5000	3100
				f_z	0.007	0.011	0.016	0.023	0.032	0.045	0.054	0.058
				f (mm/min)	250	290	340	420	500	540	540	360
K	15-20	Cast Iron		v_c (m/min)	113	125	135	144	149	151	158	155
				n	17900	13200	10700	9150	7900	6000	5000	3100
				f_z	0.007	0.011	0.016	0.023	0.032	0.045	0.054	0.058
				f (mm/min)	250	290	340	420	500	540	540	360
H	38	Hardened Steel	45-55	v_c (m/min)	45	50	54	60	62	63	63	64
				n	7100	5300	4300	3800	3200	2500	2000	1270
				f_z	0.005	0.007	0.009	0.013	0.018	0.024	0.03	0.031
				f (mm/min)	70	75	75	100	110	120	120	80
	40	Chilled Cast Iron		v_c (m/min)	73	81	86	91	5000	96	103	106
				n	11600	8500	6800	5700	0.025	3800	3200	2780
				f_z	0.005	0.008	0.012	0.017	250	0.033	0.038	0.041
				f (mm/min)	115	135	160	195	149	250	250	220
	41	Hardened Cast Iron		v_c (m/min)	45	50	54	60	62	63	63	64
				n	7100	5300	4300	3800	3200	2500	2000	1270
				f_z	0.005	0.007	0.009	0.013	0.018	0.024	0.03	0.031
				f (mm/min)	70	75	75	100	110	120	120	80



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