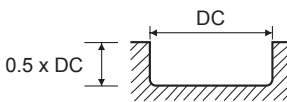


CUTTING DATA

109333, 113333 (2 Flute Miniature Corner Radius)														
VDI MATERIAL GROUP	MATERIAL		Size (mm)											
			0.4	0.6	0.8	1.0	1.2	1.5	2.0	3.0	4.0	5.0	6.0	
N	30	Graphite	v_c (m/min)	50	75	100	125	150	190	250	255	250	250	265
			n	40000	40000	40000	40000	40000	40000	40000	27000	20000	16000	14000
			f_z	0.008	0.008	0.01	0.012	0.015	0.018	0.02	0.035	0.058	0.072	0.082
			f (mm/min)	640	640	800	960	1200	1440	1600	1900	2300	2300	2300



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