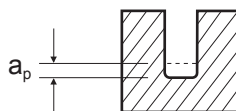


CUTTING DATA

110365 (2 Flute Extended Neck Corner Radius)												
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)								
				0.2 LU=1.0	0.3 LU=1.0	0.4 LU=2.0	0.5 LU=2.0	0.6 LU=4.0	0.8 LU=6.0	1.0 LU=6.0	1.2 LU=6.0	
P	1-5	Non-alloy Steel	<25	a_p (mm)	0.028	0.042	0.056	0.07	0.048	0.064	0.08	0.168
				v_c (m/min)	31	47	63	68	62	82	94	112
				n	49300	49800	50100	43200	32800	32600	29900	29700
				f_z	0.002	0.002	0.002	0.003	0.003	0.003	0.004	0.005
				f (mm/min)	195	200	200	260	195	195	240	295
	6-9	Low alloy Steel	25-35	a_p (mm)	0.021	0.032	0.042	0.053	0.036	0.048	0.06	0.126
				v_c (m/min)	22	30	40	44	41	54	61	71
				n	35000	31800	31800	28000	21700	21400	19400	18800
				f_z	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003
				f (mm/min)	70	65	65	110	85	85	78	110
	10-11	High alloy Steel, Tool Steel	35-45	a_p (mm)	0.021	0.032	0.042	0.053	0.036	0.048	0.06	0.126
				v_c (m/min)	22	30	40	44	41	54	61	71
n				35000	31800	31800	28000	21700	21400	19400	18800	
f_z				0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003	
f (mm/min)				70	65	65	110	85	85	78	110	
K	15-20	Cast Iron	a_p (mm)	0.028	0.042	0.056	0.07	0.048	0.064	0.08	0.168	
			v_c (m/min)	31	47	63	68	62	82	94	112	
			n	49300	49800	50100	43200	32800	32600	29900	29700	
			f_z	0.002	0.002	0.002	0.003	0.003	0.003	0.004	0.005	
			f (mm/min)	195	200	200	260	195	195	240	295	
H	38	Hardened Steel	45-55	a_p (mm)	0.017	0.025	0.034	0.042	0.029	0.038	0.048	0.101
				v_c (m/min)	13	19	25	27	25	33	37	44
				n	20600	20100	19800	17100	13200	13100	11700	11600
				f_z	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003
				f (mm/min)	40	40	40	70	50	50	45	70
	40	Chilled Cast Iron		a_p (mm)	0.021	0.032	0.042	0.053	0.036	0.048	0.06	0.126
				v_c (m/min)	22	30	40	44	41	54	61	71
				n	35000	31800	31800	28000	21700	21400	19400	18800
				f_z	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003
				f (mm/min)	70	65	65	110	85	85	78	110
	41	Hardened Cast Iron		a_p (mm)	0.017	0.025	0.034	0.042	0.029	0.038	0.048	0.101
				v_c (m/min)	13	19	25	27	25	33	37	44
				n	20600	20100	19800	17100	13200	13100	11700	11600
				f_z	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.003
				f (mm/min)	40	40	40	70	50	50	45	70



► The data given is based on LU length shown. Please adjust machining conditions according to length.

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)

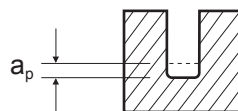
f - feed rate (mm/min)

a_p - axial depth of cut

a_e - radial depth of cut

CUTTING DATA

110365 (2 Flute Extended Neck Corner Radius)											
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)							
				1.5 LU=6.0	2.0 LU=8.0	3.0 LU=12.0	4.0 LU=16.0	6.0 LU=20.0	8.0 LU=25.0	10.0 LU=30.0	
P	1-5	Non-alloy Steel	<25	a_p (mm)	0.21	0.28	0.42	0.56	0.84	1.12	2.0
				v_c (m/min)	124	136	150	161	179	181	188
				n	26300	21600	15900	12800	9500	7200	5900
				f_z	0.006	0.007	0.01	0.016	0.032	0.044	0.053
				f (mm/min)	315	300	315	410	600	630	630
	6-9	Low alloy Steel	25-35	a_p (mm)	0.158	0.21	0.315	0.42	0.63	0.84	1.5
				v_c (m/min)	76	87	97	103	113	114	126
				n	16100	13800	10200	8200	6000	4500	4000
				f_z	0.004	0.005	0.008	0.012	0.025	0.033	0.038
				f (mm/min)	130	135	165	195	300	300	305
	10-11	High alloy Steel, Tool Steel	35-45	a_p (mm)	0.158	0.21	0.315	0.42	0.63	0.84	1.5
				v_c (m/min)	76	87	97	103	113	114	126
n				16100	13800	10200	8200	6000	4500	4000	
f_z				0.004	0.005	0.008	0.012	0.025	0.033	0.038	
f (mm/min)				130	135	165	195	300	300	305	
K	15-20	Cast Iron	a_p (mm)	0.21	0.28	0.42	0.56	0.84	1.12	2.0	
			v_c (m/min)	124	136	150	161	179	181	188	
			n	26300	21600	15900	12800	9500	7200	5900	
			f_z	0.006	0.007	0.01	0.016	0.032	0.044	0.053	
			f (mm/min)	315	300	315	410	600	630	630	
H	38	Hardened Steel	45-55	a_p (mm)	0.126	0.168	0.252	0.336	0.504	0.672	1.2
				v_c (m/min)	48	54	59	65	74	76	76
				n	10100	8600	6200	5100	3900	3000	2400
				f_z	0.003	0.005	0.006	0.009	0.018	0.023	0.029
				f (mm/min)	60	85	75	90	140	140	140
	40	Chilled Cast Iron	a_p (mm)	0.158	0.21	0.315	0.42	0.63	0.84	1.5	
			v_c (m/min)	76	87	97	103	113	114	126	
			n	16100	13800	10200	8200	6000	4500	4000	
			f_z	0.004	0.005	0.008	0.012	0.025	0.033	0.038	
			f (mm/min)	130	135	165	195	300	300	305	
	41	Hardened Cast Iron	a_p (mm)	0.126	0.168	0.252	0.336	0.504	0.672	1.2	
			v_c (m/min)	48	54	59	65	74	76	76	
			n	10100	8600	6200	5100	3900	3000	2400	
			f_z	0.003	0.005	0.006	0.009	0.018	0.023	0.029	
			f (mm/min)	60	85	75	90	140	140	140	



► The data given is based on LU length shown. Please adjust machining conditions according to length.

Recommended cutting depths are **maximum** depths, and **speeds and feeds are a starting point** based on these depths.

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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