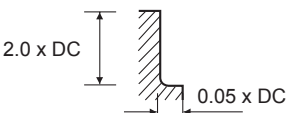


CUTTING DATA

112365 (4 Flute Corner Radius)												
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	
P	1-5	Non-alloy Steel	<25	v_c (m/min)	125	135	144	149	151	158	155	156
				n	13200	10700	9150	7900	6000	5000	4100	3100
				f_z	0.006	0.01	0.012	0.014	0.019	0.023	0.022	0.023
				f (mm/min)	315	430	440	440	460	460	360	280
	6-9	Low alloy Steel	25-35	v_c (m/min)	81	86	91	95	96	103	105	106
				n	8500	6800	5700	5000	3800	3280	2780	2100
				f_z	0.008	0.011	0.016	0.018	0.024	0.027	0.029	0.027
				f (mm/min)	275	300	370	360	365	350	320	220
	10-11	High alloy Steel, Tool Steel	35-45	v_c (m/min)	125	135	144	149	151	158	155	156
				n	13200	10700	9150	7900	6000	5000	4100	3100
				f_z	0.006	0.01	0.012	0.014	0.019	0.023	0.022	0.023
				f (mm/min)	315	430	440	440	460	460	360	280
K	15-20	Cast Iron	v_c (m/min)	125	135	144	149	151	158	155	156	
			n	13200	10700	9150	7900	6000	5000	4100	3100	
			f_z	0.006	0.01	0.012	0.014	0.019	0.023	0.022	0.023	
			f (mm/min)	315	430	440	440	460	460	360	280	
H	38	Hardened Steel	45-55	v_c (m/min)	50	54	60	62	63	63	63	64
				n	5300	4300	3800	3200	2500	2000	1670	1270
				f_z	0.006	0.008	0.011	0.013	0.017	0.021	0.021	0.022
				f (mm/min)	125	135	165	170	170	165	140	110
	40	Chilled Cast Iron		v_c (m/min)	81	86	91	95	96	103	105	106
				n	8500	6800	5700	5000	3800	3280	2780	2100
				f_z	0.008	0.011	0.016	0.018	0.024	0.027	0.029	0.027
				f (mm/min)	275	300	370	360	365	350	320	220
	41	Hardened Cast Iron		v_c (m/min)	50	54	60	62	63	63	63	64
				n	5300	4300	3800	3200	2500	2000	1670	1270
				f_z	0.006	0.008	0.011	0.013	0.017	0.021	0.021	0.022
				f (mm/min)	125	135	165	170	170	165	140	110



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