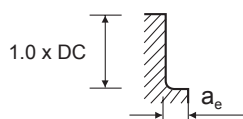


CUTTING DATA

114365 (4 Flute Extended Neck Corner Radius)														
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)										
				1.0 LU=6.0	1.2 LU=6.0	1.5 LU=8.0	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	12.0 LU=32.0	
P	1-5	Non-alloy Steel	<25	a _e (mm)	0.012	0.025	0.018	0.042	0.063	0.084	0.126	0.168	0.3	0.36
				v _c (m/min)	94	112	112	136	150	161	179	181	188	188
				n	29900	29700	23700	21600	15900	12800	9500	7200	5900	4900
				f _z	0.002	0.003	0.003	0.004	0.006	0.01	0.013	0.019	0.023	0.022
				f (mm/min)	240	350	285	340	380	500	490	545	550	440
	6-9	Low alloy Steel	25-35	a _e (mm)	0.009	0.019	0.014	0.032	0.047	0.063	0.095	0.126	0.225	0.27
				v _c (m/min)	61	71	69	87	97	103	113	114	126	126
				n	19400	18800	14600	13800	10300	8200	6000	4500	4000	3300
				f (mm/min)	230	300	230	275	330	361	430	435	430	375
	10-11	High alloy Steel, Tool Steel	35-45	a _e (mm)	0.009	0.019	0.014	0.032	0.047	0.063	0.095	0.126	0.225	0.27
				v _c (m/min)	61	71	69	87	97	103	113	114	126	126
				n	19400	18800	14600	13800	10300	8200	6000	4500	4000	3300
f (mm/min)				230	300	230	275	330	361	430	435	430	375	
K	15-20	Cast Iron	a _e (mm)	0.012	0.025	0.018	0.042	0.063	0.084	0.126	0.168	0.3	0.36	
			v _c (m/min)	94	112	112	136	150	161	179	181	188	188	
			n	29900	29700	23700	21600	15900	12800	9500	7200	5900	4900	
			f _z	0.002	0.003	0.003	0.004	0.006	0.01	0.013	0.019	0.023	0.022	
			f (mm/min)	240	350	285	340	380	500	490	545	550	440	
H	38	Hardened Steel	45-55	a _e (mm)	0.007	0.015	0.011	0.025	0.038	0.05	0.076	0.101	0.18	0.216
				v _c (m/min)	37	44	43	54	59	65	74	76	76	75
				n	11700	11600	9100	8500	6200	5100	3900	3000	2400	1950
				f _z	0.002	0.003	0.003	0.004	0.006	0.008	0.013	0.017	0.021	0.02
				f (mm/min)	95	140	105	135	150	166	200	205	200	160
	40	Chilled Cast Iron		a _e (mm)	0.009	0.019	0.014	0.032	0.047	0.063	0.095	0.126	0.225	0.27
				v _c (m/min)	61	71	69	87	97	103	113	114	126	126
				n	19400	18800	14600	13800	10300	8200	6000	4500	4000	3300
				f (mm/min)	230	300	230	275	330	361	430	435	430	375
	41	Hardened Cast Iron		a _e (mm)	0.007	0.015	0.011	0.025	0.038	0.05	0.076	0.101	0.18	0.216
				v _c (m/min)	37	44	43	54	59	65	74	76	76	75
				n	11700	11600	9100	8500	6200	5100	3900	3000	2400	1950
f (mm/min)				95	140	105	135	150	166	200	205	200	160	



► 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