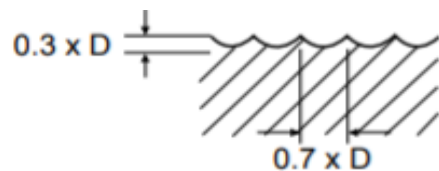


BALL ENDMILL COATED (115121, 116121)



MATERIAL GROUP	HRc		SIZE (MM)						
			6	8	10	12	16	20	25
P	≤20	Vc (M/MIN)	30	30	30	30	30	30	30
		n	1700	1200	1000	800	600	500	400
		Fz	0.026	0.044	0.06	0.067	0.083	0.087	0.088
		F(MM/MIN)	135	160	180	160	150	130	105
	20 - 30	Vc (M/MIN)	20	20	20	15	20	20	15
		n	1000	700	560	450	350	300	220
		Fz	0.023	0.036	0.054	0.059	0.076	0.083	0.091
		F(MM/MIN)	70	75	90	80	80	75	60
	30 - 40	Vc (M/MIN)	15	15	15	15	15	15	15
		n	700	500	400	320	250	200	160
		Fz	0.019	0.03	0.042	0.052	0.067	0.083	0.094
		F(MM/MIN)	40	45	50	50	50	50	45
N	Vc (M/MIN)	105	100	100	95	100	100	100	
	n	5600	400	3200	2500	2000	1600	1300	
	Fz	0.025	0.044	0.056	0.068	0.075	0.088	0.097	
	F(MM/MIN)	420	530	540	510	450	420	380	

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
HRc	Hardness of metal



All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

$$\text{To calculate RPM from cutting speed: } n = \frac{v_c \cdot 1000}{\pi \cdot \phi}$$

$$\text{To calculate cutting speed from RPM: } v_c = \frac{n \cdot \pi \cdot \phi}{1000}$$