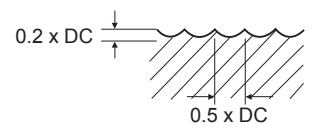


CUTTING DATA

116303 (3 Flute 40° Helix, Ball Nose)													
VDI MATERIAL GROUP		Type of cut		Size (mm)									
				2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	
N	21-25	SLOTTING	Aluminium/Aluminium Alloys	v_c (m/min)	135	135	180	225	270	280	350	420	440
			n	21600	14400	14400	14400	14400	11200	11200	11200	8800	
			f_z	0.018	0.026	0.035	0.038	0.049	0.071	0.084	0.107	0.123	
			f (mm/min)	760	760	1000	1080	1400	1600	1880	2400	2160	
	26-28		Copper/Copper Alloys	v_c (m/min)	40	40	55	70	85	85	105	125	135
			n	6400	4400	4400	4400	4400	3360	3360	3360	2640	
			f_z	0.015	0.022	0.028	0.031	0.04	0.06	0.069	0.089	0.101	
			f (mm/min)	190	190	250	270	350	400	465	600	535	



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