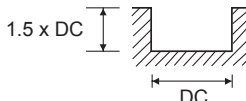


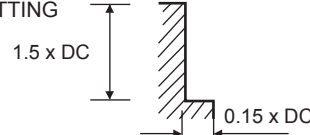
CUTTING DATA

125103, 125303, 126103, 126303 (3 Flute Roughing)									
VDI MATERIAL GROUP		Type of cut		Size (mm)					
				6.0	8.0	10.0	12.0	16.0	20.0
N 21-25	Aluminium/ Aluminium Alloys	SLOTTING	v_c (m/min)	200	200	205	320	322	320
			n	13500	10500	8500	8500	6400	5100
			f_z	0.168	0.168	0.169	0.165	0.167	0.163
			f (mm/min)	6800	5300	4300	4200	3200	2500
		SIDE CUTTING	v_c (m/min)	200	200	205	320	322	320
			n	13500	10500	8500	8500	6400	5100
			f_z	0.168	0.167	0.169	0.167	0.167	0.165
			f (mm/min)	5300	4000	3500	3200	2400	1900

SLOTTING



SIDE CUTTING



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