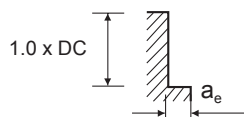


CUTTING DATA

126365 (4 Flute Extended Neck)													
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)									
				1.0 LU=5.0	1.5 LU=8.0	2.0 LU=10.0	3.0 LU=12.0	4.0 LU=16.0	5.0 LU=20.0	6.0 LU=15.0	8.0 LU=25.0	10.0 LU=30.0	
P	1-5	Non-alloy Steel	<25	a_e (mm)	0.015	0.013	0.029	0.044	0.059	0.074	0.126	0.118	0.21
				v_c (m/min)	69	72	87	101	114	119	126	127	123
				n	21900	15200	13800	10700	9000	7500	6600	5000	3900
				f_z	0.004	0.004	0.006	0.009	0.019	0.024	0.03	0.042	0.047
				f (mm/min)	350	240	330	385	690	720	800	850	730
	6-9	Low alloy Steel	25-35	a_e (mm)	0.011	0.009	0.022	0.033	0.044	0.055	0.095	0.088	0.158
				v_c (m/min)	42	45	57	63	70	71	76	43	75
				n	13300	9500	9000	6600	5500	4500	4000	3000	2300
				f_z	0.003	0.004	0.006	0.009	0.019	0.024	0.03	0.037	0.038
				f (mm/min)	160	150	220	240	420	430	480	450	360
	10-11	High alloy Steel, Tool Steel	35-45	a_e (mm)	0.011	0.009	0.022	0.033	0.044	0.055	0.095	0.088	0.158
				v_c (m/min)	42	45	57	63	70	71	76	43	75
n				13300	9500	9000	6600	5500	4500	4000	3000	2300	
f_z				0.003	0.004	0.006	0.009	0.019	0.024	0.03	0.037	0.038	
f (mm/min)				160	150	220	240	420	430	480	450	360	
K	15-20	Cast Iron	a_e (mm)	0.015	0.013	0.029	0.044	0.059	0.074	0.126	0.118	0.21	
			v_c (m/min)	69	72	87	101	114	119	126	127	123	
			n	21900	15200	13800	10700	9000	7500	6600	5000	3900	
			f_z	0.004	0.004	0.006	0.009	0.019	0.024	0.03	0.042	0.047	
			f (mm/min)	350	240	330	385	690	720	800	850	730	
H	38	Hardened Steel	45-55	a_e (mm)	0.009	0.008	0.018	0.026	0.035	0.044	0.076	0.071	0.126
				v_c (m/min)	27	28	38	38	44	44	45	51	51
				n	8500	5900	6000	4000	3500	2800	2300	2000	1600
				f_z	0.001	0.002	0.003	0.004	0.005	0.008	0.01	0.016	0.016
				f (mm/min)	34	48	75	65	70	90	95	130	100
	40	Chilled Cast Iron		a_e (mm)	0.011	0.009	0.022	0.033	0.044	0.055	0.095	0.088	0.158
				v_c (m/min)	42	45	57	63	70	71	76	43	75
				n	13300	9500	9000	6600	5500	4500	4000	3000	2300
				f_z	0.003	0.004	0.006	0.009	0.019	0.024	0.03	0.037	0.038
				f (mm/min)	160	150	220	240	420	430	480	450	360
	41	Hardened Cast Iron		a_e (mm)	0.009	0.008	0.018	0.026	0.035	0.044	0.076	0.071	0.126
				v_c (m/min)	27	28	38	38	44	44	45	51	51
				n	8500	5900	6000	4000	3500	2800	2300	2000	1600
				f_z	0.001	0.002	0.003	0.004	0.005	0.008	0.01	0.016	0.016
				f (mm/min)	34	48	75	65	70	90	95	130	100



► 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