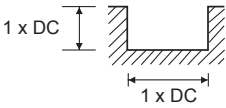
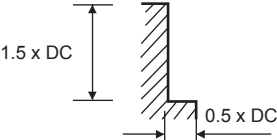
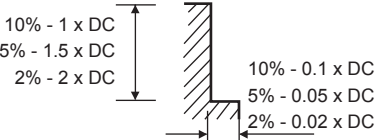


CUTTING DATA

All Mastermill AL-HPC End Mills													
VDI MATERIAL GROUP			Type of cut		Size (mm)								
				3.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0		
N	21-24	Aluminium/ Aluminium Alloys	SLOTTING	v _c (m/min)	488	488	488	488	488	488	488	488	
				n	51778	25889	19427	15533	12945	9708	7767	6213	
				f _z	0.025	0.076	0.095	0.114	0.152	0.168	0.191	0.254	
				f (mm/min)	3946	5918	5537	5326	5918	4883	4439	4735	
	25	Aluminium Si >16%		v _c (m/min)	183	183	183	183	183	183	183	183	
				n	19417	9708	7285	5825	4854	3641	2913	2330	
				f _z	0.025	0.076	0.095	0.114	0.152	0.168	0.191	0.254	
				f (mm/min)	1480	2219	2076	1997	2219	1831	1665	1775	
	21-24	Aluminium/ Aluminium Alloys		v _c (m/min)	610	610	610	610	610	610	610	610	
				n	64756	32378	24283	19427	16189	12142	9713	7771	
				f _z	0.025	0.076	0.171	0.267	0.356	0.381	0.419	0.495	
				f (mm/min)	4857	7382	12457	15561	17290	13878	12210	11539	
	25	Aluminium Si >16%	v _c (m/min)	244	244	244	244	244	244	244	244		
			n	25889	12945	9713	7767	6472	4854	3883	3107		
			f _z	0.025	0.076	0.095	0.114	0.152	0.168	0.191	0.254		
			f (mm/min)	1973	2959	2768	2663	2959	2441	2219	2367		
	21-24	Aluminium/ Aluminium Alloys	DYNAMIC 10% ae	v _c (m/min)	1000	1000	1000	1000	1000	1000	1000	1000	
				f _z	0.08	0.104	0.154	0.198	0.264	0.283	0.311	0.341	
	25	Aluminium Si >16%		v _c (m/min)	360	360	360	360	360	360	360	360	
				f _z	0.08	0.104	0.154	0.198	0.264	0.283	0.311	0.341	
	21-24	Aluminium/ Aluminium Alloys		DYNAMIC 5% ae	v _c (m/min)	1000	1000	1000	1000	1000	1000	1000	1000
					f _z	0.101	0.14	0.208	0.267	0.356	0.381	0.419	0.45
	25	Aluminium Si >16%			v _c (m/min)	360	360	360	360	360	360	360	360
					f _z	0.101	0.14	0.208	0.267	0.356	0.381	0.419	0.45
	21-24	Aluminium/ Aluminium Alloys	DYNAMIC 2% ae		v _c (m/min)	1000	1000	1000	1000	1000	1000	1000	1000
					f _z	0.101	0.202	0.3	0.385	0.514	0.55	0.605	0.665
	25	Aluminium Si >16%			v _c (m/min)	360	360	360	360	360	360	360	360
					f _z	0.101	0.202	0.3	0.385	0.514	0.55	0.605	0.665

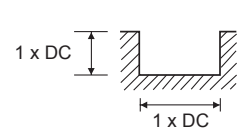
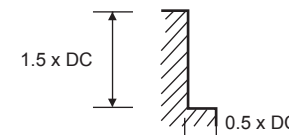
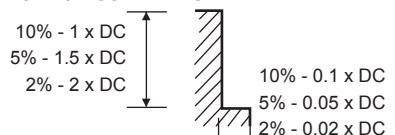
SLOTTING	SIDE CUTTING	DYNAMIC MACHINING NOT FOR USE WITH CHIPBREAKER
		

Recommended cutting depths are **maximum** depths, and **speeds and feeds are a starting point** based on these depths.
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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

CUTTING DATA

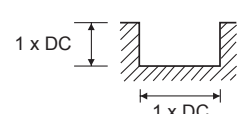
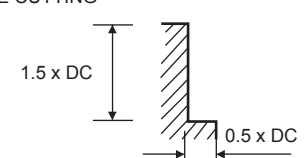
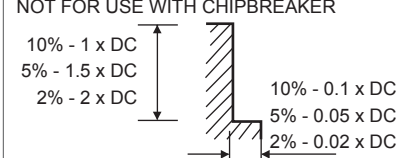
All Mastermill AL-HPC End Mills												
VDI MATERIAL GROUP			Type of cut		Size (mm)							
					3.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
N	26-27	Copper/ Copper Alloys	SLOTTING	v _c (m/min)	268	268	268	268	268	268	268	268
				n	28436	14218	11465	8531	7109	5332	4265	3412
				f _z	0.020	0.051	0.076	0.102	0.127	0.140	0.152	0.178
				f (mm/min)	1733	2167	2614	2600	2708	9311	6983	5586
	28	Copper/ Cu-Al-Fe Alloys		v _c (m/min)	91	91	91	91	91	91	91	91
				n	9655	4828	3623	2897	2414	1810	1448	1159
				f _z	0.020	0.051	0.076	0.102	0.127	0.140	0.152	0.178
				f (mm/min)	589	736	826	883	920	759	662	618
	26-27	Copper/ Copper Alloys	SIDE CUTTING	v _c (m/min)	351	351	351	351	351	351	351	351
				n	37242	18621	13973	11173	9311	6983	5586	4469
				f _z	0.020	0.051	0.076	0.102	0.127	0.140	0.152	0.178
				f (mm/min)	2270	2838	3186	3405	3547	2927	2554	2384
	28	Copper/ Cu-Al-Fe Alloys		v _c (m/min)	137	137	137	137	137	137	137	137
				n	14536	7268	5454	4361	33634	2726	2180	1744
				f _z	0.020	0.051	0.076	0.102	0.127	0.140	0.152	0.178
				f (mm/min)	886	1108	1243	1329	1385	1142	997	930
	26-27	Copper/ Copper Alloys	DYNAMIC 10% ae	v _c (m/min)	1000	1000	1000	1000	1000	1000	1000	1000
				f _z	0.12	0.17	0.25	0.321	0.433	0.471	0.519	0.535
	28	Copper/ Cu-Al-Fe Alloys		v _c (m/min)	560	560	560	560	560	560	560	560
				f _z	0.06	0.085	0.125	0.16	0.217	0.245	0.264	0.288
	26-27	Copper/ Copper Alloys	DYNAMIC 5% ae	v _c (m/min)	1000	1000	1000	1000	1000	1000	1000	1000
				f _z	0.19	0.229	0.337	0.432	0.584	0.635	0.699	0.735
	28	Copper/ Cu-Al-Fe Alloys		v _c (m/min)	560	560	560	560	560	560	560	560
				f _z	0.08	0.114	0.168	0.216	0.292	0.33	0.356	0.388
	26-27	Copper/ Copper Alloys	DYNAMIC 2% ae	v _c (m/min)	1000	1000	1000	1000	1000	1000	1000	1000
				f _z	0.28	0.331	0.486	0.924	0.843	0.916	1.01	1.12
	28	Copper/ Cu-Al-Fe Alloys		v _c (m/min)	560	560	560	560	560	560	560	560
				f _z	0.11	0.165	0.252	0.312	0.421	0.476	0.514	0.55

SLOTTING	SIDE CUTTING	DYNAMIC MACHINING NOT FOR USE WITH CHIPBREAKER
		

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CUTTING DATA

All Mastermill AL-HPC End Mills												
VDI MATERIAL GROUP			Type of cut		Size (mm)							
					3.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
N	29.1	Plastics/ Acrylics	SLOTTING	v_c (m/min)	503	503	503	503	503	503	503	503
				n	53370	26685	20024	16011	13342	10007	8005	6404
				f_z	0.038	0.102	0.146	0.191	0.254	0.249	0.305	0.356
				f (mm/min)	6100	8134	8770	9150	10167	8388	320	6832
		SIDE CUTTING	v_c (m/min)	625	625	625	625	625	625	625	625	625
			n	66314	33157	24881	19894	16579	12434	9947	7958	
			f_z	0.038	0.102	0.146	0.191	0.254	0.249	0.305	0.356	
			f (mm/min)	7580	10106	10898	11370	12633	10422	9096	8489	
		DYNAMIC 10% ae	v_c (m/min)	100	100	100	100	100	100	100	100	100
			f_z	0.18	0.29	0.41	0.512	0.586	0.611	0.64	0.688	
		DYNAMIC 5% ae	v_c (m/min)	100	100	100	100	100	100	100	100	100
			f_z	0.25	0.391	0.552	0.69	0.789	0.864	0.92	1.015	
		DYNAMIC 2% ae	v_c (m/min)	100	100	100	100	100	100	100	100	100
			f_z	0.35	0.564	0.797	0.996	1.139	1.340	1.55	1.764	
SLOTTING				SIDE CUTTING				DYNAMIC MACHINING NOT FOR USE WITH CHIPBREAKER				
												

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