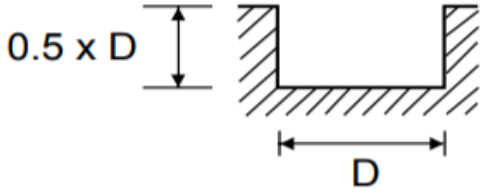
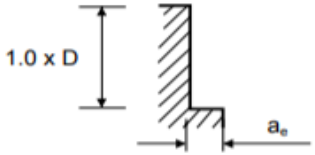
2 Flute Helix 42' Short Length Endmills For Ali Coated (131121)

MATERIAL GROUP	HRc		SIZE (MM)								
			3	6	8	10	12	14	16	18	20
N		Vc (M/MIN)	75	130	150	155	190	155	175	130	145
		n	8000	7000	6000	5000	5000	3500	3500	2300	2300
		Fz	0.035	0.05	0.071	0.12	0.012	0.177	0.177	0.283	0.283
		F(MM/MIN)	560	700	850	1200	1200	1240	1240	1300	1300



MATERIAL GROUP	HRc		SIZE (MM)								
			3	6	8	10	12	14	16	18	20
N		Vc (M/MIN)	75	130	150	155	190	155	175	130	145
		n	8000	7000	6000	5000	5000	3500	3500	2300	2300
		Fz	0.046	0.064	0.092	0.15	0.15	0.229	0.229	0.37	0.37
		F(MM/MIN)	750	900	1100	1500	1500	1600	1600	1700	1700

a_e : ø3.0mm - ø10.0mm = 0.25 x D
a_e : ø12.0mm - ø20.0mm = 0.5x D



Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
z	No. of teeth

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.

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

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