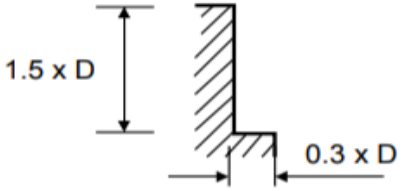
Multi Flute Long Length Endmill High Helix Uncoated (132102)

MATERIAL GROUP	HRc		SIZE (MM)											
			2	3	4	5	6	8	10	12	16	20	25	30
P	≤20	Vc (M/MIN)	30	35	30	30	35	30	30	35	30	30	35	35
		n	5000	3500	2500	2000	1800	1200	1000	900	600	500	450	350
		Fz	0.004	0.007	0.012	0.019	0.016	0.026	0.032	0.041	0.053	0.063	0.047	0.046
		F(MM/MIN)	35	50	60	75	85	95	95	110	95	95	85	85
	20 - 30	Vc (M/MIN)	35	30	25	30	25	25	30	25	25	30	25	25
		n	4500	2800	2000	1800	1300	1000	900	700	500	450	350	280
		Fz	0.003	0.006	0.01	0.015	0.014	0.022	0.026	0.033	0.043	0.048	0.039	0.04
		F(MM/MIN)	25	35	40	55	55	65	70	70	65	65	55	45
	30 -40	Vc (M/MIN)	15	15	15	15	15	15	15	15	15	15	15	15
		n	2500	1800	1200	100	900	600	500	450	300	25	200	180
		Fz	0.002	0.006	0.01	0.015	0.013	0.022	0.027	0.033	0.044	0.053	0.038	0.035
		F(MM/MIN)	10	20	25	30	35	40	40	45	40	40	30	25

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
HRc	Hardness of metal



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

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

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.