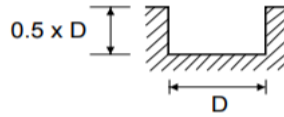


1 Flute with plain shank Short Length Coated (135327)



MATERIAL GROUP	HRc		SIZE (MM)					
			3	4	5	6	8	10
N		Vc (M/MIN)	188	226	220	207	214	220
		n	20000	18000	14000	11000	85000	7000
		Fz	0.055	0.053	0.054	0.055	0.053	0.054
		F(MM/MIN)	1100	950	750	600	450	380

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: $n = \frac{v_c \cdot 1000}{\pi \cdot \phi}$

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

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.