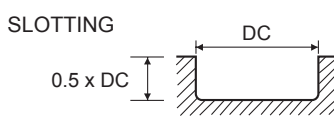


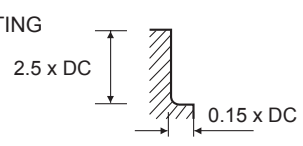
CUTTING DATA

142303, 156303 (3 Flute 45° Helix, Corner Radius & Necked Corner Radius)												
VDI MATERIAL GROUP		Type of cut		Size (mm)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
N 21-25	Aluminium/ Aluminium Alloys	SLOTTING	v_c (m/min)	95	125	155	190	200	250	300	300	250
			n	10000	10000	10000	10000	8000	8000	8000	6000	4000
			f_z	0.039	0.05	0.055	0.066	0.096	0.117	0.145	0.174	0.22
			f (mm/min)	1160	1490	1650	1980	2310	2810	3470	3140	2640
		SIDE CUTTING	v_c (m/min)	95	125	155	190	200	250	300	300	250
			n	10000	10000	10000	10000	8000	8000	8000	6000	4000
			f_z	0.05	0.061	0.072	0.083	0.125	0.145	0.179	0.22	0.262
			f (mm/min)	1490	1820	2150	2480	3000	3470	4290	3960	3140

SLOTTING



SIDE CUTTING



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