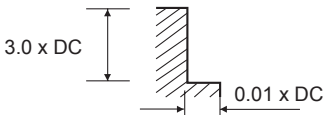
CUTTING DATA

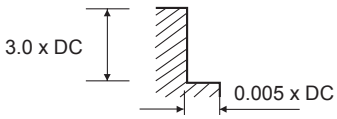
150370 (6 Flute Extra Length 45° Helix)

VDI MATERIAL GROUP		MATERIAL	HRc		Size (mm)						
					6.0	**8.0**	**10.0**	**12.0**	**16.0**	**20.0**	**25.0**
P	1-5	Non-alloy Steel	**<25**	v_c (m/min)	45	45	45	45	45	45	45
				n	2385	1790	1430	1190	895	715	570
				f_z	0.035	0.045	0.055	0.06	0.065	0.07	0.074
				f (mm/min)	500	480	470	430	350	300	255
	6-9	Low alloy Steel	**25-35**	v_c (m/min)	30	30	30	30	30	30	30
				n	1590	1190	955	795	595	475	380
				f_z	0.035	0.044	0.05	0.053	0.061	0.067	0.071
				f (mm/min)	335	315	285	250	215	190	160
	10-11	High alloy Steel, Tool Steel	**35-45**	v_c (m/min)	30	30	30	30	30	30	30
				n	1590	1190	955	795	595	475	380
				f_z	0.035	0.044	0.05	0.053	0.061	0.067	0.071
				f (mm/min)	335	315	285	250	215	190	160
K	15-20	Cast Iron		v_c (m/min)	45	45	45	45	45	45	45
				n	2385	1790	1430	1190	895	715	570
				f_z	0.035	0.045	0.055	0.06	0.065	0.07	0.074
				f (mm/min)	500	480	470	430	350	300	255
H	38	Hardened Steel	**45-55**	v_c (m/min)	25	25	25	25	25	25	25
				n	1325	995	795	660	495	395	315
				f_z	0.03	0.038	0.046	0.051	0.054	0.06	0.064
				f (mm/min)	240	225	220	200	160	140	120

MATERIAL GROUP
P, K



MATERIAL GROUP
H



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