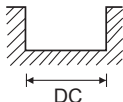


CUTTING DATA

151303, 152303, 154303 (2 Flute 45° Helix, Short, Long & Long Series)													
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	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
				f (mm/min)	700	900	1000	1200	1400	1700	2100	1900	1600
			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	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
				f (mm/min)	700	900	1000	1200	1400	1700	2100	1900	1600

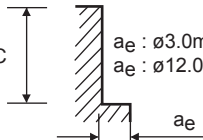
SLOTTING

0.5 x DC



SIDE CUTTING

1.0 x DC



$a_e : \varnothing 3.0\text{mm} - \varnothing 10.0\text{mm} = 0.25 \times DC$
 $a_e : \varnothing 12.0\text{mm} - \varnothing 20.0\text{mm} = 0.15 \times DC$

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