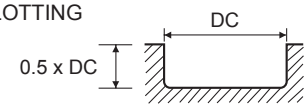
CUTTING DATA

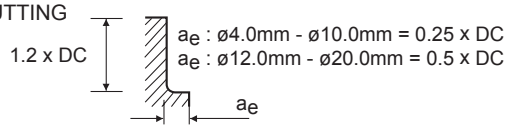
155303 (2 Flute Corner Radius)

VDI MATERIAL GROUP		Type of cut		Size (mm)						
				4.0	**6.0**	**8.0**	**10.0**	**12.0**	**16.0**	**20.0**
N	21-25 Aluminium/ Aluminium Alloys	SLOTTING	v_c (m/min)	130	195	200	250	300	320	250
			n	10400	10400	8000	8000	8000	6400	4000
			f_z	0.046	0.058	0.09	0.110	0.135	0.156	0.2
			f (mm/min)	960	1200	1440	1760	2160	2000	1600
		SIDE CUTTING	v_c (m/min)	130	195	200	250	300	320	250
			n	10400	10400	8000	8000	8000	6400	4000
			f_z	0.054	0.077	0.115	0.135	0.17	0.194	0.25
			f (mm/min)	1120	1600	1840	2160	2720	2480	2000

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