

CUTTING DATA

155370 (2 Flute Standard, Corner Radius)					Size (mm)				
VDI MATERIAL GROUP	MATERIAL	HRc			4.0	6.0	8.0	10.0	12.0
P	1-5	Non-alloy Steel	<25	v_c (m/min)	75	80	85	85	85
				n	5970	4240	3380	2705	2255
				f_z	0.016	0.032	0.045	0.053	0.051
				f (mm/min)	190	270	300	285	230
	6-9	Low alloy Steel	25-35	v_c (m/min)	45	50	55	55	60
				n	3580	2650	2190	1750	1590
				f_z	0.013	0.025	0.033	0.039	0.041
				f (mm/min)	90	130	145	135	130
	10-11	High alloy Steel, Tool Steel	35-45	v_c (m/min)	45	50	55	55	60
				n	3580	2650	2190	1750	1590
				f_z	0.013	0.025	0.033	0.039	0.041
				f (mm/min)	90	130	145	135	130
K	15-20	Cast Iron		v_c (m/min)	75	80	85	85	85
				n	5970	4240	3380	2705	2255
				f_z	0.016	0.032	0.045	0.053	0.051
				f (mm/min)	190	270	300	285	230
H	38	Hardened Steel	45-55	v_c (m/min)	30	35	35	35	35
				n	2385	1855	1390	1115	930
				f_z	0.006	0.01	0.013	0.016	0.019
				f (mm/min)	30	35	35	35	35

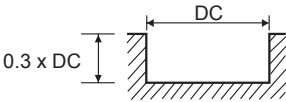


Diagram showing a rectangular tool cross-section with width DC and height $0.3 \times DC$.

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