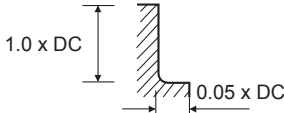
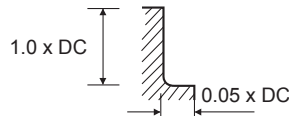


CUTTING DATA

156370 (4 Flute Stub Length, Corner Radius)											
VDI MATERIAL GROUP		MATERIAL	HRc		Size (mm)						
					2.0	3.0	4.0	6.0	8.0	10.0	12.0
P	1-5	Non-alloy Steel	<25	v _c (m/min)	95	110	125	140	140	135	135
				n	15120	11670	9945	7425	5570	4295	3580
				f _z	0.006	0.009	0.019	0.03	0.042	0.047	0.048
				f (mm/min)	360	420	755	890	935	805	685
	6-9	Low alloy Steel	25-35	v _c (m/min)	65	70	75	85	85	85	85
				n	10340	7425	5970	4500	3380	2706	2255
				f _z	0.006	0.009	0.019	0.03	0.038	0.037	0.037
				f (mm/min)	250	265	450	540	510	400	330
	10-11	High alloy Steel, Tool Steel	35-45	v _c (m/min)	65	70	75	85	85	85	85
				n	10340	7425	5970	4500	3380	2706	2255
				f _z	0.006	0.009	0.019	0.03	0.038	0.037	0.037
				f (mm/min)	250	265	450	540	510	400	330
K	15-20	Cast Iron		v _c (m/min)	95	110	125	140	140	135	135
				n	15120	11670	9945	7425	5570	4295	3580
				f _z	0.006	0.009	0.019	0.03	0.042	0.047	0.048
				f (mm/min)	360	420	755	890	935	805	685
H	38	Hardened Steel	45-55	v _c (m/min)	40	40	50	50	55	55	60
				n	6365	4240	3980	2650	2190	1750	1590
				f _z	0.002	0.004	0.005	0.01	0.016	0.017	0.017
				f (mm/min)	50	65	80	105	140	120	105





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