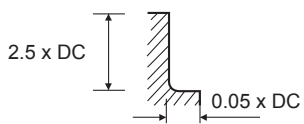
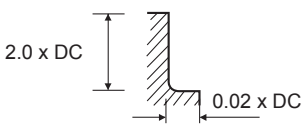


CUTTING DATA

157370 (4 Flute Standard Length, Corner Radius)												
VDI MATERIAL GROUP	MATERIAL	HRc		Size (mm)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-5 Non-alloy Steel	<25	v_c (m/min)	70	75	80	80	85	85	85	95	85
			n	7430	5970	5090	4240	3380	2700	2255	1890	1350
			f_z	0.006	0.01	0.012	0.014	0.019	0.023	0.022	0.023	0.022
			f (mm/min)	180	240	245	235	255	250	200	175	120
	6-9 Low alloy Steel	25-35	v_c (m/min)	45	45	50	50	55	55	60	60	55
			n	4775	3580	3180	2650	2190	1750	1590	1195	875
			f_z	0.008	0.011	0.016	0.018	0.024	0.029	0.029	0.03	0.028
			f (mm/min)	150	160	200	190	210	195	185	140	100
	10-11 High alloy Steel, Tool Steel	35-45	v_c (m/min)	45	45	50	50	55	55	60	60	55
			n	4775	3580	3180	2650	2190	1750	1590	1195	875
			f_z	0.008	0.011	0.016	0.018	0.024	0.029	0.029	0.03	0.028
			f (mm/min)	150	160	200	190	210	195	185	140	100
K	15-20 Cast Iron	v_c (m/min)	70	75	80	80	85	85	85	95	85	
		n	7430	5970	5090	4240	3380	2700	2255	1890	1350	
		f_z	0.006	0.01	0.012	0.014	0.019	0.023	0.022	0.023	0.022	
		f (mm/min)	180	240	245	235	255	250	200	175	120	
H	38 Hardened Steel	45-55	v_c (m/min)	25	30	35	35	35	35	35	35	35
			n	2650	2385	2230	1855	1390	1115	925	695	555
			f_z	0.006	0.008	0.011	0.013	0.017	0.021	0.020	0.022	0.023
			f (mm/min)	65	75	95	95	95	95	75	60	50
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