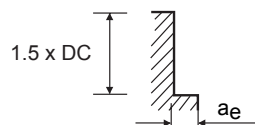
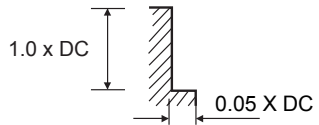


CUTTING DATA

175323 (5 Flute VX5 Roughing)												
VDI MATERIAL GROUP	HRc	SIDE CUTTING	Size (mm)									
			6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0		
M	12-14	Stainless Steel	v_c (m/min)	80	80	80	80	80	80	80	80	80
			n	4244	3183	2546	2122	1819	1592	1273	1019	
			f_z	0.025	0.034	0.041	0.051	0.057	0.063	0.081	0.091	
			f (mm/min)	531	541	522	541	518	501	516	463	
S	31-35	HRSA Fe & Ni/Co Based	v_c (m/min)	40	40	40	40	40	40	40	40	40
			n	2122	1592	1273	1061	909	796	637	509	
			f_z	0.020	0.025	0.037	0.040	0.046	0.052	0.061	0.068	
			f (mm/min)	212	199	236	212	209	207	197	173	
	36-37	Titanium/Titanium Alloys	v_c (m/min)	65	65	65	65	65	65	65	65	65
			n	3448	2586	2069	1724	1478	1293	1035	828	
			f_z	0.022	0.031	0.038	0.046	0.052	0.058	0.074	0.084	
			f (mm/min)	379	401	393	397	384	375	383	348	

<p>MATERIAL GROUP M, S36-37</p>  <p>$1.5 \times DC$</p> <p>a_e</p> <p>a_e: $\phi 6.0 - \phi 10.0 : 0.15 \times DC$ $\phi 12.0 - \phi 16.0 : 0.1 \times DC$ $\phi 20.0 - \phi 25.0 : 0.05 \times DC$</p>	<p>MATERIAL GROUP S31-35</p>  <p>$1.0 \times DC$</p> <p>$0.05 \times DC$</p>
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0.35 x DC - S36-37

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