

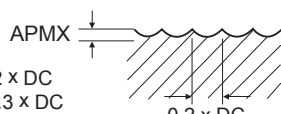
CUTTING DATA

307303, 307323, 308303, 308323 (3 Flute, Ball Nose)														
VDI MATERIAL GROUP			HRC		Size (mm)									
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
P	1-5	Non-alloy Steel	<25	v _c (m/min)	105	110	125	135	155	170	190	200	205	225
				n	11140	8755	7960	7160	6165	5410	5040	4545	4080	3580
				f _z	0.019	0.026	0.033	0.046	0.068	0.089	0.112	0.135	0.15	0.15
				f (mm/min)	635	685	790	990	1259	1445	1695	1610	1470	1290
	6-9	Low alloy Steel	25-35	v _c (m/min)	105	110	125	135	155	170	190	200	205	225
				n	11140	8755	7960	7160	6165	5410	5040	4545	4080	3580
				f _z	0.019	0.026	0.033	0.046	0.068	0.089	0.112	0.135	0.15	0.15
				f (mm/min)	635	685	790	990	1259	1445	1695	1610	1470	1290
K	15-20	Cast Iron		v _c (m/min)	65	65	65	65	65	65	65	60	65	65
				n	6895	5170	4140	3450	2585	2070	1725	1365	1295	1035
				f _z	0.012	0.021	0.03	0.04	0.068	0.083	0.097	0.135	0.149	0.149
				f (mm/min)	250	325	375	415	525	515	500	485	460	370
N	21-24	Aluminium/ Aluminium Alloys		v _c (m/min)	195	195	190	195	200	195	195	190	195	185
				n	20690	15520	12095	10345	7960	6205	5170	4320	3880	2945
				f _z	0.007	0.01	0.015	0.017	0.026	0.033	0.046	0.053	0.069	0.069
				f (mm/min)	435	465	545	530	620	615	715	600	640	490

MATERIAL GROUP P

APMX : ø3.0mm - ø6.0mm = 0.2 x DC

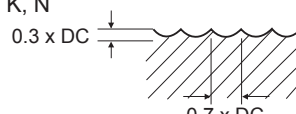
APMX : ø8.0mm - ø25.0mm = 0.3 x DC



MATERIAL GROUPS K, N

0.3 x DC

0.7 x DC



► The feed rate for long, long reach and uncoated tools should be reduced by up to 50%

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