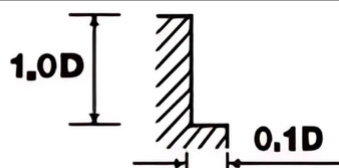


VORTEX COATED CARBIDE

3 FLUTE

CUTTING DATA for SIDE CUTTING

Material	NON-ALLOYED STEEL ALLOY STEEL & TOOL STEEL				ALLOY STEEL & HEAT RESISTANT STEEL				STAINLESS STEEL			
Hardness	≤ HRc30				HRc30 - HRc45				-			
Strength	≤ 1000 N/mm ²				1000 - 1500 N/mm ²				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	17600	110	55	0.002	10250	65	30	0.002	8650	55	25	0.002
1.5	11800	16	55	0.005	7050	85	35	0.004	7050	90	35	0.004
2	9850	180	60	0.006	6450	120	40	0.006	5350	100	35	0.006
3	7600	205	70	0.009	4750	130	45	0.009	3950	105	35	0.009
4	6450	365	80	0.019	3950	220	50	0.019	3300	180	40	0.018
5	5350	385	85	0.024	3200	230	50	0.024	2700	195	40	0.024
6	4750	425	90	0.030	2850	265	55	0.031	2400	215	45	0.030
8	3550	450	90	0.042	2150	245	55	0.038	1800	225	45	0.042
10	2750	390	85	0.047	1700	195	55	0.038	1450	195	45	0.045
12	2350	330	90	0.047	1450	160	55	0.037	1150	155	45	0.045
14	2100	465	90	0.074	1300	145	55	0.037	1050	140	45	0.044
16	1850	265	95	0.048	1150	130	60	0.038	900	130	45	0.048
20	1450	205	90	0.047	900	100	55	0.037	700	100	45	0.048



Material	CAST IRON				ALUMINIUM ALLOYS				COPPER, BRASS NON-FERROUS METALS			
Hardness	-				-				-			
Strength	-				-				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
1	18700	460	60	0.008	44000	750	140	0.006	24700	450	80	0.006
1.5	12100	46	55	0.013	27500	860	130	0.010	20300	675	95	0.011
2	9350	475	60	0.017	22000	1035	140	0.016	16500	770	105	0.016
3	6050	475	55	0.026	15400	990	145	0.021	11000	760	105	0.023
4	4600	485	60	0.035	11000	1035	140	0.031	8800	770	110	0.029
5	3650	485	55	0.044	9150	1010	145	0.037	6800	760	105	0.037
6	2950	570	55	0.064	7600	1100	145	0.048	5700	825	105	0.048
8	2200	615	55	0.093	5700	1100	145	0.064	4400	825	110	0.063
10	1850	640	60	0.115	4600	1100	145	0.080	3400	825	105	0.081
12	1450	670	55	0.154	3750	1100	140	0.098	2850	825	105	0.096
14	1300	705	55	0.181	3300	1100	145	0.111	2400	825	105	0.115
16	1100	725	55	0.22	2850	1100	145	0.129	2200	825	110	0.125
20	900	770	55	0.285	2200	1100	140	0.167	1700	825	105	0.162

NOTE: For long & extra long types the feed should be reduced by around 50%

