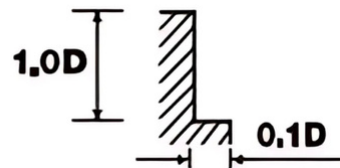


VORTEX COATED CARBIDE

4 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	150	55	0.002	10250	85	30	0.002	8650	75	25	0.002
1.5	11800	215	55	0.005	7050	115	35	0.004	7050	120	35	0.004
2	9850	240	60	0.006	6450	145	40	0.006	5350	120	35	0.006
3	7600	270	70	0.009	4750	170	45	0.009	3950	145	35	0.009
4	6450	485	80	0.019	3950	300	50	0.019	3300	240	40	0.018
5	5350	510	85	0.024	3200	305	50	0.024	2700	255	40	0.024
6	4750	560	90	0.029	2850	350	55	0.031	2400	280	45	0.029
8	3550	605	90	0.043	2150	325	55	0.038	1800	300	45	0.042
10	2750	520	85	0.047	1700	255	55	0.038	1450	255	45	0.044
12	2350	440	90	0.047	1450	215	55	0.037	1150	205	45	0.045
14	2100	395	90	0.047	1300	195	55	0.038	1050	190	45	0.045
16	1850	350	95	0.047	1150	170	60	0.037	950	170	50	0.045
20	1450	270	90	0.047	900	135	55	0.038	700	130	45	0.046



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	620	60	0.008	44000	1050	140	0.006	24700	605	80	0.006
1.5	12100	620	55	0.013	2750	1160	130	0.011	20300	910	95	0.011
2	9350	640	60	0.017	22000	1320	140	0.015	16500	1035	105	0.016
3	6050	640	55	0.026	15400	1320	145	0.021	11000	1035	105	0.024
4	4600	640	60	0.035	11000	1320	140	0.030	8800	1035	110	0.029
5	3650	640	55	0.044	9150	1320	145	0.036	6800	1035	105	0.038
6	2950	770	55	0.065	7600	1430	145	0.047	5700	1100	105	0.048
8	2200	815	55	0.093	5700	1430	145	0.063	4400	1100	110	0.063
10	1850	860	60	0.116	4600	1430	145	0.078	3400	1100	105	0.081
12	1450	900	55	0.155	3750	1430	140	0.095	2850	1100	105	0.096
14	1300	945	55	0.182	3300	1430	145	0.108	2400	1100	105	0.115
16	1100	970	55	0.22	2850	1430	145	0.125	2200	1100	110	0.125
20	900	1035	55	0.288	2200	1430	140	0.163	1700	1100	105	0.162

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

