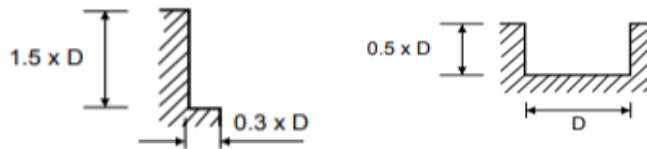


## Multiple Helix 4 Flute Endmill (PM75E)



MATERIAL GROUP	HRc		SIZE (MM)								
			6	8	10	12	14	16	18	20	25
P	≤20	Vc (M/MIN)	70	70	77	77	77	77	77	77	77
		n	3715	2785	2450	2040	1750	1530	1360	1225	980
		Fz	0.016	0.028	0.039	0.047	0.049	0.053	0.059	0.065	0.063
		F(MM/MIN)	238	312	383	384	343	325	322	319	247
	20 - 30	Vc (M/MIN)	44	44	49	49	49	49	49	49	49
		n	2335	1750	1560	1300	1115	975	865	780	620
		Fz	0.016	0.028	0.038	0.047	0.05	0.052	0.058	0.066	0.065
		F(MM/MIN)	149	196	237	244	223	203	201	206	162
M		Vc (M/MIN)	48	48	48	48	48	48	48	48	48
		n	2545	1910	1525	1270	1090	955	850	760	610
		Fz	0.018	0.029	0.048	0.056	0.06	0.063	0.081	0.077	0.078
		F(MM/MIN)	183	222	294	285	262	241	275	235	191
K		Vc (M/MIN)	45	55	50	50	50	55	55	55	55
		n	2385	2185	1590	1325	1135	1095	970	875	635
		Fz	0.018	0.028	0.038	0.047	0.05	0.052	0.059	0.066	0.065
		F(MM/MIN)	172	245	242	249	227	228	230	231	166
S		Vc (M/MIN)	15	15	18	18	18	18	18	18	18
		n	795	595	570	475	405	355	315	285	230
		Fz	0.016	0.024	0.039	0.047	0.049	0.053	0.059	0.065	0.063
		F(MM/MIN)	50	57	89	90	80	76	75	75	58

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
HRc	Hardness of metal



To calculate RPM from cutting speed:  $n = \frac{v_c \cdot 1000}{\pi \cdot \phi}$

To calculate cutting speed from RPM:  $v_c = \frac{n \cdot \pi \cdot \phi}{1000}$