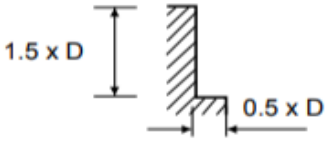
Multiple Helix 4 Flute Endmill (PM75S)

MATERIAL GROUP	HRc		SIZE (MM)								
			6	8	10	12	14	16	18	20	25
P	≤30	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
	30 - 40	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)	29	43	43	43	44	43	45	44	44
		n	2070	1710	1365	1140	1000	855	795	700	560
		Fz	0.019	0.03	0.045	0.064	0.059	0.069	0.075	0.084	0.104
		F(MM/MIN)	157	205	246	292	295	295	299	294	290
K		Vc (M/MIN)	40	50	45	45	45	50	50	50	45
		n	2120	1990	1430	1190	1020	995	885	795	570
		Fz	0.02	0.03	0.053	0.069	0.063	0.069	0.062	0.072	0.088
		F(MM/MIN)	170	239	304	330	322	343	274	287	252
S		Vc (M/MIN)	12	12	15	15	15	15	15	15	15
		n	635	475	475	395	340	300	265	235	190
		Fz	0.018	0.028	0.042	0.061	0.055	0.066	0.06	0.069	0.082
		F(MM/MIN)	46	54	80	97	94	90	80	82	78

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: $n = \frac{V_c \cdot 1000}{\pi \cdot \varnothing}$

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

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.