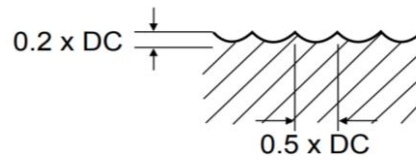


Solid Milling - Carbide - 2 Flute - VOR45-2ABN / 2ALBN / WAB312



MATERIAL GROUP		TYPE OF CUT		Recommended Feed Rate (mm/Rev)					
				Diameter					
				6.0	8.0	10.0	12.0	16.0	20.0
N	Aluminium	SLOTTING	Vc (m/min)	270	280	350	420	440	350
			n	14400	11200	11200	11200	8800	5600
			fz	0.049	0.071	0.084	0.07	0.123	0.157
	f (mm/min)		1400	1600	1880	2400	2160	1760	
	Plastics		Vc (m/min)	85	85	105	125	135	105
			n	4400	3360	3360	3360	2640	1680
			fz	0.04	0.06	0.069	0.089	0.101	0.131
f (mm/min)		350	400	465	600	535	440		



N - Non-ferrous metals and aluminium

Vc	Cutting speed (m/min)
n	RPM (rev/min)
fn	Feed rate (mm/rev)
∅	drill diameter (mm)

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

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

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%.

