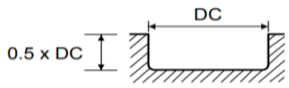
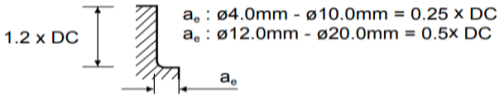
Solid Milling - Carbide - 2 Flute Corner Radius
VOR45-RA245 / RALS245 / WAR302

MATERIAL GROUP		TYPE OF CUT		Recommended Feed Rate (mm/Rev)						
				Diameter						
				4.0	6.0	8.0	10.0	12.0	16.0	20.0
N	Aluminium	SLOTTING	Vc (m/min)	130	195	200	250	300	320	250
			n	10400	10400	8000	8000	8000	6400	4000
			fz	0.046	0.058	0.09	0.11	0.135	0.156	0.2
			f (mm/min)	960	1200	1440	1760	2160	2000	1600
		SIDE CUTTING	Vc (m/min)	130	195	200	250	300	320	250
			n	10400	10400	8000	8000	8000	6400	4000
			fz	0.054	0.077	0.115	0.135	0.17	0.194	0.25
			f (mm/min)	1120	1600	1840	2160	2720	2480	2000

SLOTTING



SIDE CUTTING



N - Non-ferrous metals and aluminium

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

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

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

The feed rate for long & long series tools should be reduced by up to 50%

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%.