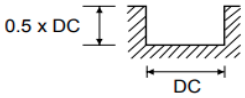
Solid Milling - Carbide - 3 Flute 45º Helix, Long, Necked & Long Series
VOR55-A3 / WAE30(2)3 / VOR45-A355 / ALS355

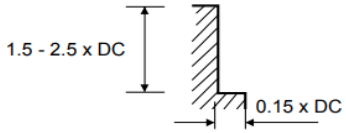


MATERIAL GROUP		TYPE OF CUT		Recommended Feed Rate (mm/Rev)								
				Diameter								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
N	Aluminium	SLOTTING	Vc (m/min)	65	90	110	130	140	175	210	210	175
			n	7000	7000	7000	7000	5600	5600	5600	4200	2800
			fz	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
			f (mm/min)	730	940	1050	1250	1470	1780	2200	1990	1680
		SIDE CUTTING	Vc (m/min)	65	90	110	130	140	175	210	210	175
			n	7000	7000	7000	7000	5600	5600	5600	4200	2800
			fz	0.045	0.055	0.065	0.075	0.113	0.131	0.163	0.2	0.238
			f (mm/min)	940	1150	1360	1580	1900	2200	2740	2520	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: $n = \frac{V_c * 1000}{\pi * \varnothing}$

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

The feed rate for long series and long necked 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%.