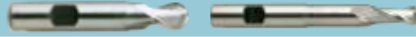
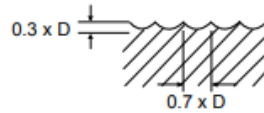


112102, 114102 (2 Flute, Ball Nose)



MATERIAL GROUP	HRc		Size (mm)									
			3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0	
P	11 12	< 20	v_c (m/min)	30	30	30	30	30	30	30	30	30
			n	3400	2400	1700	1200	1000	800	600	500	400
			f_z	0.01	0.017	0.026	0.044	0.06	0.066	0.083	0.085	0.088
			f (mm/min)	70	80	90	105	120	105	100	85	70
	11 12	20-30	v_c (m/min)	20	20	20	20	20	15	20	20	15
			n	2000	1400	1000	700	560	450	350	300	220
			f_z	0.008	0.013	0.026	0.036	0.054	0.061	0.079	0.083	0.091
			f (mm/min)	30	35	45	50	60	55	55	50	40
	13 14	30-40	v_c (m/min)	15	15	15	15	15	15	15	15	15
			n	1400	1000	700	500	400	320	250	200	160
			f_z	0.007	0.013	0.018	0.03	0.044	0.055	0.07	0.088	0.094
			f (mm/min)	20	25	25	30	35	35	35	35	30
N	71 72 73	v_c (m/min)	105	100	105	100	100	95	100	100	100	
		n	11000	8000	5600	4000	3200	2500	2000	1600	1300	
		f_z	0.01	0.016	0.025	0.044	0.056	0.068	0.075	0.088	0.096	
		f (mm/min)	230	260	280	350	360	340	300	280	250	



- ▶ The feed rate for long and long reach tools should be reduced by up to 50%
- ▶ The speeds and feeds for TiAlN coated tools can be increased by up to 30%