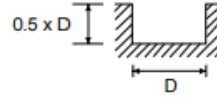


131102 (3 Flute Aluminium Roughing)

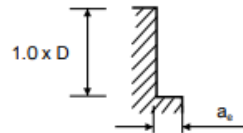


MATERIAL GROUP	HRc		Size (mm)								
			3.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
N	71	v_c (m/min)	75	130	150	155	190	155	175	130	145
	72	n	8000	7000	6000	5000	5000	3500	3500	2300	2300
	73	f_z	0.035	0.05	0.071	0.12	0.12	0.177	0.177	0.283	0.283
		f (mm/min)	560	700	850	1200	1200	1240	1240	1300	1300



MATERIAL GROUP	HRc		Size (mm)								
			3.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
N	71	v_c (m/min)	75	130	150	155	190	155	175	130	145
	72	n	8000	7000	6000	5000	5000	3500	3500	2300	2300
	73	f_z	0.046	0.064	0.092	0.15	0.15	0.229	0.229	0.37	0.37
		f (mm/min)	730	900	1100	1500	1500	1600	1600	1700	1700

$a_p : \phi 3.0\text{mm} - \phi 10.0\text{mm} = 0.25 \times D$
 $a_p : \phi 12.0\text{mm} - \phi 20.0\text{mm} = 0.5 \times D$



► The speeds and feeds for TiAlN coated tools can be increased by up to 30%