

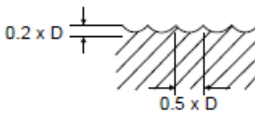


112303 (2 Flute 50° Helix, Ball Nose)

MATERIAL GROUP	Type of cut		Size (mm)						
			6.0	8.0	10.0	12.0	16.0	20.0	
N	Copper and Copper alloys		v_c (m/min)	85	85	105	125	135	105
			n	4400	3360	3360	3360	2640	1680
			f_z	0.04	0.06	0.069	0.089	0.101	0.131
			f (mm/min)	350	400	465	600	535	440
	Aluminium and Aluminium alloys		v_c (m/min)	270	280	350	420	440	350
			n	14400	11200	11200	11200	8800	5600
			f_z	0.049	0.071	0.084	0.07	0.123	0.157
			f (mm/min)	1400	1600	1880	2400	2160	1760



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%.

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed per tooth (mm)
 f - feed rate (mm/min)
 a_p - axial depth of cut
 a_e - radial depth of cut