

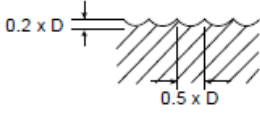


116303 (3 Flute 40° Helix, Ball Nose)

MATERIAL GROUP		Type of cut		Size (mm)								
				2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0
N	61 62 63 64 Copper and Copper alloys		v_c (m/min)	40	40	55	70	85	85	105	125	135
			n	6400	4400	4400	4400	4400	3360	3360	3360	2640
			f_z	0.015	0.022	0.028	0.031	0.04	0.06	0.069	0.089	0.101
			f (mm/min)	190	190	250	270	350	400	465	600	535
	71 72 73 74 Aluminium and Aluminium alloys		v_c (m/min)	135	135	180	225	270	280	350	420	440
			n	21600	14400	14400	14400	14400	11200	11200	11200	8800
			f_z	0.018	0.026	0.035	0.038	0.049	0.071	0.084	0.107	0.123
			f (mm/min)	760	760	1000	1080	1400	1600	1880	2400	2160



0.2 x D
0.5 x D