

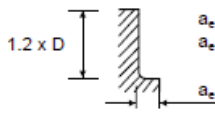


155303 (2 Flute Corner Radius)

MATERIAL GROUP		Type of cut		Size (mm)						
				4.0	6.0	8.0	10.0	12.0	16.0	20.0
N	Aluminium and Aluminium alloys		v_c (m/min)	130	195	200	250	300	320	250
			n	10400	10400	8000	8000	8000	6400	4000
			f_z	0.054	0.077	0.115	0.135	0.17	0.194	0.25
			f (mm/min)	1120	1600	1840	2160	2720	2480	2000
			v_c (m/min)	130	195	200	250	300	320	250
			n	10400	10400	8000	8000	8000	6400	4000
			f_z	0.046	0.058	0.09	0.110	0.135	0.156	0.2
			f (mm/min)	960	1200	1440	1760	2160	2000	1600
SIDE CUTTING				SLOTTING						
 <p> $a_e : \varnothing 4.0\text{mm} - \varnothing 10.0\text{mm} = 0.25 \times D$ $a_e : \varnothing 12.0\text{mm} - \varnothing 20.0\text{mm} = 0.5 \times D$ </p>				