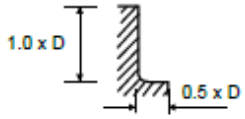
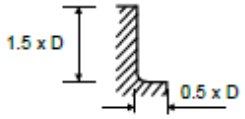
140323, 142323 (4 Flute, Corner Radius)

MATERIAL GROUP		HRc		Size (mm)							
				2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	11 12	< 30	v_c (m/min)	60	70	80	85	90	90	85	90
			n	9850	7600	6450	5350	4750	3550	2750	2350
			f_z	0.006	0.009	0.019	0.024	0.029	0.043	0.047	0.047
			f (mm/min)	240	270	480	510	560	605	520	440
	13 14	30-45	v_c (m/min)	40	45	50	50	55	55	55	55
			n	6450	4750	3950	3200	2850	2150	1700	1450
			f_z	0.006	0.009	0.019	0.024	0.031	0.038	0.038	0.037
			f (mm/min)	145	170	300	305	350	325	255	215
M	21 22		v_c (m/min)	35	35	40	40	45	45	45	45
			n	5350	3950	3300	2700	2400	1800	1450	1150
			f_z	0.006	0.009	0.018	0.024	0.029	0.042	0.044	0.045
			f (mm/min)	120	145	240	255	280	300	255	205
K	31 32 33		v_c (m/min)	60	55	60	55	55	55	60	55
			n	9350	6050	4600	3650	2950	2200	1850	1450
			f_z	0.017	0.026	0.035	0.044	0.065	0.093	0.116	0.155
			f (mm/min)	640	640	640	640	770	815	860	900
N	61 62 63		v_c (m/min)	105	105	110	105	105	110	105	105
			n	16500	11000	8800	6800	5700	4400	3400	2850
			f_z	0.016	0.024	0.029	0.038	0.048	0.063	0.081	0.096
			f (mm/min)	1035	1035	1035	1035	1100	1100	1100	1100
	71 72 73		v_c (m/min)	140	145	140	145	145	145	145	140
			n	22000	15400	11000	9150	7600	5700	4600	3750
			f_z	0.015	0.021	0.03	0.036	0.047	0.063	0.078	0.095
			f (mm/min)	1320	1320	1320	1320	1430	1430	1430	1430

STEEL, STAINLESS STEEL



CAST IRON, COPPER, ALUMINIUM



▶ The feed rate for long and long reach tools should be reduced by up to 50%

v_c - cutting speed (m/min)
n - RPM (rev/min)
f_Z - feed rate (mm/tooth)
f - feed rate (mm/rev)
z - No. of teeth
a_p - axial depth of cut
a_e - radial depth of cut

To calculate RPM from cutting speed: $n = \frac{v_c \times 1000}{\pi * \varnothing}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * \varnothing}{1000}$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.