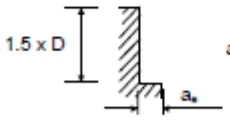
Cutting Conditions 175323 (5 Flute VX5 Roughing)

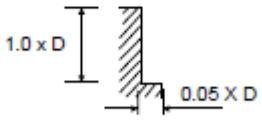
MATERIAL GROUP			Type of cut		Diameter (mm)							
					6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0
M	21 22 23	Stainless steel		v_c (m/min)	80 (64-96)							
				n	4244	3183	2546	2122	1819	1592	1273	1019
				f_z	0.025	0.034	0.041	0.051	0.057	0.063	0.081	0.091
				f (mm/min)	531	541	522	541	518	501	516	463
S	41 42 43	Titanium, Titanium alloys		v_c (m/min)	65 (52-78)							
				n	3448	2586	2069	1724	1478	1293	1035	828
				f_z	0.022	0.031	0.038	0.046	0.052	0.058	0.074	0.084
				f (mm/min)	379	401	393	397	384	375	383	348
	51 52 53	Nickel, Nickel alloys		v_c (m/min)	40 (32-48)							
				n	2122	1592	1273	1061	909	796	637	509
				f_z	0.020	0.025	0.037	0.040	0.046	0.052	0.061	0.068
				f (mm/min)	212	199	236	212	209	207	197	173

SIDE CUTTING - STAINLESS & TITANIUM



a_e: ø6.0 - ø10.0 : 0.15 x D
ø12.0 - ø16.0 : 0.1 x D
ø20.0 - ø 25.0 : 0.05 x D

SIDE CUTTING - NICKEL



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.
Finishing cuts typically require reduced feed rates and/or higher spindle speed, with a_e of 2% x D; please adjust parameters accordingly.

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