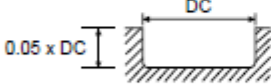
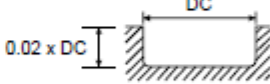


100350 (2 Flute Miniature)

MATERIAL GROUP	HARDNESS HRC		Size (mm)									
			0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.5	2.0	
<b>P</b>	13 14	30-40	$v_c$ (m/min)	45	65	80	95	125	150	160	175	210
			$n$	47770	51750	50955	50425	49780	47770	42480	37155	33435
			$f_z$	0.002	0.002	0.004	0.005	0.006	0.008	0.009	0.011	0.013
			$f$ (mm/min)	190	205	405	500	595	760	760	815	885
<b>H</b>	15 16	40-50	$v_c$ (m/min)	40	55	70	85	100	120	130	145	165
			$n$	42480	43790	44585	45115	39805	38215	34500	30785	26270
			$f_z$	0.002	0.002	0.003	0.004	0.006	0.008	0.009	0.011	0.013
			$f$ (mm/min)	170	175	285	360	475	610	620	675	680
	15 16	50-55	$v_c$ (m/min)	40	50	65	75	75	80	85	100	110
			$n$	42480	39805	41400	39805	29855	25475	22555	21230	17515
			$f_z$	0.001	0.002	0.003	0.004	0.005	0.007	0.008	0.01	0.012
			$f$ (mm/min)	85	155	245	315	295	355	360	425	420
	15 16	55-60	$v_c$ (m/min)	30	40	50	55	65	65	75	80	90
			$n$	31845	31845	31845	29190	25875	20700	19900	16985	14330
			$f_z$	0.001	0.001	0.002	0.003	0.004	0.005	0.006	0.007	0.009
			$f$ (mm/min)	60	60	125	175	205	205	235	235	255
	15 16	60-65	$v_c$ (m/min)	25	30	40	45	50	50	55	60	70
			$n$	26535	23885	25475	23885	19900	15920	14595	12735	11145
			$f_z$	0.001	0.001	0.002	0.002	0.003	0.004	0.005	0.006	0.007
			$f$ (mm/min)	50	45	100	95	115	125	145	150	155
< HRc55												
> HRc55												

$v_c$  - 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:  $n = \frac{v_c \cdot 1000}{\pi \cdot \phi}$

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

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.