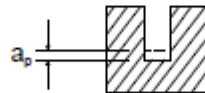


100450 (2 Flute Rib Processing)

MATERIAL GROUP	HARDNESS HRc		Size (mm)							
			0.1	0.2	0.3	0.4	0.5	0.6	0.8	
P	13 14	30-45	a_p (mm)	0.01	0.01	0.01	0.016	0.018	0.021	0.024
			v_c (m/min)	15	31	44	45	46	52	54
			n	47770	49360	46700	35800	29200	27600	21490
			f_z	0.0025	0.0035	0.004	0.006	0.007	0.008	0.011
			f (mm/min)	240	345	375	430	410	440	470
H	15 15	45-55	a_p (mm)	0.007	0.007	0.009	0.011	0.013	0.014	0.017
			v_c (m/min)	15	31	41	41	39	40	40
			n	47770	49360	43520	32640	24840	21230	15920
			f_z	0.002	0.003	0.003	0.005	0.006	0.007	0.009
			f (mm/min)	190	295	260	320	295	295	285
	16 16	55-65	a_p (mm)	0.005	0.005	0.007	0.008	0.008	0.009	0.01
			v_c (m/min)	15	31	26	27	25	26	27
			n	47770	49360	27600	21490	15920	13800	10740
			f_z	0.001	0.002	0.003	0.004	0.005	0.006	0.007
			f (mm/min)	95	195	165	170	160	165	150
N	61 62 63 64	a_p (mm)	0.016	0.016	0.018	0.031	0.033	0.035	0.041	
		v_c (m/min)	15	31	46	62	74	82	90	
		n	47770	49360	48830	49380	47130	43520	35820	
		f_z	0.003	0.005	0.006	0.008	0.011	0.012	0.014	
		f (mm/min)	285	490	585	790	1035	1045	1000	



► The data shown is based on medial length tools. Please adjust machining conditions according to length.

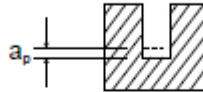
v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed rate (mm/tooth)
 f - feed rate (mm/rev)
 z - No. of teeth
 a_p - axial depth of cut
 a_e - radial depth of cut

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

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

100450 (2 Flute Rib Processing)

MATERIAL GROUP	HARDNESS HRC		Size (mm)						
			1.0	1.2	1.5	2.0	3.0	4.0	
P	13 14	30-45	a_p (mm)	0.02	0.047	0.047	0.08	0.13	0.17
			v_c (m/min)	49	52	53	53	53	54
			n	15800	13800	11250	8435	5620	4295
			f_z	0.014	0.017	0.024	0.027	0.063	0.064
			f (mm/min)	435	465	540	455	705	550
H	15 16	45-55	a_p (mm)	0.014	0.028	0.033	0.057	0.095	0.12
			v_c (m/min)	34	35	36	40	41	41
			n	10800	9280	7640	6365	4350	3260
			f_z	0.012	0.014	0.018	0.022	0.056	0.056
			f (mm/min)	280	280	275	280	485	365
	15 16	55-65	a_p (mm)	0.008	0.017	0.02	0.034	0.057	0.076
			v_c (m/min)	22	23	23	26	26	26
			n	7000	6100	4880	4140	2760	2070
			f_z	0.007	0.008	0.011	0.013	0.035	0.035
			f (mm/min)	95	95	105	105	190	145
N	61 62 63 64		a_p (mm)	0.033	0.068	0.08	0.138	0.228	0.3
			v_c (m/min)	89	93	94	102	104	104
			n	28340	24680	19955	16240	11040	8280
			f_z	0.018	0.021	0.026	0.033	0.079	0.079
			f (mm/min)	1020	1030	1035	1070	1740	1305



► The data shown is based on medial length tools. Please adjust machining conditions according to length.

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