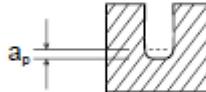


101850, 102350 (2 Flute Cm Rad Rib Processing)

MATERIAL GROUP	HARDNESS HRC		Size (mm)							
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	
P	13 14	30-45	a_p (mm)	0.0203	0.0179	0.0238	0.0193	0.0473	0.0609	0.0805
			v_c (m/min)	46	52	53	49	52	63	53
			n	29295	27600	21095	15805	13800	13375	8435
			f_z	0.028	0.032	0.045	0.057	0.067	0.094	0.107
			f (mm/min)	7555	1765	1895	1775	1845	2515	1805
H	15 15	45-55	a_p (mm)	0.013	0.0145	0.0143	0.0138	0.0285	0.0332	0.0575
			v_c (m/min)	39	40	40	35	36	36	40
			n	24840	21230	15920	11145	9550	7640	6365
			f_z	0.024	0.026	0.037	0.048	0.055	0.07	0.089
			f (mm/min)	1190	1100	1175	1070	1050	1070	1130
	15 16	55-60	a_p (mm)	0.0077	0.0087	0.0083	0.0102	0.0171	0.0199	0.0345
			v_c (m/min)	25	26	26	22	23	23	26
			n	15920	13800	10350	7005	6100	4880	4140
			f_z	0.015	0.016	0.022	0.03	0.035	0.044	0.053
			f (mm/min)	475	440	455	420	425	430	435



► 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: $n = \frac{v_c \times 1000}{\pi \times \phi}$

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

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.

101850, 102350 (2 Flute Cm Rad Rib Processing)

MATERIAL GROUP	HARDNESS HRc		Size (mm)				
			3.0	4.0	6.0	8.0	
P	13 14	30-45	a_p (mm)	0.08	0.09	0.1	0.1
			v_c (m/min)	65	70	85	100
			n	6900	5570	4510	3980
			f_z	0.114	0.12	0.16	0.19
			f (mm/min)	1570	1335	1440	1510
H	15 16	45-55	a_p (mm)	0.05	0.06	0.07	0.07
			v_c (m/min)	45	50	65	80
			n	4775	3980	3450	3185
			f_z	0.08	0.09	0.12	0.14
			f (mm/min)	760	715	825	890
	15 16	55-60	a_p (mm)	0.03	0.04	0.05	0.05
			v_c (m/min)	30	35	45	60
			n	3185	2785	2385	2385
			f_z	0.06	0.07	0.09	0.12
			f (mm/min)	380	390	430	570

The diagram illustrates a cross-section of a 2-flute radial rib. A horizontal dimension line labeled a_p indicates the axial depth of cut, which is the distance from the outer edge of the rib to the start of the flute.

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

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.