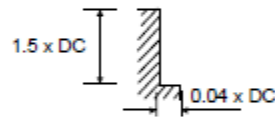


102950 (6 Flute 45° Long Length)

MATERIAL GROUP	HARDNESS HRC		Size (mm)									
			6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	
<b>P</b>	13 14	30-40	$v_c$ (m/min)	120	120	120	120	120	120	120	120	125
			$n$	6365	4775	3820	3185	2730	2385	2120	1910	1590
			$f_t$	0.039	0.052	0.063	0.07	0.081	0.09	0.095	0.099	0.11
			$f$ (mm/min)	1490	1490	1440	1335	1325	1290	1610	1510	1400
<b>H</b>	15 16	40-55	$v_c$ (m/min)	95	95	95	95	95	95	95	95	100
			$n$	5040	3780	3025	2520	2160	1890	1680	1510	1270
			$f_t$	0.035	0.046	0.055	0.062	0.07	0.079	0.08	0.091	0.096
			$f$ (mm/min)	1055	1040	995	935	905	895	1075	1100	975
	15 16	55-65	$v_c$ (m/min)	70	70	70	70	70	70	70	70	75
			$n$	3715	2785	2225	1855	1590	1390	1235	1115	955
			$f_t$	0.031	0.042	0.05	0.056	0.066	0.072	0.073	0.079	0.087
			$f$ (mm/min)	690	700	665	620	630	600	720	700	665
	15 16	65-70	$v_c$ (m/min)	50	50	50	50	50	50	50	50	55
			$n$	2650	1990	1590	1325	1135	995	885	795	700
			$f_t$	0.028	0.037	0.045	0.05	0.051	0.064	0.066	0.071	0.079
			$f$ (mm/min)	445	440	430	395	345	380	465	450	440



$v_c$  - 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  
 $a_w$  - 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.