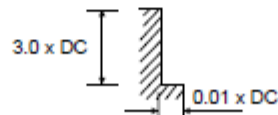


103950 (6 Flute 45° Extra Length)

MATERIAL GROUP	HARDNESS HRc		Size (mm)							
			6.0	8.0	10.0	12.0	16.0	20.0	25.0	
P	13 14	30-40	v_c (m/min)	60	60	60	60	60	60	60
			n	3185	2385	1910	1590	1190	955	760
			f_z	0.04	0.05	0.06	0.07	0.081	0.086	0.089
			f (mm/min)	760	715	685	685	580	655	540
H	15 16	40-55	v_c (m/min)	60	60	60	60	60	60	60
			n	3185	2385	1910	1590	1190	955	760
			f_z	0.03	0.04	0.05	0.061	0.071	0.08	0.08
			f (mm/min)	570	570	570	580	505	610	485
	15 16	55-65	v_c (m/min)	50	50	50	50	50	50	50
			n	2850	1990	1590	1325	995	795	635
			f_z	0.03	0.04	0.05	0.06	0.07	0.08	0.08
			f (mm/min)	475	475	475	475	415	510	405



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.