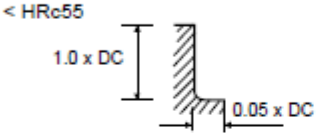
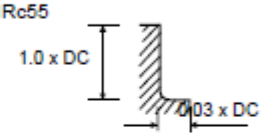
108350 (6 Flute 45° Corner Radius)

MATERIAL GROUP		HARDNESS HRc		Size (mm)					
				6.0	8.0	10.0	12.0	16.0	20.0
P	13 14	30-40	v_c (m/min)	465	490	505	505	505	505
			n	24680	19500	16080	13400	10050	8040
			f_z	0.036	0.046	0.051	0.058	0.067	0.07
			f (mm/min)	5330	5380	4920	4660	4040	3375
H	15 16	40-50	v_c (m/min)	445	470	480	485	490	490
			n	23620	18710	15285	12870	9750	7800
			f_z	0.035	0.044	0.048	0.055	0.064	0.073
			f (mm/min)	4960	4935	4400	4245	3745	3415
	15 16	50-55	v_c (m/min)	300	300	300	300	300	300
			n	15920	11940	9550	7960	5970	4775
			f_z	0.051	0.064	0.072	0.079	0.094	0.111
			f (mm/min)	4870	4585	4125	3770	3360	3180
	15 16	55-60	v_c (m/min)	250	250	250	250	250	250
			n	13270	9950	7960	6635	4975	3980
			f_z	0.041	0.052	0.06	0.063	0.077	0.088
			f (mm/min)	3260	3105	2885	2505	2295	2100
	15 16	60-65	v_c (m/min)	200	200	200	200	200	200
			n	10615	7960	6365	5305	3980	3185
			f_z	0.033	0.042	0.047	0.05	0.052	0.053
			f (mm/min)	2100	2005	1795	1590	1240	1010
	15 16	65-70	v_c (m/min)	150	150	150	150	150	150
			n	7960	5970	4775	3980	2985	2385
			f_z	0.03	0.036	0.04	0.043	0.047	0.05
			f (mm/min)	1430	1290	1145	1025	840	715

< HRc55



> HRc55



- 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: $n = \frac{v_c * 1000}{\pi * \varnothing}$

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

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.