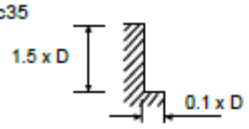
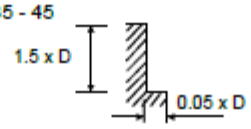
106365 (6 Flute, 45° Helix) 

MATERIAL GROUP		HARDNESS HRc		Size (mm)					
				6.0	8.0	10.0	12.0	16.0	20.0
P	13	< 35	v_c (m/min)	105	106	106	107	106	106
			n	5560	4200	3360	2840	2100	1680
	14		f_z	0.06	0.079	0.099	0.099	0.1	0.1
			f (mm/min)	2000	2000	2000	1680	1260	1010
H	15	35-45	v_c (m/min)	73	74	73	75	74	73
			n	1370	2940	2320	2000	1480	1160
	15		f_z	0.059	0.078	0.098	0.097	0.099	0.099
			f (mm/min)	3880	1370	1370	1160	880	690
	15	45-55	v_c (m/min)	30	29	31	32	32	31
			n	1580	1160	1000	840	640	500
	15		f_z	0.022	0.03	0.035	0.036	0.034	0.037
			f (mm/min)	210	210	210	180	130	110
K	31		v_c (m/min)	105	106	106	107	106	106
	32		n	5560	4200	3360	2840	2100	1680
	33		f_z	0.06	0.079	0.099	0.099	0.1	0.1
	34		f (mm/min)	2000	2000	2000	1680	1260	1010

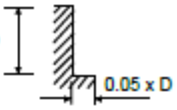
< HRc35



HRc35 - 45



> HRc45



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

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

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.