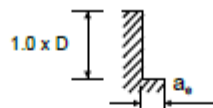


126365 (4 Flute Extended Neck)



MATERIAL GROUP	HARDNESS HRc		Size (mm)									
			1.0	1.5	2.0	3.0	4.0	5.0	6.0	8.0	10.0	
P	13 14	< 35	a_p (mm)	0.005	0.008	0.011	0.025	0.034	0.042	0.088	0.118	0.147
			v_c (m/min)	55	72	70	91	103	107	128	127	123
			n	17600	15300	11120	9630	9160	6800	6670	5040	3910
			f_z	0.003	0.004	0.005	0.008	0.017	0.022	0.03	0.042	0.047
			f (mm/min)	200	260	210	310	550	585	790	850	730
H	15 16	35-45	a_p (mm)	0.004	0.006	0.008	0.019	0.025	0.032	0.066	0.088	0.11
			v_c (m/min)	34	45	46	57	63	64	76	76	75
			n	10800	9630	7260	6000	4990	4080	4030	3020	2400
			f_z	0.003	0.004	0.004	0.008	0.017	0.021	0.03	0.037	0.038
			f (mm/min)	115	155	130	195	340	350	490	450	360
	16 16	45-55	a_p (mm)	0.003	0.005	0.006	0.015	0.02	0.025	0.053	0.071	0.088
			v_c (m/min)	21	28	30	34	40	39	45	51	51
			n	6800	5850	4800	3630	3180	2500	2400	2010	1630
			f_z	0.001	0.002	0.002	0.004	0.004	0.007	0.01	0.016	0.016
			f (mm/min)	30	40	40	55	55	70	95	130	105
K	31 32 33 34		a_p (mm)	0.005	0.008	0.011	0.025	0.034	0.042	0.088	0.118	0.147
			v_c (m/min)	55	72	70	91	103	107	128	127	123
			n	17600	15300	11120	9630	9160	6800	6670	5040	3910
			f_z	0.003	0.004	0.005	0.008	0.017	0.022	0.03	0.042	0.047
			f (mm/min)	200	260	210	310	550	585	790	850	730



► 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

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

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

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.