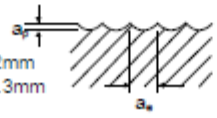
114320 (2 Flute Long Reach, Ball Nose)

MATERIAL GROUP		HARDNESS HRc	NORMAL SPEED	Size (mm)									
				2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	13 14	< 30-40	v_c (m/min)	60	75	85	90	105	115	130	140	150	165
			n	9250	8000	6720	5840	5500	4600	4070	3700	3000	2600
			f_z	0.014	0.023	0.031	0.039	0.055	0.08	0.101	0.12	0.142	0.16
			f (mm/min)	260	370	420	460	600	740	820	890	850	830
H	15 16	45-65	v_c (m/min)	25	35	40	45	50	50	50	55	55	55
			n	3870	3620	3360	2940	2550	2000	1650	1400	1100	890
			f_z	0.012	0.017	0.021	0.024	0.029	0.044	0.055	0.07	0.089	0.112
			f (mm/min)	90	120	140	140	150	175	180	195	195	200
K	31		v_c (m/min)	80	100	105	115	130	145	160	175	190	205
	32		n	12600	10500	8400	7310	6800	5700	5100	4700	3800	3300
	33		f_z	0.017	0.026	0.035	0.045	0.06	0.09	0.12	0.149	0.182	0.202
	34		f (mm/min)	420	540	590	660	820	1030	1220	1400	1380	1330

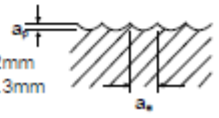
< HRc45

a_p: ø1.0mm - 6.0mm = 0.2mm
a_p: ø8.0mm - 20.0mm = 0.3mm
a_e: 0.2 x D



> HRc45

a_p: ø1.0mm - 6.0mm = 0.2mm
a_p: ø8.0mm - 20.0mm = 0.3mm
a_e: 0.1 x D



MATERIAL GROUP		HARDNESS HRc	HIGH SPEED	Size (mm)									
				2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	13 14	< 30-40	v_c (m/min)	105	160	210	265	315	335	350	370	380	400
			n	16800	16800	16800	16800	16800	13400	11200	9800	7600	6400
			f_z	0.036	0.048	0.07	0.086	0.095	0.119	0.138	0.158	0.181	0.199
			f (mm/min)	1200	1600	2350	2880	3200	3200	3100	3100	2750	2550
H	15 16	45-65	v_c (m/min)	105	130	135	150	160	170	175	185	190	200
			n	16800	13600	10930	9600	8400	6700	5600	4900	3800	3200
			f_z	0.022	0.031	0.043	0.05	0.06	0.075	0.086	0.095	0.105	0.116
			f (mm/min)	750	830	930	960	1000	1000	960	930	800	740
K	31		v_c (m/min)	105	160	210	265	315	335	350	370	380	400
	32		n	16800	16800	16800	16800	16800	13400	11200	9800	7600	6400
	33		f_z	0.036	0.048	0.07	0.086	0.095	0.119	0.138	0.158	0.181	0.199
	34		f (mm/min)	1200	1600	2350	2880	3200	3200	3100	3100	2750	2550

a_p: ø1.0mm - 6.0mm = 0.2mm
a_p: ø8.0mm - 20.0mm = 0.3mm
a_e: 0.05 x D