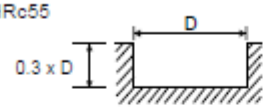
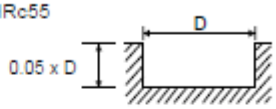
## 155120, 155320 (2 Flute Long, Corner Radius)

| MATERIAL GROUP | | HRc | | Size (mm) | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 4.0 | 5.0 | 6.0 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 |
| P | 11 12 | < 30 | $v_c$ (m/min) | 65 | 70 | 75 | 75 | 80 | 80 | 85 | 80 |
| | | | n | 5360 | 4580 | 3950 | 3000 | 2520 | 2080 | 1740 | 1260 |
| | | | $f_z$ | 0.016 | 0.023 | 0.032 | 0.045 | 0.054 | 0.051 | 0.055 | 0.056 |
| | | | f (mm/min) | 170 | 210 | 250 | 270 | 270 | 210 | 190 | 140 |
| | 13 14 | 30-45 | $v_c$ (m/min) | 45 | 45 | 50 | 50 | 50 | 50 | 55 | 50 |
| | | | n | 3410 | 2900 | 2520 | 1900 | 1640 | 1390 | 1070 | 820 |
| | | | $f_z$ | 0.012 | 0.017 | 0.025 | 0.033 | 0.038 | 0.041 | 0.042 | 0.037 |
| | | | f (mm/min) | 85 | 100 | 125 | 125 | 125 | 115 | 90 | 60 |
| H | 15 16 | 45-55 | $v_c$ (m/min) | 25 | 30 | 30 | 30 | 30 | 30 | 35 | 30 |
| | | | n | 2150 | 1900 | 1640 | 1260 | 1010 | 840 | 670 | 500 |
| | | | $f_z$ | 0.009 | 0.013 | 0.018 | 0.024 | 0.03 | 0.03 | 0.03 | 0.03 |
| | | | f (mm/min) | 40 | 50 | 60 | 60 | 60 | 50 | 40 | 30 |
| | 15 16 | 55-65 | $v_c$ (m/min) | 20 | 20 | 20 | 20 | 20 | 20 | 20 | 20 |
| | | | n | 1470 | 1260 | 1160 | 840 | 670 | 550 | 440 | 340 |
| | | | $f_z$ | 0.007 | 0.01 | 0.015 | 0.021 | 0.026 | 0.023 | 0.023 | 0.022 |
| | | | f (mm/min) | 20 | 25 | 35 | 35 | 35 | 25 | 20 | 15 |
| K | 31 32 33 34 | | $v_c$ (m/min) | 65 | 70 | 75 | 75 | 80 | 80 | 85 | 80 |
| | | | n | 5360 | 4580 | 3950 | 3000 | 2520 | 2080 | 1740 | 1260 |
| | | | $f_z$ | 0.016 | 0.023 | 0.032 | 0.045 | 0.054 | 0.051 | 0.055 | 0.056 |
| | | | f (mm/min) | 170 | 210 | 250 | 270 | 270 | 210 | 190 | 140 |

< HRc55




> HRc55




$v_c$ - 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.