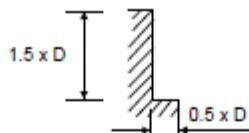


192140 (Multiflute PM Sabre, Extended Neck, Coarse Pitch)



MATERIAL GROUP	HRc		Size (mm)					
			10.0	12.0	16.0	20.0	25.0	
P	11	< 20	v _c (m/min)	47	47	47	47	
			n	1500	1200	950	760	
	12		f _x	0.045	0.058	0.074	0.092	
			f (mm/min)	270	280	280	270	
H	13	20-30	v _c (m/min)	33	33	33	33	
			n	1050	900	660	530	
	14		f _x	0.039	0.054	0.074	0.092	
			f (mm/min)	165	195	195	185	
M	21 22 23	30-40	v _c (m/min)	28	28	282	28	
			n	890	740	550	440	
			f _x	0.038	0.052	0.07	0.088	
			f (mm/min)	135	155	155	155	
K	31 32 33 34		v _c (m/min)	47	47	47	47	
			n	1500	1200	950	760	
			f _x	0.045	0.058	0.074	0.092	
			f (mm/min)	270	280	280	270	

v_c - cutting speed (m/min)

n - RPM (rev/min)

f_x - feed rate (mm/tooth)

f - feed rate (mm/rev)

z - No. of teeth

a_p - axial depth of cuta_r - radial depth of cut

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

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

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.