

AB382 Series Cutting Data

3 Flute 30° Helix Ball Nose Carbide Slot Drill Cutting Data



STÄRKE



AB382 SERIES													
VDI Material Group			Type of cut		Size (mm)								
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
N	21- 25	Aluminium/ Aluminium Alloys	Slotting	v_c (m/min)	135	135	180	225	270	280	350	420	440
				n	21600	14400	14400	14400	14400	11200	11200	11200	8800
				f_z	0.018	0.026	0.035	0.038	0.049	0.071	0.084	0.107	0.123
				f (mm/min)	760	760	1000	1080	1400	1600	1880	2400	2160
	26- 28	Copper/ Copper Alloys		v_c (m/min)	40	40	55	70	85	85	105	125	135
				n	6400	4400	4400	4400	4400	3360	3360	3360	2640
				f_z	0.015	0.022	0.028	0.031	0.04	0.06	0.069	0.089	0.101
				f (mm/min)	190	190	250	270	350	400	465	600	535

0.2 x DC

0.5 x DC

Recommended cutting depths are **maximum** depths, and **speeds and feeds are a starting point** based on these depths. All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.

For long series and long necked tools it may be necessary to reduce feed rate by up to 50%.

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed per tooth (mm)
 f - feed rate (mm/min)
 a_p - axial depth of cut
 a_e - radial depth of cut