

2 Flute 45° Helix Long Length Carbide Slot Drill Cutting Data



STÄRKE



AL452 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)	95	125	155	190	200	250	300	300	250
				n	10000	10000	10000	10000	8000	8000	8000	6000	4000
				f _z	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
				f (mm/min)	700	900	1000	1200	1400	1700	2100	1900	1600
			Side cutting	v _c (m/min)	95	125	155	190	200	250	300	300	250
				n	10000	10000	10000	10000	8000	8000	8000	6000	4000
				f _z	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
				f (mm/min)	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2

Slotting

0.5 x DC

DC

Side Cutting

1.0 x DC

a_e

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