

PR55 Series Cutting Data

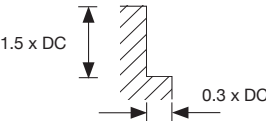
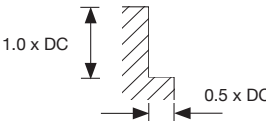
4 Flute Coated Carbide Ripper Cutting Data



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The feed rate for long, long reach and uncoated tools should be reduced by up to 50%

PR55 SERIES										
VDI Material Group			HRc	Side Cutting	Size (mm)					
					6.0	8.0	10.0	12.0	16.0	20.0
P	1-5	Non-Alloy Steel	<25	v _c (m/min)	310	305	305	315	315	315
				n	16440	12135	9710	8355	6265	5010
				f _z	0.05	0.067	0.063	0.075	0.1	0.113
				f (mm/min)	2465	2440	2450	2505	2505	2265
	6-9	Low-Alloy Steel	25-35	v _c (m/min)	60	70	80	85	90	90
				n	9550	7425	6365	5410	4775	3580
				f _z	0.006	0.009	0.019	0.024	0.03	0.042
				f (mm/min)	170	200	360	390	430	450
	10-11	High Alloy Steel, Tool Steel	35-45	v _c (m/min)	245	245	250	240	255	240
				n	12995	9750	7955	6365	5070	3820
				f _z	0.023	0.03	0.028	0.033	0.04	0.039
				f (mm/min)	895	875	890	840	810	595
M	14	Austenitic Stainless Steel		v _c (m/min)	165	165	170	165	175	160
				n	8750	6565	5410	4375	3480	2545
				f _z	0.023	0.03	0.028	0.064	0.039	0.038
				f (mm/min)	600	590	605	595	540	385
K	15-20	Cast Iron		v _c (m/min)	310	305	305	315	315	315
				n	16440	12135	9710	8355	6265	5010
				f _z	0.05	0.067	0.063	0.075	0.1	0.113
				f (mm/min)	2465	2440	2450	2505	2505	2265
H	38	h	45-55	v _c (m/min)	65	65	65	65	65	65
				n	3450	2585	2070	1720	1290	1035
				f _z	0.026	0.033	0.036	0.039	0.034	0.038
				f (mm/min)	270	255	295	270	175	155
Material Groups P, M, K										
Material Group H										

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