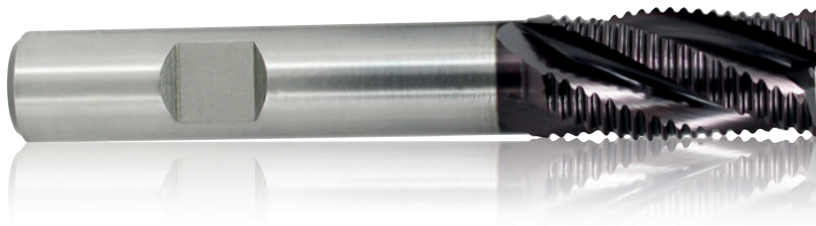


HSCR Series Cutting Data

Multi Flute Fine Pitch Ripper Cutting Data

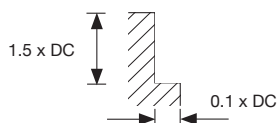


STÄRKE

HSC
MILL

The speeds and feeds for TiAlN coated tools can be increased by up to 30%

HSCR SERIES											
VDI Material Group			HRc		Size (mm)						
					3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1-5	Non-Alloy Steel	<25	v _c (m/min)	30	30	30	30	30	30	30
				n	1600	1100	900	800	560	450	400
				f _z	0.013	0.023	0.033	0.044	0.063	0.078	0.085
				f (mm/min)	60	75	120	140	140	140	170
	6-9	Low-Alloy Steel	25-35	v _c (m/min)	25	25	25	25	25	25	25
				n	1200	900	800	630	450	400	310
				f _z	0.015	0.024	0.034	0.044	0.061	0.069	0.09
				f (mm/min)	55	65	110	110	110	110	140
	10-11	High alloy Steel, Tool Steel	35-45	v _c (m/min)	15	15	15	15	15	15	15
				n	800	560	450	400	280	220	180
				f _z	0.013	0.021	0.033	0.044	0.063	0.08	0.094
				f (mm/min)	30	35	60	70	70	70	85
N	21-24	Aluminium/ Aluminium Alloys		v _c (m/min)	85	80	80	75	80	75	80
				n	4500	3100	2500	2000	1600	1200	1000
				f _z	0.015	0.025	0.035	0.05	0.07	0.104	0.09
				f (mm/min)	200	230	350	400	450	500	450



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.

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed per tooth (mm)
 f - feed rate (mm/min)
 z - No. of Teeth
 a_p - axial depth of cut
 a_e - radial depth of cut

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