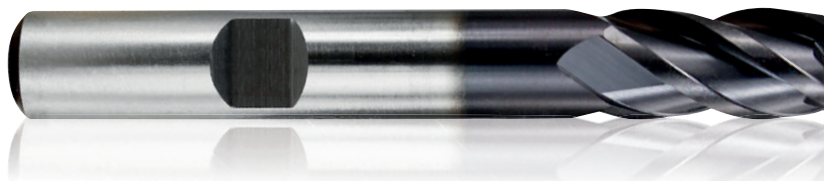


HSC4 Series Cutting Data

4 Flute HSc08 End Mill Cutting Data

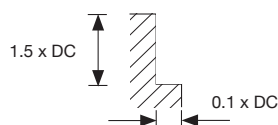


STÄRKE

HSC
MILL

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

HSC4 SERIES													
VDI Material Group		HRc	Slotting	Size (mm)									
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
P	1-5	Non-Alloy Steel	<25	v_c (m/min)	30	30	30	30	30	30	30	30	30
				n	3200	2200	1800	1600	1100	900	800	560	450
				f_z	0.006	0.011	0.017	0.023	0.036	0.044	0.056	0.071	0.089
				f (mm/min)	80	100	125	145	160	160	180	160	145
	6-9	Low-Alloy Steel	25-35	v_c (m/min)	25	25	25	25	25	25	25	25	25
				n	2500	1800	1600	1200	900	800	630	450	400
				f_z	0.006	0.009	0.014	0.019	0.029	0.038	0.048	0.058	0.066
				f (mm/min)	60	65	90	90	105	120	120	105	105
	10-11	High alloy Steel, Tool Steel	35-45	v_c (m/min)	15	15	15	15	15	15	15	15	15
				n	1600	1100	900	800	560	450	400	280	220
				f_z	0.005	0.01	0.014	0.019	0.029	0.036	0.047	0.058	0.074
				f (mm/min)	30	45	50	60	65	65	75	65	65
N	21-24	Aluminium/ Aluminium Alloys		v_c (m/min)	105	100	100	105	100	95	95	100	100
				n	11000	8000	6300	5600	4000	3100	2500	2000	1600
				f_z	0.009	0.014	0.019	0.021	0.036	0.048	0.057	0.066	0.075
				f (mm/min)	380	440	470	470	580	600	570	100	100



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: $v_c = \frac{n \cdot \pi \cdot \phi}{1000}$