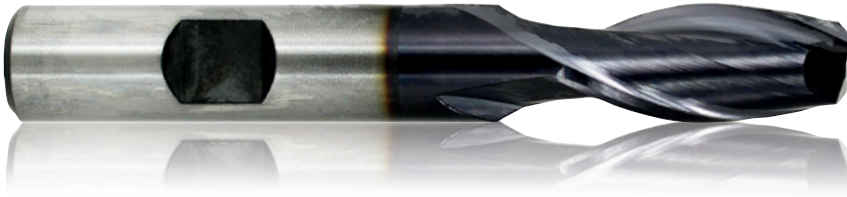


HSC2 Series Cutting Data

2 Flute HSc08 Slot Drill Cutting Data



STÄRKE

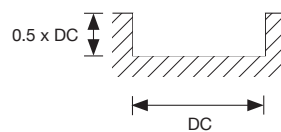


The speeds and feeds for TiAlN coated tools can be increased by up to 30%

HSC2 SERIES														
VDI Material Group			HRc		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	30
				n	3200	2200	1800	1600	1100	900	800	560	450	400
				f _z	0.007	0.013	0.019	0.025	0.041	0.05	0.063	0.08	0.1	0.1
				f (mm/min)	45	55	70	80	90	90	100	90	90	80
	6-9	Low-Alloy Steel	25-35	v _c (m/min)	25	25	25	25	25	25	25	25	25	25
				n	2500	1800	1600	1200	900	800	630	450	400	310
				f _z	0.008	0.013	0.019	0.025	0.039	0.05	0.063	0.078	0.088	0.097
				f (mm/min)	40	45	60	60	70	80	80	70	70	60
	10-11	High alloy Steel, Tool Steel	35-45	v _c (m/min)	15	15	15	15	15	15	15	15	15	15
				n	1600	1100	900	800	560	450	400	280	220	180
				f _z	0.006	0.014	0.019	0.025	0.04	0.05	0.063	0.08	0.102	0.097
				f (mm/min)	20	30	35	40	45	45	50	45	45	35
N	21-24	Aluminium/ Aluminium Alloys		v _c (m/min)	105	100	100	105	100	95	95	100	100	95
				n	11000	8000	6300	5600	4000	3100	2500	2000	1600	1200
				f _z	0.011	0.018	0.025	0.028	0.049	0.065	0.076	0.088	0.1	0.117
				f (mm/min)	250	290	310	310	390	400	380	350	320	280

0.5 x DC

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