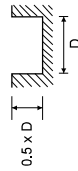


331303, 151303, 152303 ( 2 Flute 45° Helix, Short & Long)

**SLOTING**



MATERIAL GROUP	Size (mm)										
	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
71	95	125	155	190	200	250	300	265	300	225	250
72	n	10000	10000	10000	8000	8000	8000	6000	6000	4000	4000
73	f <sub>c</sub>	0.035	0.045	0.05	0.06	0.088	0.106	0.15	0.158	0.175	0.2
74	f (mm/min)	700	900	1000	1200	1400	1700	1800	1900	1400	1600

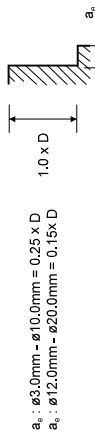


331303, 151303, 152303 ( 2 Flute 45° Helix, Short & Long)

**PROFILING**



MATERIAL GROUP	Size (mm)										
	3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
71	95	125	155	190	200	250	300	265	300	225	250
72	n	10000	10000	10000	8000	8000	8000	6000	6000	4000	4000
73	f <sub>c</sub>	0.045	0.055	0.065	0.075	0.113	0.131	0.163	0.183	0.2	0.238
74	f (mm/min)	900	1100	1300	1500	1800	2100	1600	2200	2400	1900



a<sub>r1</sub> : ø3.0mm - ø10.0mm = 0.25 x D  
a<sub>r2</sub> : ø12.0mm - ø20.0mm = 0.15 x D

v<sub>c</sub> - cutting speed (m/min)  
n - RPM (rev/min)  
f<sub>z</sub> - feed rate (mm/tooth)  
f - feed rate (mm/rev)  
z - No. of teeth  
a<sub>r</sub> - axial depth of cut  
a<sub>r1</sub> - 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:  $v_c = \frac{n \cdot \pi \cdot \phi}{1000}$

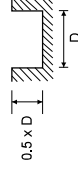
All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

157303 ( 2 Flute 55° Helix)

**SLOTING**



MATERIAL GROUP	Size (mm)									
	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
71	339	407	424	458	452	452	441	452	452	
72	n	36000	32400	27000	24300	18000	14400	9000	7200	
73	f <sub>c</sub>	0.019	0.025	0.047	0.052	0.07	0.1	0.123	0.188	
74	f (mm/min)	1350	1620	2520	2520	2520	2880	2880	2700	

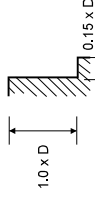


157303 ( 2 Flute 55° Helix)

**PROFILING**



MATERIAL GROUP	Size (mm)									
	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	
71	339	407	424	458	452	452	441	452	452	
72	n	36000	32400	27000	24300	18000	14400	9000	7200	
73	f <sub>c</sub>	0.03	0.036	0.067	0.074	0.1	0.141	0.225	0.269	
74	f (mm/min)	2160	2340	3600	3600	3600	4050	4050	3870	



v<sub>c</sub> - cutting speed (m/min)  
n - RPM (rev/min)  
f<sub>z</sub> - feed rate (mm/tooth)  
f - feed rate (mm/rev)  
z - No. of teeth  
a<sub>r</sub> - axial depth of cut  
a<sub>r1</sub> - 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:  $v_c = \frac{n \cdot \pi \cdot \phi}{1000}$

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.