

125103, 125303, 126103, 126303 (3 Flute Roughing)

MATERIAL GROUP	Type of cut	Size (mm)					
		6.0	8.0	10.0	12.0	16.0	20.0
71	v_c (m/min)	200	200	205	320	322	320
	n	13500	10500	8500	8500	6400	5100
72	f_z	0.168	0.167	0.169	0.167	0.167	0.165
	f (mm/min)	5300	4000	3500	3200	2400	1900
73	v_c (m/min)	200	200	205	320	322	320
	n	13500	10500	8500	8500	6400	5100
74	f_z	0.168	0.168	0.169	0.165	0.167	0.163
	f (mm/min)	6800	5300	4300	4200	3200	2500

SIDE CUTTING

 $1.5 \times D$
 $0.5 \times D$

SLOTING

 $1.5 \times D$
 D

155303 (2 Flute Corner Radius)

MATERIAL GROUP	Type of cut	Size (mm)						
		4.0	6.0	8.0	10.0	12.0	16.0	20.0
71	v_c (m/min)	130	195	200	250	300	320	250
	n	10400	10400	8000	8000	8000	6400	4000
72	f_z	0.054	0.077	0.115	0.135	0.17	0.194	0.25
	f (mm/min)	1120	1600	1840	2160	2720	2480	2000
73	v_c (m/min)	130	195	200	250	300	320	250
	n	10400	10400	8000	8000	8000	6400	4000
74	f_z	0.046	0.058	0.09	0.110	0.135	0.156	0.2
	f (mm/min)	960	1200	1440	1760	2160	2000	1600

SIDE CUTTING

 $1.2 \times D$
 $0.5 \times D$

$a_s : \phi 4.0\text{mm} - \phi 10.0\text{mm} = 0.25 \times D$
 $a_s : \phi 12.0\text{mm} - \phi 20.0\text{mm} = 0.5 \times D$

SLOTING

 D

151303, 152303, 154303 (2 Flute 45° Helix, Short, Long & Long Series)

MATERIAL GROUP	Type of cut	Size (mm)								
		3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
71	v_c (m/min)	95	125	155	190	200	250	300	300	250
	n	10000	10000	10000	10000	8000	8000	8000	6000	4000
72	f_z	0.045	0.055	0.065	0.075	0.113	0.131	0.163	0.2	0.238
	f (mm/min)	900	1100	1300	1500	1800	2100	1600	2400	1900
73	v_c (m/min)	95	125	155	190	200	250	300	300	250
	n	10000	10000	10000	10000	8000	8000	8000	6000	4000
74	f_z	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
	f (mm/min)	700	900	1000	1200	1400	1700	2100	1900	1600

SIDE CUTTING

 $1.0 \times D$
 $0.5 \times D$

$a_s : \phi 3.0\text{mm} - \phi 10.0\text{mm} = 0.25 \times D$
 $a_s : \phi 12.0\text{mm} - \phi 20.0\text{mm} = 0.15 \times D$

SLOTING

 D

116303 (3 Flute 40° Helix, Ball Nose)

MATERIAL GROUP	Type of cut	Size (mm)								
		2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0
61	v_c (m/min)	40	40	55	70	85	85	105	125	135
	n	6400	4400	4400	4400	4400	3360	3360	3360	2640
62	f_z	0.015	0.022	0.028	0.031	0.04	0.06	0.069	0.089	0.101
	f (mm/min)	190	190	250	270	350	400	465	600	535
63	v_c (m/min)	135	135	180	225	270	280	350	420	440
	n	21600	14400	14400	14400	14400	11200	11200	11200	8800
64	f_z	0.018	0.026	0.035	0.038	0.049	0.071	0.084	0.107	0.123
	f (mm/min)	760	760	1000	1080	1400	1600	1880	2400	2160

SIDE CUTTING

 $0.2 \times D$
 $0.5 \times D$

▶ The feed rate for long & long series tools should be reduced by up to 50%