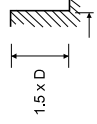


Cutting Conditions 171323, 172323, 173323, 174323 (5 Flute VX5)

MATERIAL GROUP	Type of cut	Diameter (mm)						
		6.0	8.0	10.0	12.0	16.0	20.0	25.0
P		144 (115-173)					1833	
		v_c (m/min)	7639	5730	4584	3620		2865
		f_z (mm/tooth)	0.034	0.038	0.050	0.063		0.076
P		101 (81-121)					926	
		v_c (m/min)	1299	1089	1146	1203		1089
		f_z (mm/tooth)	0.034	0.038	0.050	0.063		0.076
H		60 (48-72)					764	
		v_c (m/min)	911	764	804	844		764
		f_z (mm/tooth)	0.024	0.027	0.035	0.044		0.054
M		117 (94-140)					1490	
		v_c (m/min)	382	322	334	350		322
		f_z (mm/tooth)	0.024	0.027	0.035	0.044		0.054
M		82 (66-98)					459	
		v_c (m/min)	6207	4655	3724	3104		2328
		f_z (mm/tooth)	0.024	0.025	0.030	0.046		0.054
K		59 (47-71)					1044	
		v_c (m/min)	4350	3263	2610	2175		1631
		f_z (mm/tooth)	0.030	0.032	0.038	0.063		0.069
S		106 (85-127)					1350	
		v_c (m/min)	5823	4218	3374	2812		2109
		f_z (mm/tooth)	0.043	0.048	0.063	0.079		0.096
S		69 (55-83)					879	
		v_c (m/min)	3661	2745	2196	1830		1373
		f_z (mm/tooth)	0.027	0.029	0.034	0.057		0.062
S		31 (25-37)					347	
		v_c (m/min)	494	398	373	522		426
		f_z (mm/tooth)	0.021	0.022	0.027	0.044		0.048
S		SIDE CUTTING - STAINLESS & TITANIUM					122	
		v_c (m/min)	173	136	133	181		148
		f_z (mm/tooth)	0.021	0.022	0.027	0.044		0.053



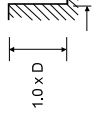
SIDE CUTTING

Recommended cutting depths are **maximum** depths, and **speeds and feeds are a starting point** based on these depths.
 All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your setup.
 Finishing cuts typically require reduced feed rates and/or higher spindle speed, with a_r of 2% x D; please adjust parameters accordingly.

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed per tooth (mm)
 f - feed rate (mm/min)
 a_r - axial depth of cut
 a_e - radial depth of cut

Cutting Conditions 175323 (5 Flute VX5 Roughing)

MATERIAL GROUP	Type of cut	Diameter (mm)						
		6.0	8.0	10.0	14.0	20.0	25.0	
M		80 (64-96)					1019	
		v_c (m/min)	4244	3183	2546	2122		1819
		f_z (mm/tooth)	0.025	0.034	0.041	0.051		0.057
S		65 (52-78)					463	
		v_c (m/min)	531	541	522	541		518
		f_z (mm/tooth)	0.025	0.034	0.041	0.051		0.057
S		40 (32-48)					348	
		v_c (m/min)	3448	2566	2069	1724		1478
		f_z (mm/tooth)	0.022	0.031	0.038	0.046		0.052
S		SIDE CUTTING - STAINLESS & TITANIUM					173	
		v_c (m/min)	212	199	236	212		209
		f_z (mm/tooth)	0.020	0.025	0.037	0.040		0.046



SIDE CUTTING - STAINLESS & TITANIUM

Recommended cutting depths are **maximum** depths, and **speeds and feeds are a starting point** based on these depths.
 All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your setup.
 Finishing cuts typically require reduced feed rates and/or higher spindle speed, with a_r of 2% x D; please adjust parameters accordingly.

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_z - feed per tooth (mm)
 f - feed rate (mm/min)
 a_r - axial depth of cut
 a_e - radial depth of cut