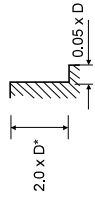


Cutting Conditions 173329, 174329, 175329, 176329 (6 Flute VX6) **TROCHOIDAL**

MATERIAL GROUP	Type of cut	Diameter (mm)												
		6.0	8.0	10.0	12.0	16.0	20.0	25.0						
P		300 (240-360)					v _c (m/min) n f _t f (mm/min) f (mm/min)	15915	11937	9549	7958	5968	4775	3820
		0.068	0.116	0.144	0.173	0.202		0.225	0.232					
		6494	8308	8251	8260	7234		6446	5317					
		203 (162-244)						10769	8077	6462	5385	4039	3231	2585
H		100 (60-120)					v _c (m/min) n f _t f (mm/min) f (mm/min)	5305	3979	3163	2653	1989	1592	1273
		0.041	0.071	0.088	0.105	0.123		0.137	0.144					
		1305	1695	1681	1681	1468		1308	1100					
		213 (170-256)						11300	8475	6780	5650	4238	3390	2712
M		147 (118-176)					v _c (m/min) n f _t f (mm/min) f (mm/min)	0.049	0.084	0.104	0.125	0.146	0.162	0.168
		3322	4271	4231	4238	3712		3294	2734					
		134 (107-161)						7799	5849	4679	3899	2924	2340	1872
		0.041	0.071	0.088	0.105	0.123		0.137	0.143					
S		213 (170-256)					v _c (m/min) n f _t f (mm/min) f (mm/min)	7109	5332	4265	3554	2666	2133	1706
		0.041	0.071	0.088	0.105	0.123		0.137	0.142					
		1749	2271	2252	2239	1967		1753	1454					
		60 (50-70)						11300	8475	6780	5650	4238	3390	2712
S		213 (170-256)					v _c (m/min) n f _t f (mm/min) f (mm/min)	0.033	0.055	0.070	0.083	0.097	0.113	0.117
		2239	2798	2849	2815	2467		2300	1905					
		60 (50-70)						3185	2389	1911	1592	1194	955	764
		0.033	0.055	0.070	0.082	0.097		0.112	0.115					



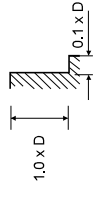
TROCHOIDAL MILLING

*If tool's length of cut is below 2xD use 90% of the length.
 *Long length tools can be used up to 4xD if rigidity is 100%.
 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 set-up.

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

Cutting Conditions 173329, 174329, 175329, 176329 (6 Flute VX6) **CONVENTIONAL**

MATERIAL GROUP	Type of cut	Diameter (mm)												
		6.0	8.0	10.0	12.0	16.0	20.0	25.0						
P		151 (121-181)					v _c (m/min) n f _t f (mm/min) f (mm/min)	7998	5988	4799	3999	2999	2399	1919
		0.022	0.035	0.043	0.053	0.061		0.069	0.075					
		1056	1224	1238	1272	1098		993	864					
		126 (101-152)						6705	5029	4023	3353	2514	2012	1609
H		70 (56-84)					v _c (m/min) n f _t f (mm/min) f (mm/min)	0.017	0.028	0.035	0.041	0.049	0.053	0.058
		684	845	845	825	739		640	560					
		131 (105-157)						3716	2787	2230	1858	1394	1115	892
		0.012	0.019	0.024	0.029	0.033		0.037	0.040					
M		93 (74-112)					v _c (m/min) n f _t f (mm/min) f (mm/min)	6947	5211	4168	3474	2605	2084	1667
		0.017	0.028	0.035	0.041	0.049		0.053	0.058					
		709	875	875	855	766		663	580					
		85 (68-102)						4928	3696	2957	2464	1848	1478	1183
S		93 (74-112)					v _c (m/min) n f _t f (mm/min) f (mm/min)	0.012	0.021	0.027	0.031	0.038	0.043	0.048
		326	466	479	458	421		381	341					
		26 (21-31)						4524	3393	2714	2262	1696	1354	1086
		0.012	0.021	0.027	0.031	0.038		0.043	0.048					
S		93 (74-112)					v _c (m/min) n f _t f (mm/min) f (mm/min)	326	428	440	421	387	350	313
		26 (21-31)						4928	3696	2957	2464	1848	1478	1183
		0.014	0.023	0.029	0.036	0.044		0.048	0.053					
		426	510	514	532	488		426	376					
S		26 (21-31)					v _c (m/min) n f _t f (mm/min) f (mm/min)	1373	1030	824	687	515	412	330
		0.012	0.021	0.027	0.031	0.038		0.043	0.048					
		99	130	104	128	117		106	95					
		93 (74-112)						4928	3696	2957	2464	1848	1478	1183



CONVENTIONAL MILLING

*For long length tools reduce feed by up to 50%.
 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 set-up.

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