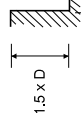


Cutting Conditions 171323, 172323, 173323, 174323 (5 Flute VX5)

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)									
		v_c (m/min)	n	7639	5730	4584	3620		2865	1833	
		f_z	0.034	0.038	0.050	0.063	0.076		0.089	0.101	
		f (mm/min)	1299	1089	1146	1203	1089		1020	926	
H		101 (81-121)									
		v_c (m/min)	n	5358	4019	3215	2679		2009	1607	1286
		f_z	0.034	0.038	0.050	0.063	0.076		0.089	0.101	
		f (mm/min)	911	764	804	844	764		715	649	
M		60 (48-72)									
		v_c (m/min)	n	3183	2387	1910	1592		1194	955	764
		f_z	0.024	0.027	0.035	0.044	0.054		0.062	0.071	
		f (mm/min)	382	322	334	350	322		296	271	
S		117 (94-140)									
		v_c (m/min)	n	6207	4655	3724	3104		2328	1862	1490
		f_z	0.024	0.025	0.030	0.046	0.054		0.061	0.071	
		f (mm/min)	745	582	559	714	628		568	529	
K		82 (66-98)									
		v_c (m/min)	n	4350	3263	2610	2175		1631	1305	1044
		f_z	0.030	0.032	0.038	0.063	0.069		0.076	0.088	
		f (mm/min)	653	522	496	685	563		496	459	
S		59 (47-71)									
		v_c (m/min)	n	3130	2348	1878	1565		1174	939	751
		f_z	0.030	0.032	0.038	0.063	0.069		0.076	0.088	
		f (mm/min)	470	376	354	493	405		357	331	
S		106 (85-127)									
		v_c (m/min)	n	5823	4218	3374	2812		2109	1687	1350
		f_z	0.043	0.048	0.063	0.079	0.096		0.111	0.126	
		f (mm/min)	1209	1012	1063	1111	1012		936	850	
S		69 (55-83)									
		v_c (m/min)	n	3661	2745	2196	1830		1373	1098	879
		f_z	0.027	0.029	0.034	0.057	0.062		0.069	0.079	
		f (mm/min)	494	398	373	522	426		379	347	
S		31 (25-37)									
		v_c (m/min)	n	1645	1233	987	822		617	493	395
		f_z	0.021	0.022	0.027	0.044	0.048		0.053	0.062	
		f (mm/min)	173	136	133	181	148		131	122	



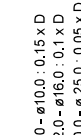
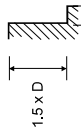
SIDE CUTTING

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_e 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_e - axial depth of cut
 a_r - 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	16.0	20.0	25.0				
M		80 (64-96)										
		v_c (m/min)	n	4244	3183	2546	2122		1819	1592	1273	1019
		f_z	0.025	0.034	0.041	0.051	0.057		0.063	0.081	0.081	
		f (mm/min)	531	541	522	541	518		501	516	463	
S		65 (52-78)										
		v_c (m/min)	n	3448	2566	2069	1724		1478	1293	1035	828
		f_z	0.022	0.031	0.038	0.046	0.052		0.058	0.074	0.084	
		f (mm/min)	379	401	393	397	384		375	383	348	
S		40 (32-48)										
		v_c (m/min)	n	2122	1592	1273	1061		909	786	637	509
		f_z	0.020	0.025	0.037	0.040	0.046		0.052	0.061	0.068	
		f (mm/min)	212	199	236	212	209		207	197	173	



SIDE CUTTING - STAINLESS & TITANIUM

SIDE CUTTING - NICKEL

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_e 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_e - axial depth of cut
 a_r - radial depth of cut