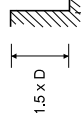


Cutting Conditions 171323, 172323, 173323, 174323 (5 Flute VX5)

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

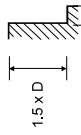


Recommended cutting depths are maximum depths, and speeds and feeds are a starting point based on these depths.
 All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your setup.
 Finishing cuts typically require reduced feed rates and/or higher spindle speed, with a_x 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_x - 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		1819	1592
		f_z	f_z	0.025	0.034	0.041		0.051	0.063
		f (mm/min)	f (mm/min)	531	541	522		541	501
S		65 (52-78)							
		v_c (m/min)	n	3448	2586	2069		1724	1478
		f_z	f_z	0.022	0.031	0.038		0.046	0.052
		f (mm/min)	f (mm/min)	379	401	393		397	384
S		40 (32-48)							
		v_c (m/min)	n	2122	1592	1273		1061	909
		f_z	f_z	0.020	0.025	0.037		0.040	0.046
		f (mm/min)	f (mm/min)	212	199	236		212	209



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_x 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_x - axial depth of cut
 a_r - radial depth of cut