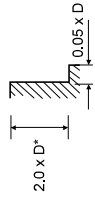


Cutting Conditions 173329, 174329, 175329, 176329 (6 Flute VX6) **TROCHOIDAL**

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)		
		11	15915	11937	9549	7958		5968	3820
		12	0.068	0.116	0.144	0.173		0.202	0.232
		13	6494	8308	8251	8260		7234	6446
H		203 (162-244)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		13	10769	8077	6462	5385		4039	3231
		14	0.050	0.085	0.106	0.128		0.149	0.167
		15	3231	4119	4110	4135		3610	3237
M		100 (60-120)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		15	5305	3979	3163	2653		1989	1592
		16	0.041	0.071	0.088	0.105		0.123	0.137
		17	1305	1695	1681	1681		1468	1308
S		213 (170-256)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		21	11300	8475	6780	5650		4238	3390
		22	0.049	0.084	0.104	0.125		0.146	0.162
		23	3322	4271	4231	4238		3712	3294
S		147 (118-176)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		21	7799	5849	4679	3899		2924	2340
		22	0.041	0.071	0.088	0.105		0.123	0.137
		23	1918	2492	2471	2457		2158	1923
S		134 (107-161)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		21	7109	5332	4265	3554		2666	2133
		22	0.041	0.071	0.088	0.105		0.123	0.137
		23	1749	2271	2252	2239		1967	1753
S		213 (170-256)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		41	11300	8475	6780	5650		4238	3390
		42	0.033	0.055	0.070	0.083		0.097	0.113
		43	2239	2798	2849	2815		2467	2300
S		60 (50-70)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		51	3185	2389	1911	1592		1194	955
		52	0.033	0.055	0.070	0.082		0.097	0.112
		53	631	788	803	783		695	642



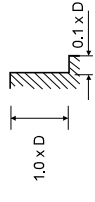
TROCHOIDAL MILLING

*If tool's length of cut is below 2xD use 90% of the length.
 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)		
		11	7998	5998	4799	3999		2999	1919
		12	0.022	0.035	0.043	0.053		0.061	0.069
		13	1056	1224	1238	1272		1098	993
H		126 (101-152)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		13	6705	5029	4023	3353		2514	2012
		14	0.017	0.028	0.035	0.041		0.049	0.053
		15	684	845	845	825		739	640
M		70 (56-84)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		15	3716	2787	2230	1858		1394	1115
		16	0.012	0.019	0.024	0.029		0.033	0.037
		17	268	318	321	323		276	247
M		131 (105-157)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		21	6947	5211	4168	3474		2605	2084
		22	0.017	0.028	0.035	0.041		0.049	0.053
		23	709	875	875	855		766	663
M		93 (74-112)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		22	4928	3696	2957	2464		1848	1478
		23	0.012	0.021	0.027	0.031		0.038	0.043
		24	326	466	479	458		421	381
S		85 (68-102)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		23	4524	3393	2714	2262		1696	1354
		24	0.012	0.021	0.027	0.031		0.038	0.043
		25	326	428	440	421		387	350
S		93 (74-112)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		41	4928	3696	2957	2464		1848	1478
		42	0.014	0.023	0.029	0.036		0.044	0.048
		43	426	510	514	532		488	426
S		26 (21-31)					v _c (m/min) n f _t f (mm/min) f (mm/min)		
		51	1373	1030	824	687		515	412
		52	0.012	0.021	0.027	0.031		0.038	0.043
		53	99	130	104	128		117	106



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