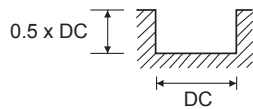


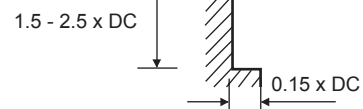
CUTTING DATA

143303, 144303, 153303 (3 Flute 45° Helix, Long, Necked & Long Series)												
VDI MATERIAL GROUP		Type of cut		Size (mm)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
N 21-25	Aluminium/ Aluminium Alloys	SLOTTING	v_c (m/min)	65	90	110	130	140	175	210	210	175
			n	7000	7000	7000	7000	5600	5600	5600	4200	2800
			f_z	0.035	0.045	0.05	0.06	0.088	0.106	0.131	0.158	0.2
			f (mm/min)	730	940	1050	1250	1470	1780	2200	1990	1680
		SIDE CUTTING	v_c (m/min)	65	90	110	130	140	175	210	210	175
			n	7000	7000	7000	7000	5600	5600	5600	4200	2800
			f_z	0.045	0.055	0.065	0.075	0.113	0.131	0.163	0.2	0.238
			f (mm/min)	940	1150	1360	1580	1900	2200	2740	2520	2000

SLOTTING



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 set-up.
For long series and long necked tools it may be necessary to reduce feed rate by up to 50%.

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