

6-16 TOOTH DOVETAIL CUTTER

ML112, ML122, ML132 & ML142

CUTTING DATA

MATERIAL	CARBON STEELS, ALLOY STEELS & TOOL STEELS																ALUMINIUM & ALUMINIUM ALLOYS			
	-				~ HRc 20				HRc 20 ~ HRc 30				HRc 30 ~ HRc 40				-			
Hardness	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²				-			
Strength	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
16	615	110	30	0.030	305	57	15	0.031	215	40	10	0.031	160	20	10	0.021	1850	336	95	0.030
20	500	110	30	0.037	255	55	15	0.036	180	38	10	0.035	125	15	10	0.020	1350	324	85	0.040
25	380	80	30	0.026	190	47	15	0.031	135	30	10	0.028	100	16	10	0.020	1150	270	90	0.029
32	300	125	30	0.042	155	64	15	0.041	100	40	10	0.040	80	16	10	0.020	920	375	90	0.041
40	250	130	30	0.043	125	64	15	0.043	90	45	10	0.042	60	16	10	0.022	765	387	95	0.042
50	190	90	30	0.030	100	42	15	0.026	75	36	10	0.030	50	16	10	0.020	550	265	85	0.030

8-14 TOOTH WOODRUFF KEYSEAT CUTTER

ML162 Series

CUTTING DATA

MATERIAL	CARBON STEELS, ALLOY STEELS & TOOL STEELS																ALUMINIUM & ALUMINIUM ALLOYS			
	-				~ HRc 20				HRc 20 ~ HRc 30				HRc 30 ~ HRc 40				-			
Hardness	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²				-			
Strength	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				1000 ~ 1300N/mm ²				-			
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
10.5	900	72	30	0.010	600	48	20	0.010	480	38	15	0.010	300	24	10	0.010	3000	240	100	0.010
13.5	700	56	30	0.010	470	38	20	0.010	370	30	15	0.010	230	18	10	0.010	2300	184	100	0.010
16.5	570	114	30	0.025	380	76	20	0.025	300	60	15	0.025	190	38	10	0.025	1900	380	100	0.025
19.5	480	134	30	0.035	320	90	20	0.035	260	73	15	0.035	160	45	10	0.035	1600	448	100	0.035
22.5	420	168	30	0.040	280	112	20	0.040	220	88	15	0.040	140	56	10	0.040	1400	560	100	0.040
28.5	330	165	30	0.050	220	110	20	0.050	180	90	15	0.050	110	55	10	0.050	1100	550	100	0.050
32.5	290	209	30	0.060	190	137	20	0.060	155	112	15	0.060	90	65	10	0.060	900	648	90	0.060
45.5	210	206	30	0.070	130	127	20	0.070	110	108	15	0.070	70	69	10	0.070	700	686	100	0.070

6 & 8 TOOTH T-SLOT CUTTER

ML172 Series

CUTTING DATA

MATERIAL	CARBON STEELS, ALLOY STEELS & TOOL STEELS												ALUMINIUM & ALUMINIUM ALLOYS							
	-				~ HRc 20				HRc 20 ~ HRc 30				-							
Hardness	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				-							
Strength	~ 500N/mm ²				500 ~ 800N/mm ²				800 ~ 1000N/mm ²				-							
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
12.5	770	38	30	0.008	380	16	15	0.007	270	8	10	0.005	2350	110	90	0.008				
16	600	45	30	0.013	300	19	15	0.011	210	9	10	0.007	1830	140	90	0.013				
18	550	47	30	0.014	270	20	15	0.012	195	12	10	0.010	1680	150	95	0.015				
19	500	50	30	0.017	250	20	15	0.013	180	15	10	0.014	1540	160	90	0.017				
21	470	52	30	0.018	230	22	15	0.016	160	16	10	0.017	1430	165	95	0.019				
22	440	55	30	0.021	220	25	15	0.019	150	17	10	0.019	1330	170	90	0.021				
25	390	65	30	0.028	190	30	15	0.026	135	18	10	0.022	1170	180	90	0.026				
28	345	75	30	0.036	170	38	15	0.037	120	20	10	0.028	1040	210	90	0.034				
32	310	90	30	0.036	150	42	15	0.035	100	20	10	0.025	910	250	90	0.034				
50	270	80	40	0.037	135	40	20	0.037	90	20	15	0.028	800	230	125	0.036				
63	240	70	50	0.036	120	38	25	0.040	85	20	15	0.029	730	210	145	0.036				

RPM: revolutions per minute Feed: mm per minute Vc: surface speed (metres per minute) Fz: feed per tooth