



# V5LCB

## Endmill Recommended cutting data

V5LCB Cutting Parameters      Axial Depth of Cut (ap)      ≤ 4 x D

Material Groups	Vc		Ø6.0	Ø8.0	Ø10.0	Ø12.0	Ø16.0
			ae 10%	ae 10%	ae 10%	ae 10%	ae 10%
			0.1 x Ø	0.1 x Ø	0.1 x Ø	0.1 x Ø	0.1 x Ø
			Radial Depth of Cut (ae)	Radial Depth of Cut (ae)	Radial Depth of Cut (ae)	Radial Depth of Cut (ae)	Radial Depth of Cut (ae)
			0.6mm	0.8mm	1.0mm	1.2mm	1.6mm
Low Carbon, Free Machining Steels	300	RPM	15,900	11,925	9,540	7,950	5,963
		Feed (Vf)	5,724	5,724	5,724	5,724	5,724
Alloy Steels, Tool Steels & Nitriding Steels	200	RPM	10,600	7,950	5,300	3,975	3,180
		Feed (Vf)	3,816	3,816	3,816	3,816	3,816
Free Machining & Austenitic Stainless Steels ≤ 32 HRC	150	RPM	7,950	5,963	4,770	3,975	2,981
		Feed (Vf)	2,862	2,862	2,862	2,862	2,862
Moderate Machining & PH Stainless Steels	130	RPM	6,890	5,168	4,134	3,445	2,584
		Feed (Vf)	2,480	2,480	2,480	2,480	2,480
Duplex & Super Duplex Stainless Steels	80	RPM	4,240	3,180	2,544	2,120	1,590
		Feed (Vf)	1,526	1,526	1,526	1,526	1,526
Titanium Alloys	80	RPM	4,240	3,180	2,544	2,120	1,590
		Feed (Vf)	1,526	1,526	1,526	1,526	1,526