

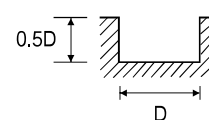
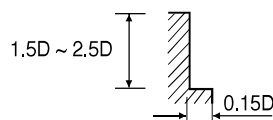


**RECOMMENDED CUTTING CONDITIONS  
EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 3 FLUTE 45° HELIX  
VOLLHARTMETALL, 3 SCHNEIDEN 45° RECHTSSPIRALE**

**E5E49, E5E50 SERIES**

| MATERIAL | N                                |      |     |       |      |      |     |       |
|----------|----------------------------------|------|-----|-------|------|------|-----|-------|
|          | ALUMINUM<br>LOW SILICON ALUMINUM |      |     |       |      |      |     |       |
| DIAMETER | RPM                              | FEED | Vc  | fz    | RPM  | FEED | Vc  | fz    |
| 3.0      | 7000                             | 940  | 65  | 0.045 | 7000 | 730  | 65  | 0.035 |
| 4.0      | 7000                             | 1150 | 90  | 0.055 | 7000 | 940  | 90  | 0.045 |
| 5.0      | 7000                             | 1360 | 110 | 0.065 | 7000 | 1050 | 110 | 0.050 |
| 6.0      | 7000                             | 1580 | 130 | 0.075 | 7000 | 1250 | 130 | 0.060 |
| 8.0      | 5600                             | 1900 | 140 | 0.113 | 5600 | 1470 | 140 | 0.088 |
| 9.0      | 5600                             | 2050 | 160 | 0.122 | 5600 | 1630 | 160 | 0.097 |
| 10.0     | 5600                             | 2200 | 175 | 0.131 | 5600 | 1780 | 175 | 0.106 |
| 12.0     | 5600                             | 2740 | 210 | 0.163 | 5600 | 2200 | 210 | 0.131 |
| 16.0     | 4200                             | 2520 | 210 | 0.200 | 4200 | 1990 | 210 | 0.158 |
| 20.0     | 2800                             | 2000 | 175 | 0.238 | 2800 | 1680 | 175 | 0.200 |

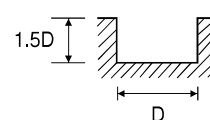
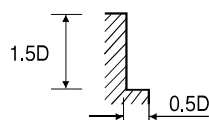


RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/tooth

**CARBIDE, 3 FLUTE ROUGHING  
VOLLHARTMETALL, 3 SCHNEIDEN SCHRUPPFÄSER**

**E5E39, E5E40, E5742, E5711 SERIES**

| MATERIAL | N        |      |     |       |       |      |     |       |
|----------|----------|------|-----|-------|-------|------|-----|-------|
|          | ALUMINUM |      |     |       |       |      |     |       |
| DIAMETER | RPM      | FEED | Vc  | fz    | RPM   | FEED | Vc  | fz    |
| 6.0      | 13500    | 6800 | 254 | 0.168 | 10500 | 5300 | 198 | 0.168 |
| 8.0      | 10500    | 5300 | 264 | 0.168 | 8000  | 4000 | 201 | 0.167 |
| 10.0     | 8500     | 4300 | 267 | 0.169 | 6500  | 3500 | 204 | 0.179 |
| 12.0     | 8500     | 4200 | 320 | 0.165 | 6400  | 3200 | 241 | 0.167 |
| 16.0     | 6400     | 3200 | 322 | 0.167 | 4800  | 2400 | 241 | 0.167 |
| 20.0     | 5100     | 2500 | 320 | 0.163 | 3850  | 1900 | 242 | 0.165 |



RPM = rev./min.  
FEED = mm/min.  
Vc = m/min.  
fz = mm/tooth