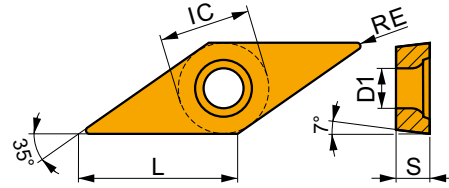




VCGW

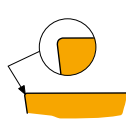


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1303	7.940	3.40	13.80	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



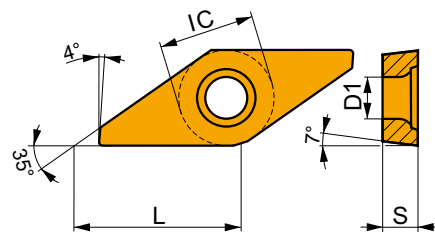
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

VCGW 130302	T5305	0.2	—	—	—	—	—	—	170	0.08	1.3	—	—	—	—	—	35	0.15	1.0
VCGW 130304	T5305	0.4	—	—	—	—	—	—	165	0.10	1.3	—	—	—	—	—	35	0.15	1.0
VCGW 130308	T5305	0.8	—	—	—	—	—	—	160	0.18	1.3	—	—	—	—	—	30	0.15	1.0

VCGX

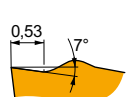


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1303	7.940	3.40	13.80	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



FR-FF2 geometry with positive right-handed design for fine-finish to finish machining, and continuous cuts.

VCGX 130300FR-FF2	T6310	0.0	140	0.05	1.0	—	—	—	110	0.05	1.0	—	—	—	—	—	—	—	—
	T8315	0.0	150	0.05	1.0	—	—	—	140	0.05	1.0	—	—	—	—	—	—	—	—
	TT010	0.0	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
VCGX 130301FR-FF2	T6310	0.1	140	0.05	1.0	—	—	—	110	0.05	1.0	—	—	—	—	—	—	—	—
	T8315	0.1	150	0.05	1.0	—	—	—	140	0.05	1.0	—	—	—	—	—	—	—	—
	TT010	0.1	240	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—