

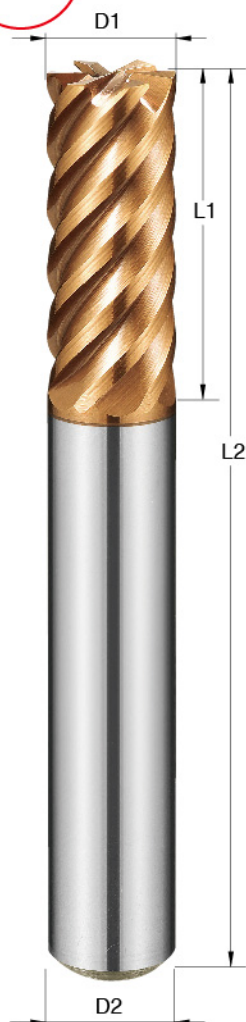
V70

V70E

► Square / for **H** **P**

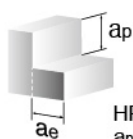
unit: mm

NEW

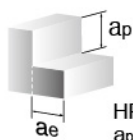


Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
V70E 0606	6.0	16	50	6
V70E 0808	8.0	20	60	8
V70E 1010	10.0	25	75	10
V70E 1212	12.0	30	75	12
V70E 1616	16.0	40	100	16

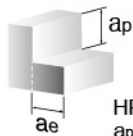
## ▼ Depth of cut

HRC55  
ap ≤ 1.5 D1

Dia	ae(mm)
6	0.3
8	0.4
10	0.5
12	0.6
16	0.8

HRC65  
ap ≤ 1.5 D1

Dia	ae(mm)
6	0.2
8	0.2
10	0.3
12	0.3
16	0.5

HRC70  
ap ≤ 1.0 D1

Dia	ae(mm)
6	0.1
8	0.1
10	0.2
12	0.2
16	0.3

## ▼ Recommended cutting condition for V70E

MATERIAL	Hardened Steels SKD61, SKT4		Hardened Steels SKD11		Hardened Steels SKS, SKH	
HARDNESS	~HRC55		~HRC65		~HRC70	
Dia. (D1)	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm / min
6	13000	4600	6400	2400	4200	1450
8	10000	4600	4800	2400	3200	1450
10	7700	4600	4000	2400	2600	1450
12	6400	3800	3200	1900	2200	1200
16	4800	2900	2400	1400	1600	900