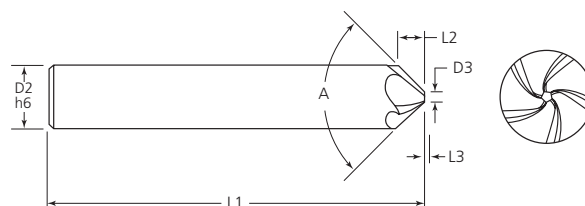
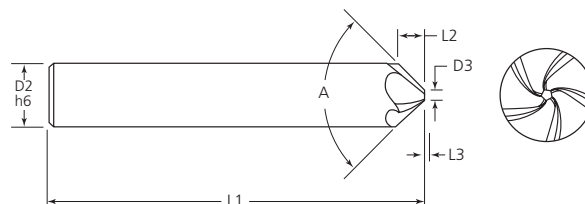
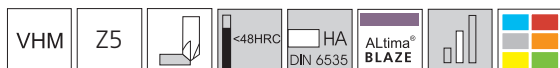


TuffCut® Series 5HC 90°



Tool Number	EDP	D2	D3	Angle	L1	L2	L3
5HCM06003B	35026	6.0	1.5	90°	57.0	2.25	0.75
5HCM08003B	35027	8.0	1.75	90°	63.0	3.125	0.875
5HCM10003B	35028	10.0	1.75	90°	72.0	4.125	0.875
5HCM12003B	35029	12.0	2.0	90°	83.0	5.0	1.0
5HCM16003B	35030	16.0	2.25	90°	92.0	6.875	1.125

TuffCut® Series 5HC 60°



Tool Number	EDP	D2	D3	Angle	L1	L2	L3
5HCM06001B	19993	6.0	1.5	60°	57.0	3.9	1.3
5HCM08001B	19994	8.0	1.75	60°	63.0	5.4	1.5
5HCM10001B	19995	10.0	1.75	60°	72.0	7.1	1.5
5HCM12001B	19996	12.0	2.0	60°	83.0	8.7	1.7
5HCM16001B	19997	16.0	2.25	60°	92.0	13.9	2.0

Recommended Cutting Data

Series 5HCM										
Workpiece Material Group	ISO	Coolant			Vc-m/ min	Tool Diameter				
		Emulsion	Air	MQL		6mm	8mm	10mm	12mm	16mm
						fz-mm/tooth				
Low Carbon Steels	P	●	●	●	350	0.072	0.096	0.120	0.144	0.192
Medium Carbon Steels		●	●	●	270	0.048	0.064	0.080	0.096	0.128
Alloy Tool Steels		●	●	●	250	0.048	0.064	0.080	0.096	0.128
Die/Tool Steels		●	●	●	220	0.042	0.056	0.070	0.084	0.112
Free Machining Stainless	M	●	X	○	180	0.042	0.056	0.070	0.084	0.112
Austenitic Stainless		●	X	○	130	0.036	0.048	0.060	0.072	0.096
Difficult Stainless		●	X	○	75	0.030	0.040	0.050	0.060	0.080
PH Stainless		●	X	○	130	0.036	0.048	0.060	0.072	0.096
Cobalt Chrome Alloys		●	X	○	75	0.030	0.040	0.050	0.060	0.080
Duplex (22%)		●	X	○	75	0.030	0.040	0.050	0.060	0.080
Super Duplex (25%)		●	X	○	55	0.030	0.040	0.050	0.060	0.080
High Temp Alloys	S	●	X	X	45	0.030	0.040	0.050	0.060	0.080
Titanium Alloys		●	X	X	100	0.036	0.048	0.060	0.072	0.096
Grey Cast Iron	K	●	○	○	300	0.084	0.112	0.140	0.168	0.224
Ductile Cast Iron		●	○	○	190	0.060	0.080	0.100	0.120	0.160
Hardened Steels 45 - 50HRC	H	○	●	○	80	0.030	0.040	0.050	0.060	0.080
Hardened Steels 50 - 55HRC		○	●	○	60	0.036	0.048	0.060	0.072	0.096
Aluminium Alloys	N	●	X	○	600	0.072	0.096	0.120	0.144	0.192

● Preferred ○ Possible X Not Possible

Please note:

Technical data provided should be considered as advisory only and alterations may be necessary depending on the specific application.

Decreased feeds and/or a finish pass may be required to reach the desired surface finish requirements.

Decreased speeds and feeds may be required for heavy duty cutting.

Cutting speed (Vc) should be calculated from the effective cutting diameter using the following formula:

(Major diameter D2 + minor diameter D3) / 2.

Alternatively, estimate the actual diameter that is in contact with the workpiece.

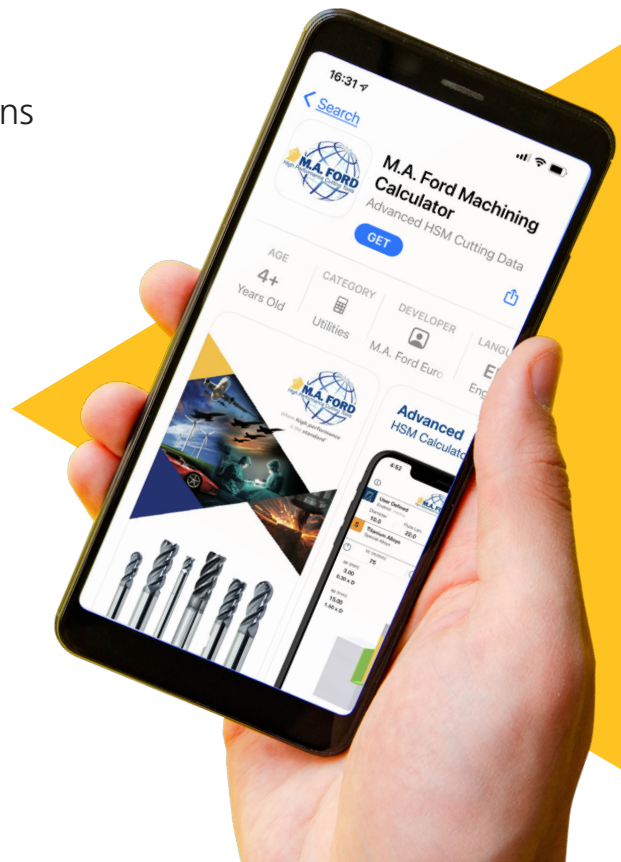
The M.A. Ford interactive cutting data app

- Everything you need at your fingertips

Our interactive app for iOS and Android devices makes tool cutting data calculations simpler and faster by minimising text input and using 3D graphics that respond instantly to changing cutting parameters, using smart-phone or tablet touch screens.

Developed around our proven cutting data, the app supports a wide range of ISO materials including steel, aluminium alloys, stainless steel and titanium, as well as cast iron, hardened steels and exotic alloys.

Once basic information has been selected from 'drop down' menus, such as tool type, diameter and material, the app allows you to 'drag' the tool graphic display to change the radial engagement and depth of cut, which instantly calculates speeds and feeds.



Colour coded feedback guides you toward the recommended cutting conditions based on the chosen input parameters. User over-ride controls allow cutting data to be fine-tuned for individual applications, as well as enabling calculations to be made that compare multiple scenarios instantly.

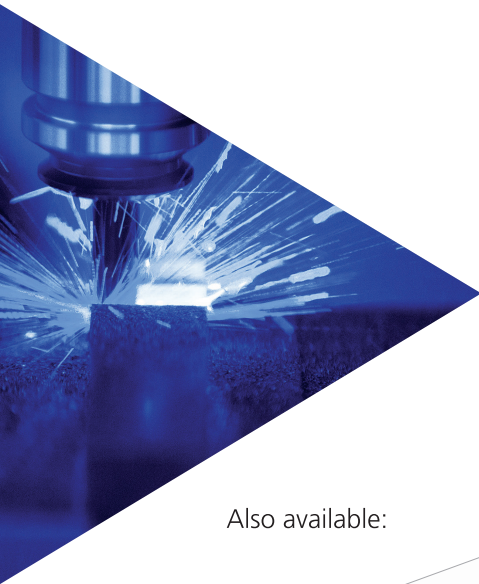
Proven cutting data can be stored via the 'Save' feature for future reference or shared with other app users. A hyperlink to M.A. Ford Europe's website also allows immediate access to online information and downloads.



Radial chip thinning data is also calculated for use with high-speed machining (HSM) strategies, which can significantly reduce cycle times and improve tool life.



For further information please contact our support team on: 01332 267960



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is the **standard**[®]

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