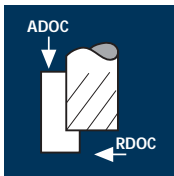


Application



Material

Hardened tool steel
52 - 56 HRC

H

Hardened tool steel
56 - 60 HRC

H

Hardened tool steel
60 - 64 HRC

H

Hardened tool steel
64 - 70 HRC

H

d1 [in]	f1	Speed [ft/min]	FPT [in]	ADOC [in]	RDOC [in]	RPM [min ⁻¹]	Feed [in/min]
1/4	5	165	0.0006	1.125	0.004	2520	8
3/8	7	165	0.0010	1.688	0.005	1680	12
1/2	7	165	0.0012	2.250	0.007	1260	11
5/8	7	165	0.0016	2.813	0.009	1010	11
3/4	7	165	0.0019	3.375	0.011	840	11
1	7	165	0.0025	4.500	0.014	630	11
1 1/4	9	165	0.0028	5.625	0.018	505	13
1/4	5	130	0.0006	1.125	0.004	1985	6
3/8	7	130	0.0010	1.688	0.005	1325	9
1/2	7	130	0.0012	2.250	0.007	995	8
5/8	7	130	0.0016	2.813	0.009	795	9
3/4	7	130	0.0019	3.375	0.011	660	9
1	7	130	0.0025	4.500	0.014	495	9
1 1/4	9	130	0.0028	5.625	0.018	395	10
1/4	5	80	0.0006	1.125	0.004	1220	4
3/8	7	80	0.0010	1.688	0.005	815	6
1/2	7	80	0.0012	2.250	0.007	610	5
5/8	7	80	0.0016	2.813	0.009	490	5
3/4	7	80	0.0019	3.375	0.011	405	5
1	7	80	0.0025	4.500	0.014	305	5
1 1/4	9	80	0.0028	5.625	0.018	245	6
1/4	5	50	0.0006	1.125	0.004	765	2
3/8	7	50	0.0010	1.688	0.005	510	4
1/2	7	50	0.0012	2.250	0.007	380	3
5/8	7	50	0.0016	2.813	0.009	305	3
3/4	7	50	0.0019	3.375	0.011	255	3
1	7	50	0.0025	4.500	0.014	190	3
1 1/4	9	50	0.0028	5.625	0.018	155	4