

INCH

INCH CARBIDE END MILLS

Material	Property	Vc : SFM Uncoated	Vc : SFM AITIN	Feed : (ipt)								
				Ø0.157"	Ø0.236"	Ø0.315"	Ø0.394"	Ø0.472"	Ø0.630"	Ø0.787"	Ø0.984"	
	<60 ksi	330	490	Roughing	0.00067	0.00138	0.00181	0.00224	0.00280	0.00346	0.00402	0.00445
				Finishing	0.00094	0.00189	0.00252	0.00315	0.00390	0.00048	0.00563	0.00626
				Slotting	0.00047	0.00094	0.00126	0.00157	0.00197	0.00244	0.00087	0.00311
	<100 ksi	330	490	Roughing	0.00063	0.00126	0.00165	0.00205	0.00256	0.00319	0.00370	0.00409
				Finishing	0.00087	0.00173	0.00232	0.00287	0.00358	0.00445	0.00520	0.00575
				Slotting	0.00043	0.00087	0.00114	0.00146	0.00181	0.00224	0.00260	0.00287
	<145 ksi	230	360	Roughing	0.00051	0.00102	0.00134	0.00169	0.00209	0.00260	0.00303	0.00335
				Finishing	0.00071	0.00142	0.00189	0.00236	0.00295	0.00366	0.00425	0.00469
				Slotting	0.00035	0.00071	0.00094	0.00118	0.00146	0.00181	0.00213	0.00236
	<190 ksi	195	330	Roughing	0.00047	0.00091	0.00122	0.00150	0.00185	0.00232	0.00268	0.00299
				Finishing	0.00063	0.00126	0.00169	0.00209	0.00260	0.00323	0.00378	0.00417
				Slotting	0.00031	0.00063	0.00083	0.00106	0.00130	0.00161	0.00189	0.00209
	55HRC	100	195	Roughing	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260
				Finishing	0.00055	0.00110	0.00146	0.00185	0.00228	0.00283	0.00331	0.00366
				Slotting	0.00028	0.00055	0.00075	0.00091	0.00114	0.00142	0.00165	0.00181
	68HRC	65	130	Roughing	0.00035	0.00067	0.00091	0.00114	0.00142	0.00173	0.00201	0.00224
				Finishing	0.00047	0.00094	0.00126	0.00157	0.00197	0.00244	0.00283	0.00311
				Slotting	0.00024	0.00047	0.00063	0.00079	0.00098	0.00122	0.00142	0.00157
	<130 ksi	195	295	Roughing	0.00051	0.00102	0.00134	0.00169	0.00209	0.00260	0.00303	0.00335
				Finishing	0.00071	0.00142	0.00189	0.00236	0.00295	0.00366	0.00425	0.00469
				Slotting	0.00035	0.00071	0.00094	0.00118	0.00146	0.00181	0.00213	0.00236
	>130 ksi	165	260	Roughing	0.00047	0.00091	0.00122	0.00150	0.00185	0.00232	0.00268	0.00299
				Finishing	0.00063	0.00126	0.00169	0.00209	0.00260	0.00323	0.00378	0.00417
				Slotting	0.00031	0.00063	0.00083	0.00106	0.00130	0.00161	0.00189	0.00209
	<130 ksi	130	195	Roughing	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260
				Finishing	0.00055	0.00110	0.00146	0.00185	0.00228	0.00283	0.00331	0.00366
				Slotting	0.00028	0.00055	0.00075	0.00091	0.00114	0.00142	0.00165	0.00181
	>130 ksi	100	165	Roughing	0.00035	0.00067	0.00091	0.00114	0.00142	0.00173	0.00201	0.00224
				Finishing	0.00047	0.00094	0.00126	0.00157	0.00197	0.00244	0.00283	0.00311
				Slotting	0.00024	0.00047	0.00063	0.00079	0.00098	0.00122	0.00142	0.00157
	<130 ksi	100	165	Roughing	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260
				Finishing	0.00055	0.00110	0.00146	0.00185	0.00228	0.00283	0.00331	0.00366
				Slotting	0.00028	0.00055	0.00075	0.00091	0.00114	0.00142	0.00165	0.00181
	>130 ksi	65	130	Roughing	0.00035	0.00067	0.00091	0.00114	0.00142	0.00173	0.00201	0.00224
				Finishing	0.00047	0.00094	0.00126	0.00157	0.00197	0.00244	0.00283	0.00311
				Slotting	0.00024	0.00047	0.00063	0.00079	0.00098	0.00122	0.00142	0.00157
	<8HRC	330	490	Roughing	0.00063	0.00126	0.00165	0.00205	0.00256	0.00319	0.00370	0.00409
				Finishing	0.00087	0.00173	0.00232	0.00287	0.00358	0.00445	0.00520	0.00575
				Slotting	0.00043	0.00087	0.00114	0.00146	0.00181	0.00224	0.00260	0.00287
	>8HRC	260	395	Roughing	0.00055	0.00114	0.00150	0.00189	0.00232	0.00291	0.00335	0.00374
				Finishing	0.00079	0.00157	0.00213	0.00264	0.00327	0.00406	0.00472	0.00520
				Slotting	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260
	Silicon <10%	985	1640	Roughing	0.00067	0.00138	0.00181	0.00224	0.00280	0.00346	0.00402	0.00445
				Finishing	0.00094	0.00189	0.00252	0.00315	0.00390	0.00484	0.00563	0.00626
				Slotting	0.00047	0.00094	0.00126	0.00157	0.00197	0.00244	0.00283	0.00311
	Silicon >10%	655	1310	Roughing	0.00063	0.00126	0.00165	0.00205	0.00256	0.00319	0.00370	0.00409
				Finishing	0.00087	0.00173	0.00232	0.00287	0.00358	0.00445	0.00520	0.00575
				Slotting	0.00043	0.00087	0.00114	0.00146	0.00181	0.00224	0.00260	0.00287
	Bronze	330	490	Roughing	0.00055	0.00114	0.00150	0.00189	0.00232	0.00291	0.00335	0.00374
				Finishing	0.00079	0.00157	0.00213	0.00264	0.00327	0.00406	0.00472	0.00520
				Slotting	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260
	Brass	260	395	Roughing	0.00055	0.00114	0.00150	0.00189	0.00232	0.00291	0.00335	0.00374
				Finishing	0.00079	0.00157	0.00213	0.00264	0.00327	0.00406	0.00472	0.00520
				Slotting	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260
	-	985	1640	Roughing	0.00055	0.00114	0.00150	0.00189	0.00232	0.00291	0.00335	0.00374
				Finishing	0.00079	0.00157	0.00213	0.00264	0.00327	0.00406	0.00472	0.00520
				Slotting	0.00039	0.00079	0.00106	0.00130	0.00161	0.00201	0.00236	0.00260