



Speed & Feed Recommendations

57M Metric	HARDNESS	CUT	SPEED	FEED (mm/flute)			
	BRINELL	Type	m/min	6	8	10	12
STEEL TOOL STEEL MOLD & DIE STEEL 300M, 4340, 52100, HP 9-4-20, M-50, A2, D2, H13, L2, M2, P20, S7, T15, W2	> 280 ≤ 420	Slot	66	0.032	0.048	0.064	0.079
		Profile	81	0.046	0.066	0.089	0.112
		High Speed	171	0.056	0.084	0.112	0.140
	> 420 ≤ 560	Slot	37	0.025	0.038	0.051	0.064
		Profile	46	0.036	0.053	0.071	0.089
		High Speed	149	0.046	0.066	0.089	0.112
	> 560 ≤ 745	Slot	20	0.020	0.028	0.038	0.048
		Profile	24	0.028	0.041	0.053	0.066
		High Speed	76	0.033	0.048	0.064	0.079

CUT TYPE						<div>rpm = sfm x 3.82 / D₁ rpm = (1000 x m/min) / (3.14 x D₁) mm/min = (mm/flute) x 6 x rpm • maximum recommended depths shown • finish cuts typically require reduced feed and cutting depths of .02 x D₁ maximum • refer to the SGS Tool Wizard for more complete technical information (available at) • Ramping not recommended</div>
SLOT		PROFILE		HIGH SPEED		
> 280 ≤ 560 Bhn a _p = 0.3 x D ₁ a _e = D ₁	> 560 ≤ 740 Bhn a _p = 0.1 x D ₁ a _e = D ₁	> 280 ≤ 560 Bhn a _p = 1.5 x D ₁ a _e = 0.1 X D ₁	> 560 ≤ 740 Bhn Rw a _p = 1.5 x D ₁ a _e = 0.05 x D ₁	> 280 ≤ 560 Bhn a _p = 1.5 x D ₁ a _e = 0.04 x D ₁	> 560 ≤ 740 Bhn a _p = 1.5 x D ₁ a _e = 0.01 x D ₁	
						