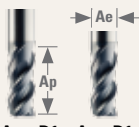














Hardness BRINELL	Series 66M, 66MCR Metric			Vc (m/min)	Diameter (mm)								
		Ap x D1	Ae x D1		6	8	10	12	16	20	25		
≤ 185	STAINLESS STEEL (DIFFICULT) 304, 304L, 316, 316L	 Profile	1	≤ 0.05	117	RPM	6202	4651	3721	3101	2326	1861	1488
					(94-140)	Fz	0.022	0.036	0.045	0.055	0.067	0.075	0.080
					Feed (mm/min)	955	1172	1172	1535	1402	1535	1310	
		 Finish	2	≤ 0.02	140	RPM	7442	5582	4465	3721	2791	2233	1786
					(112-168)	Fz	0.018	0.029	0.036	0.044	0.054	0.060	0.064
					Feed (mm/min)	917	1125	1125	1474	1346	1474	1257	
≤ 325	STAINLESS STEEL (PH) 13-8 PH, 15-5PH, 17-4 PH, Custom 450	 Profile	1	≤ 0.05	108	RPM	5725	4294	3435	2862	2147	1717	1374
					(86-130)	Fz	0.017	0.030	0.037	0.043	0.051	0.059	0.065
					Feed (mm/min)	681	902	890	1108	985	1115	982	
		 Finish	2	≤ 0.02	130	RPM	6870	5152	4122	3435	2576	2061	1649
					(104-156)	Fz	0.014	0.024	0.030	0.034	0.041	0.047	0.052
					Feed (mm/min)	654	866	854	1063	946	1070	943	
≤ 300	SUPER ALLOYS (NICKEL, COBALT, IRON BASED) Inconel 601, 617, 625, Incoly 800, Monel 400	 Profile	1	≤ 0.05	32	RPM	1696	1272	1018	848	636	509	407
					(26-38)	Fz	0.017	0.030	0.037	0.043	0.051	0.059	0.065
					Feed (mm/min)	202	267	214	328	292	330	291	
		 Finish	2	≤ 0.02	38	RPM	2036	1527	1221	1018	763	611	489
					(31-46)	Fz	0.014	0.024	0.030	0.034	0.041	0.047	0.052
					Feed (mm/min)	194	256	253	315	280	317	279	
> 300	SUPER ALLOYS (NICKEL, COBALT, IRON BASED – DIFFICULT) Inconel 718, 750X, Incoly 925, Waspaloy, Hastelloy, Rene	 Profile	1	≤ 0.05	26	RPM	1378	1034	827	689	517	413	331
					(21-31)	Fz	0.012	0.020	0.025	0.030	0.035	0.039	0.044
					Feed (mm/min)	113	143	142	184	162	176	159	
		 Finish	2	≤ 0.02	31	RPM	1654	1240	992	827	620	496	397
					(25-37)	Fz	0.009	0.016	0.020	0.024	0.028	0.031	0.035
					Feed (mm/min)	108	138	137	177	155	169	153	
≤ 350	TITANIUM ALLOYS Pure Titanium, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si	 Profile	1	≤ 0.05	119	RPM	6308	4731	3785	3154	2365	1892	1514
					(95-143)	Fz	0.019	0.032	0.040	0.050	0.059	0.067	0.073
					Feed (mm/min)	839	1060	1060	1419	1256	1395	1216	
		 Finish	2	≤ 0.02	143	RPM	7570	5677	4542	3785	2839	2271	1817
					(114-171)	Fz	0.015	0.026	0.032	0.040	0.047	0.054	0.058
					Feed (mm/min)	805	1017	1017	1363	1206	1339	1167	
> 350 ≤ 450	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3	 Profile	1	≤ 0.05	43	RPM	2279	1710	1368	1140	855	684	547
					(34-52)	Fz	0.019	0.032	0.040	0.050	0.059	0.067	0.073
					Feed (mm/min)	303	383	383	513	454	504	439	
		 Finish	2	≤ 0.02	52	RPM	2735	2051	1641	1368	1026	821	656
					(41-62)	Fz	0.015	0.026	0.032	0.040	0.047	0.054	0.058
					Feed (mm/min)	291	368	368	492	436	484	422	

*Maximum recommended depth shown

*Reduce speed and feed recommendations for materials harder than listed

*Above recommendations are based on ideal conditions. Adjust parameters accordingly for smaller taper machining centers or less rigid conditions

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