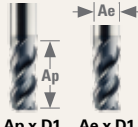







Hardness BRINELL	Series 66, 66CR Fractional				Vc (SFM)	Diameter (inch)							
		Ap x D1	Ae x D1										
						3/16	1/4	3/8	1/2	5/8	3/4	1	
≤ 175	CARBON STEEL 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	 Profile	1	≤ 0.05	720	RPM	14669	11002	7334	5501	4401	3667	2750
					(576-864)	Fz	0.0009	0.0012	0.0022	0.0030	0.0033	0.0036	0.0042
					Feed (IPM)	92	92	113	149	131	145	127	
		 Finish	2	≤ 0.02	864	RPM	17603	13202	8801	6601	5281	4401	3300
					(691-1037)	Fz	0.0007	0.0010	0.0018	0.0024	0.0026	0.0029	0.0034
					Feed (IPM)	89	89	108	143	125	139	122	
≤ 275	ALLOY STEEL 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	 Profile	1	≤ 0.05	530	RPM	10798	8098	5399	4049	3239	2699	2025
					(424-636)	Fz	0.0006	0.0009	0.0017	0.0023	0.0026	0.0028	0.0032
					Feed (IPM)	45	51	64	84	76	83	71	
		 Finish	2	≤ 0.02	636	RPM	12957	9718	6479	4859	3887	3239	2430
					(509-763)	Fz	0.0005	0.0007	0.0014	0.0018	0.0021	0.0022	0.0026
					Feed (IPM)	44	49	62	80	73	80	68	
≤ 375	TOOL STEEL A2, D2, H13, L2, M2, P20, S7, T15, W2	 Profile	1	≤ 0.05	290	RPM	5908	4431	2954	2216	1772	1477	1108
					(232-348)	Fz	0.0004	0.0006	0.0012	0.0016	0.0018	0.0019	0.0022
					Feed (IPM)	17	19	25	32	29	31	27	
		 Finish	2	≤ 0.02	348	RPM	7090	5317	3545	2659	2127	1772	1329
					(278-418)	Fz	0.0003	0.0005	0.0010	0.0013	0.0014	0.0015	0.0018
					Feed (IPM)	16	18	24	31	28	30	26	
≤ 260	CAST IRON (LOW / MEDIUM ALLOY) Gray, Malleable, Ductile	 Profile	1	≤ 0.05	525	RPM	10696	8022	5348	4011	3209	2674	2006
					(420-630)	Fz	0.0008	0.0012	0.0022	0.0030	0.0033	0.0036	0.0042
					Feed (IPM)	60	67	82	108	95	106	93	
		 Finish	2	≤ 0.02	630	RPM	12835	9626	6418	4813	3851	3209	2407
					(504-756)	Fz	0.0006	0.0010	0.0018	0.0024	0.0026	0.0029	0.0034
					Feed (IPM)	58	65	79	104	91	102	89	
> 260 ≤ 320	CAST IRON (DIFFICULT / HIGH ALLOY) Gray, Malleable, Ductile	 Profile	1	≤ 0.05	300	RPM	6112	4584	3056	2292	1834	1528	1146
					(240-360)	Fz	0.0002	0.0003	0.0006	0.0008	0.0008	0.0009	0.0011
					Feed (IPM)	9	10	12	16	14	15	13	
		 Finish	2	≤ 0.02	360	RPM	7334	5501	3667	2750	2200	1834	1375
					(288-432)	Fz	0.0001	0.0002	0.0005	0.0006	0.0007	0.0007	0.0008
					Feed (IPM)	5	9	12	15	13	15	13	
≤ 185	STAINLESS STEEL (FREE MACHINING) 303, 416, 420F, 430F 440F	 Profile	1	≤ 0.05	560	RPM	11409	8557	5705	4278	3423	2852	2139
					(448-672)	Fz	0.0006	0.0009	0.0017	0.0023	0.0026	0.0028	0.0032
					Feed (IPM)	48	54	68	89	80	88	75	
		 Finish	2	≤ 0.02	672	RPM	13691	10268	6845	5134	4107	3423	2567
					(538-806)	Fz	0.0005	0.0007	0.0014	0.0018	0.0021	0.0022	0.0026
					Feed (IPM)	46	52	65	85	77	84	72	