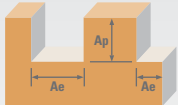


Speed & Feed Recommendations

Series 21M, 22M Metric		 Ae x D ₁ Ap x D ₁		Vc (m/min)		Diameter (D ₁) (mm)				
						3	6	10	12	20
HARDWOODS	 Slot	1	≤ 1	470	RPM	49828	24914	14948	12457	7474
				(376-564)	Fz	0.020	0.040	0.065	0.075	0.115
					Feed (mm/min)	1993	1993	1943	1869	1719
	 Profile	≤ 0.5	≤ 1.5	470	RPM	49828	24914	8155	4241	1509
				(376-564)	Fz	0.020	0.040	0.065	0.075	0.115
					Feed (mm/min)	1993	1993	1060	636	347
SOFTWOODS	 Slot	1	≤ 1	600	RPM	63610	31805	19083	15903	9542
				(480-720)	Fz	0.025	0.050	0.075	0.090	0.140
					Feed (mm/min)	3181	3181	2862	2862	2672
	 Profile	≤ 0.5	≤ 1.5	600	RPM	63610	31805	19083	15903	303467
				(480-720)	Fz	0.025	0.050	0.075	0.090	0.140
					Feed (mm/min)	3181	3181	2862	2862	84971
PLYWOODS	 Slot	1	≤ 1	600	RPM	63610	31805	19083	15903	9542
				(480-720)	Fz	0.030	0.065	0.100	0.125	0.190
					Feed (mm/min)	3817	4135	3817	3976	3626
	 Profile	≤ 0.5	≤ 1.5	600	RPM	63610	31805	19083	15903	303467
				(480-720)	Fz	0.030	0.065	0.100	0.125	0.190
					Feed (mm/min)	3817	4135	3817	3976	115318
ALUMINUM ALLOYS	 Slot	1	≤ 1	350	RPM	37106	18553	11132	9276	5566
				(289-420)	Fz	0.015	0.040	0.050	0.065	0.100
					Feed (mm/min)	1113	1484	1113	1206	1113
	 Profile	≤ 0.5	≤ 1.5	350	RPM	37106	18553	11132	9276	177023
				(289-420)	Fz	0.015	0.040	0.050	0.065	0.100
					Feed (mm/min)	1113	1484	1113	1206	35405
PLASTICS	 Slot	1	≤ 1	600	RPM	63610	31805	19083	15903	9542
				(480-720)	Fz	0.020	0.040	0.065	0.090	0.125
					Feed (mm/min)	2544	2544	2481	2862	2385
	 Profile	≤ 0.5	≤ 1.5	600	RPM	63610	31805	19083	15903	9542
				(480-720)	Fz	0.020	0.040	0.065	0.090	0.125
					Feed (mm/min)	2544	2544	2481	2862	2385

rpm = (1000 x m/min) / (3.14 x D₁)
mm / min = (mm / flute) x 2 x rpm