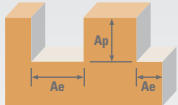


	Series 66, 66CR Fractional	Hardness BRINELL			Vc (SFM)		Diameter (D ₁) (inch)						
			Ae x D ₁	Ap x D ₁			3/16	1/4	3/8	1/2	5/8	3/4	1
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 275	 Profile ≤ 0.05 ≤ 1		635	RPM	12937	9703	6469	4851	3881	3234	2426
					(508-762)	Fz	0.0008	0.0012	0.0022	0.0030	0.0037	0.0038	0.0042
						Feed (IPM)	72.4	81.5	99.6	131.0	129.2	135.2	112.1
			 Finish ≤ 0.02 ≤ 2		762	RPM	15524	11643	7762	5822	4657	3881	2911
					(610-914)	Fz	0.0006	0.0010	0.0018	0.0024	0.0030	0.0030	0.0034
						Feed (IPM)	69.5	78.2	95.6	125.7	124.1	129.8	107.6
P	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 375	 Profile ≤ 0.05 ≤ 1		360	RPM	7334	5501	3667	2750	2200	1834	1375
					(288-432)	Fz	0.0006	0.0009	0.0017	0.0023	0.0029	0.0030	0.0032
						Feed (IPM)	30.8	34.7	43.6	56.9	57.4	60.5	48.4
			 Finish ≤ 0.02 ≤ 2		432	RPM	8801	6601	4401	3300	2640	2200	1650
					(346-518)	Fz	0.0005	0.0007	0.0014	0.0018	0.0023	0.0024	0.0026
						Feed (IPM)	29.6	33.3	41.9	54.7	55.1	58.1	46.5
P	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 375	 Profile ≤ 0.05 ≤ 1		290	RPM	5908	4431	2954	2216	1772	1477	1108
					(232-348)	Fz	0.0004	0.0006	0.0012	0.0016	0.0020	0.0021	0.0022
						Feed (IPM)	16.5	18.6	24.8	31.9	31.9	34.1	26.8
			 Finish ≤ 0.02 ≤ 2		348	RPM	7090	5317	3545	2659	2127	1772	1329
					(278-418)	Fz	0.0003	0.0005	0.0010	0.0013	0.0016	0.0017	0.0018
						Feed (IPM)	15.9	17.9	23.8	30.6	30.6	32.8	25.7
K	CAST IRONS (LOW & MEDIUM ALLOY) Gray, Malleable, Ductile	≤ 220	 Profile ≤ 0.05 ≤ 1		705	RPM	14363	10772	7182	5386	4309	3591	2693
					(564-846)	Fz	0.0008	0.0012	0.0022	0.0030	0.0037	0.0038	0.0042
						Feed (IPM)	80.4	90.5	110.6	145.4	143.5	150.1	124.4
			 Finish ≤ 0.02 ≤ 2		846	RPM	17236	12927	8618	6463	5171	4309	3232
					(677-1015)	Fz	0.0006	0.0010	0.0018	0.0024	0.0030	0.0030	0.0034
						Feed (IPM)	77.2	86.9	106.2	139.6	137.7	144.1	119.4
K	CAST IRONS (HIGH ALLOY) Gray, Malleable, Ductile	> 220 ≤ 260	 Profile ≤ 0.05 ≤ 1		540	RPM	11002	8251	5501	4126	3300	2750	2063
					(432-648)	Fz	0.0006	0.0009	0.0017	0.0023	0.0029	0.0030	0.0032
						Feed (IPM)	46.2	52.0	65.5	85.4	86.1	90.8	72.6
			 Finish ≤ 0.02 ≤ 2		648	RPM	13202	9901	6601	4951	3961	3300	2475
					(518-778)	Fz	0.0005	0.0007	0.0014	0.0018	0.0023	0.0024	0.0026
						Feed (IPM)	44.4	49.9	62.8	82.0	82.7	87.1	69.7
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F 440F	≤ 275	 Profile ≤ 0.05 ≤ 1		560	RPM	11409	8557	5705	4278	3423	2852	2139
					(448-672)	Fz	0.0006	0.0009	0.0017	0.0023	0.0029	0.0030	0.0032
						Feed (IPM)	47.9	53.9	67.9	88.6	89.3	94.1	75.3
			 Finish ≤ 0.02 ≤ 2		448	RPM	9127	6845	4564	3423	2738	2282	1711
					(358-538)	Fz	0.0005	0.0007	0.0014	0.0018	0.0023	0.0024	0.0026
						Feed (IPM)	30.7	34.5	43.4	56.7	57.2	60.2	48.2

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