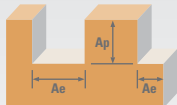


Series 66M, 66MCR Metric	Hardness BRINELL				Vc (m/min)	Diameter (D ₁) (mm)							
		Ae x D ₁	Ap x D ₁			6	8	10	12	16	20	25	
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	 Profile	≤ 0.05	≤ 1	194	RPM	10260	7695	6156	5130	3847	3078	2462
					(155-232)	Fz	0.029	0.047	0.059	0.072	0.095	0.101	0.105
					Feed (mm/min)	2068	2528	2528	3324	3280	3431	2844	
		 Finish	≤ 0.02	≤ 2	232	RPM	12312	9234	7387	6156	4617	3693	2955
					(186-279)	Fz	0.023	0.038	0.047	0.058	0.076	0.081	0.084
					Feed (mm/min)	1985	2427	2427	3191	3149	3294	2730	
P	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	 Profile	≤ 0.05	≤ 1	110	RPM	5816	4362	3490	2908	2181	1745	1396
					(88-132)	Fz	0.022	0.036	0.045	0.055	0.074	0.080	0.080
					Feed (mm/min)	879	1108	1107	1445	1457	1536	1229	
		 Finish	≤ 0.02	≤ 2	132	RPM	6980	5235	4188	3490	2617	2094	1675
					(105-158)	Fz	0.017	0.029	0.036	0.044	0.059	0.064	0.064
					Feed (mm/min)	844	1063	1063	1387	1399	1474	1179	
P	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	 Profile	≤ 0.05	≤ 1	88	RPM	4686	3514	2811	2343	1757	1406	1125
					(71-106)	Fz	0.014	0.026	0.032	0.038	0.051	0.056	0.055
					Feed (mm/min)	472	630	630	810	810	866	680	
		 Finish	≤ 0.02	≤ 2	106	RPM	5622.615	4217	3374	2811	2108	1687	1349
					(85-127)	Fz	0.012	0.020	0.026	0.031	0.041	0.045	0.044
					Feed (mm/min)	453	605	605	777	777	831	653	
K	CAST IRONS (LOW & MEDIUM ALLOY) Gray, Malleable, Ductile	 Profile	≤ 0.05	≤ 1	215	RPM	11391	8543	6834	5695	4271	3417	2734
					(172-258)	Fz	0.029	0.047	0.059	0.072	0.095	0.101	0.105
					Feed (mm/min)	2296	2807	2807	3690	3641	3809	3158	
		 Finish	≤ 0.02	≤ 2	258	RPM	13669	10252	8201	6834	5126	4101	3281
					(206-309)	Fz	0.023	0.038	0.047	0.058	0.076	0.081	0.084
					Feed (mm/min)	2204	2695	2694	3543	3496	3657	3031	
K	CAST IRONS (HIGH ALLOY) Gray, Malleable, Ductile	 Profile	≤ 0.05	≤ 1	165	RPM	8725	6544	5235	4362	3272	2617	2094
					(132-198)	Fz	0.022	0.036	0.045	0.055	0.074	0.080	0.080
					Feed (mm/min)	1319	1661	1661	2167	2186	2303	1843	
		 Finish	≤ 0.02	≤ 2	198	RPM	10470	7852	6282	5235	3926	3141	2513
					(158-237)	Fz	0.017	0.029	0.036	0.044	0.059	0.064	0.064
					Feed (mm/min)	1266	1595	1595	2080	2099	2211	1769	
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F 440F	 Profile	≤ 0.05	≤ 1	171	RPM	9048	6786	5429	4524	3393	2714	2171
					(137-205)	Fz	0.022	0.036	0.045	0.055	0.074	0.080	0.080
					Feed (mm/min)	1368	1723	1723	2247	2267	2389	1911	
		 Finish	≤ 0.02	≤ 2	137	RPM	7238	5429	4343	3619	2714	2171	1737
					(109-164)	Fz	0.017	0.029	0.036	0.044	0.059	0.064	0.064
					Feed (mm/min)	875	1103	1103	1438	1451	1529	1223	

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