



Series 56MB Metric	Hardness BRINELL			Vc (m/min)	Diameter (D ₁) (mm)							
		Ae x D ₁	Ap x D ₁		1	1.5	3	5	6	10	12	20
P	≤ 370	 Rough ≤ 0.4 ≤ 0.1	191	RPM	60748	40498	20249	12150	10125	6075	5062	3037
			(153-229)	Fz	0.015	0.038	0.076	0.102	0.127	0.203	0.254	0.305
				Feed (mm/min)	1822	3078	3078	2479	2572	2466	2572	1853
		 HSM ≤ 0.4 ≤ 0.03	290	RPM	92235	61490	46117	18447	15372	9223	7686	4612
			(232-348)	Fz	0.018	0.043	0.084	0.112	0.117	0.224	0.279	0.330
				Feed (mm/min)	3320	5288	7748	4132	3597	4132	4289	3044
P	> 370 ≤ 475	 Rough ≤ 0.4 ≤ 0.05	229	RPM	72833	48556	24278	14567	12139	7283	6069	3642
			(183-275)	Fz	0.013	0.028	0.058	0.076	0.097	0.152	0.191	0.216
				Feed (mm/min)	1894	2719	2816	2214	2355	2214	2319	1573
		 HSM ≤ 0.4 ≤ 0.02	351	RPM	111636	74424	37212	22327	18606	11164	9303	5582
			(281-421)	Fz	0.015	0.030	0.064	0.084	0.107	0.168	0.208	0.254
				Feed (mm/min)	3349	4465	4763	3751	3982	3751	3870	2836
H	> 475 ≤ 655	 Rough ≤ 0.4 ≤ 0.04	152	RPM	48344	32229	16115	9669	8057	4834	4029	2417
			(122-182)	Fz	0.010	0.020	0.043	0.058	0.074	0.114	0.145	0.160
				Feed (mm/min)	967	1289	1386	1122	1192	1102	1168	773
		 HSM ≤ 0.4 ≤ 0.01	305	RPM	97005	64670	32335	19401	16168	9701	8084	4850
			(244-366)	Fz	0.013	0.023	0.048	0.064	0.081	0.127	0.160	0.180
				Feed (mm/min)	2522	2975	3104	2483	2619	2464	2587	1746

rpm = (1000 x m/min) / (3.14 x D₁)

mm / min = (mm / flute) x 2 x rpm

HSM (high speed machining)

reduce speed and feed for materials harder than listed

reduce feed and Ae when finish milling (.02 x D₁ maximum)

refer to the SGS Tool Wizard for complete technical information ()