

Speed and Feed Recommendations for Cutting Die Molds (Metric)

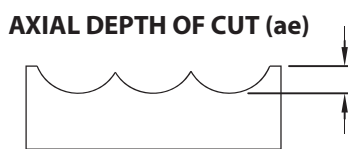
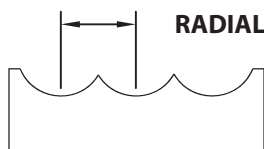
Roughing

(Reference series: 950MX)

| DIAMETER | RPM | | CHIPLOAD PER FLUTE (Fz) | |
|----------|-----------------|-----------------|-------------------------|-------------|
| | 40 - 50 HRc | 50 - 60 HRc | 40 - 50 HRc | 50 - 60 HRc |
| 1.0 | 20,000 - 40,000 | 20,000 - 40,000 | .013 - .018 | .010 - .013 |
| 1.5 | 20,000 - 40,000 | 20,000 - 40,000 | .025 - .038 | .020 - .025 |
| 2.0 | 20,000 - 32,000 | 20,000 - 30,000 | .038 - .050 | .025 - .038 |
| 3.0 | 18,000 - 24,000 | 15,000 - 20,000 | .050 - .065 | .038 - .050 |
| 4.0 | 12,000 - 16,000 | 10,000 - 14,000 | .075 - .100 | .050 - .075 |
| 6.0 | 9,000 - 12,000 | 7,500 - 10,000 | .100 - .125 | .065 - .100 |
| 8.0 | 7,000 - 10,000 | 6,000 - 8,500 | .125 - .165 | .088 - .125 |
| 10.0 | 6,000 - 8,000 | 5,000 - 7,000 | .150 - .190 | .110 - .150 |
| 12.0 | 4,500 - 6,000 | 4,000 - 5,500 | .200 - .250 | .140 - .200 |
| 16.0 | 3,500 - 5,000 | 3,000 - 4,500 | .225 - .275 | .165 - .225 |
| 20.0 | 3,000 - 4,000 | 2,500 - 3,500 | .250 - .300 | .190 - .250 |
| 25.0 | 2,300 - 3,000 | 2,000 - 2,500 | .275 - .325 | .215 - .275 |

Semi-Finishing and Finishing

| DIAMETER | RPM | | CHIPLOAD PER FLUTE (Fz) | |
|----------|-----------------|-----------------|-------------------------|-------------|
| | 40 - 50 HRc | 50 - 60 HRc | 40 - 50 HRc | 50 - 60 HRc |
| 1.0 | 20,000 - 40,000 | 20,000 - 40,000 | .010 - .013 | .008 - .010 |
| 1.5 | 20,000 - 40,000 | 20,000 - 40,000 | .020 - .025 | .013 - .020 |
| 2.0 | 20,000 - 40,000 | 20,000 - 40,000 | .025 - .038 | .020 - .030 |
| 3.0 | 20,000 - 40,000 | 20,000 - 36,000 | .038 - .050 | .025 - .038 |
| 4.0 | 20,000 - 32,000 | 20,000 - 25,000 | .050 - .075 | .038 - .050 |
| 6.0 | 18,000 - 25,000 | 15,000 - 18,000 | .065 - .100 | .050 - .075 |
| 8.0 | 14,000 - 19,000 | 12,000 - 14,000 | .088 - .125 | .065 - .100 |
| 10.0 | 12,000 - 16,000 | 10,000 - 12,000 | .110 - .150 | .075 - .110 |
| 12.0 | 9,000 - 12,000 | 7,500 - 9,000 | .140 - .200 | .100 - .150 |
| 16.0 | 6,500 - 9,000 | 5,000 - 7,000 | .165 - .225 | .125 - .175 |
| 20.0 | 5,500 - 7,500 | 4,000 - 6,000 | .190 - .250 | .150 - .200 |
| 25.0 | 4,000 - 6,000 | 3,500 - 5,500 | .215 - .275 | .175 - .225 |



| Roughing | |
|-------------|-------------------|
| Axial (ae) | 15% - 25% of Dia. |
| Radial (ap) | 20% - 30% of Dia. |

| Semi-Finishing | |
|----------------|-----------------|
| Axial (ae) | 5% - 8% of Dia. |
| Radial (ap) | 2% - 5% of Dia. |

| Finishing | |
|-------------|------------------|
| Axial (ae) | 1% - 3% of Dia. |
| Radial (ap) | .5% - 1% of Dia. |

High pressure air is recommended for clearing chips away from the cut.

NOTE - ABOVE ARE STARTING PARAMETERS ONLY. HIGHER RESULTS MAY BE ACHIEVED WITH OPTIMUM CONDITIONS.