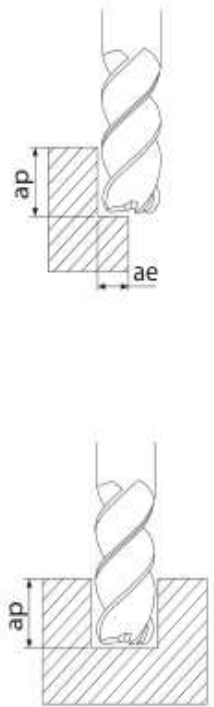


2 Flute end mill

Processing mode	Material	Mode	Dia(mm)	φ1	φ2	φ4	φ6	φ8	φ12	φ16
	carbon steel cast iron	Side	Speed(min <sup>-1</sup> )	25500	13200	6600	4400	3300	2200	1700
			Feed(mm/min)	225	230	375	415	420	310	240
		Groove	Speed(min <sup>-1</sup> )	19000	11000	6000	4000	3000	2000	1500
			Feed(mm/min)	135	140	225	250	250	245	245
	alloy steel	Side	Speed(min <sup>-1</sup> )	22000	11000	5600	3700	2800	1900	1400
			Feed(mm/min)	195	220	285	315	310	230	200
		Groove	Speed(min <sup>-1</sup> )	18000	9500	4800	3200	2400	1600	1200
			Feed(mm/min)	115	130	170	190	185	185	185
	Pre hardened steel (30-45 HRC)	Side	Speed(min <sup>-1</sup> )	17000	8800	4400	3000	2200	1500	1100
			Feed(mm/min)	55	80	100	105	105	110	110
		Groove	Speed(min <sup>-1</sup> )	16000	8000	4000	2700	2000	1300	990
			Feed(mm/min)	35	50	60	63	63	65	65
stainless steel	Side	Speed(min <sup>-1</sup> )	22000	11000	5600	3700	2800	1900	1400	
		Feed(mm/min)	95	95	110	115	115	115	115	
	Groove	Speed(min <sup>-1</sup> )	16000	8000	4000	2700	2000	1300	990	
		Feed(mm/min)	60	60	65	70	70	70	70	