

V7 YG-1

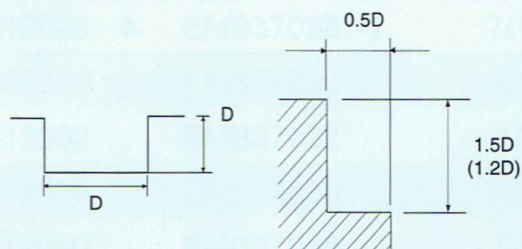
CARBIDE ENDMILLS

SPEED & FEED DATA

MATERIAL (material)	ALLOY STEELS CAST IRON (Legierte Stähle / Grauguss)		ALLOY STEELS CAST IRON (Legierte Stähle / Grauguss)		STAINLESS STEELS 300SERIES (Rostfreie Stähle 300Serien)		STAINLESS STEELS 400SERIES (Rostfreie Stähle 400Serien)		TITANIUM (Titanium)		INCONEL (Inconel)	
HARDNESS	~HB 300		HB 300~HB 380									
STRENGTH	~1000N/mm2		1000N/mm2~1300N/mm2									
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3	13475	275	9430	190	10185	195	14260	205	10185	205	2715	55
4	10105	330	7070	230	7600	250	14260	255	7600	255	2005	55
5	8085	370	5660	260	6110	310	8655	310	6110	310	1630	80
6	6735	435	4715	385	5095	360	7130	360	5095	360	1355	95
8	5050	555	3535	385	3820	435	5345	465	3280	465	1015	125
10	4455	690	3115	480	3055	590	4275	585	3055	585	815	155
12	3710	695	2600	485	2545	565	3565	565	2545	565	675	150
14	3180	620	2225	435	2180	520	3055	520	2180	520	580	140
16	2785	590	1950	410	1910	480	2670	480	1910	480	505	130
18	2475	585	1730	410	1695	475	2375	475	1695	475	450	125
20	2225	580	1560	405	1525	470	2140	470	1525	470	405	125
25	1780	450	1245	315	1215	380	1710	380	1215	380	320	110

RPM=REVOLUTION PER MIN.
FEED=mm/min.

•ALLOY STEELS CAST IRON / STAINLESS STEELS 300, 400SERIES / TITANIUM



•1.2 x D Axial cutting depth should be applied for Short length series DIA over 8mm

•INCONEL

