

Speeds and Feeds

Metric Chamfer Mills



Material Group	Material Subgroup	Material Description	Parameter	Diameter (Ø)						
				3	6	10	12	16	20	25
P	1	Non-alloy steel	Vc	78	78	78	78	78	78	78
			RPM	8170	4090	2450	2040	1530	1230	980
			Fz	0.013	0.025	0.043	0.048	0.061	0.076	0.097
	FEED		228.6	203.2	203.2	203.2	177.8	177.8	177.8	
	2		Vc	78	78	78	78	78	78	78
			RPM	8170	4090	2450	2040	1530	1230	980
			Fz	0.013	0.025	0.043	0.048	0.061	0.076	0.097
	3		Vc	56	56	56	56	56	56	56
			RPM	5940	2970	1780	1490	1110	890	710
			Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094
	4		FEED	127	127	127	152.4	127	127	127
		Vc	56	56	56	56	56	56	56	
		RPM	5940	2970	1780	1490	1110	890	710	
	5	Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094	
		FEED	127	127	127	152.4	127	127	127	
		Vc	49	49	49	49	49	49	49	
	6	RPM	5200	2600	1560	1300	970	780	620	
		Fz	0.010	0.023	0.038	0.046	0.058	0.076	0.094	
		FEED	101.6	101.6	127	127	127	127	127	
	7	Vc	78	78	78	78	78	78	78	
		RPM	8170	4090	2450	2040	1530	1230	980	
		Fz	0.013	0.025	0.043	0.048	0.061	0.076	0.097	
	8	FEED	228.6	203.2	203.2	203.2	177.8	177.8	177.8	
		Vc	56	56	56	56	56	56	56	
		RPM	5940	2970	1780	1490	1110	890	710	
	9	Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094	
		FEED	127	127	127	152.4	127	127	127	
		Vc	49	49	49	49	49	49	49	
	10	RPM	5200	2600	1560	1300	970	780	620	
		Fz	0.010	0.023	0.038	0.046	0.058	0.076	0.094	
		FEED	101.6	101.6	127	127	127	127	127	
	11.1	Vc	49	49	49	49	49	49	49	
		RPM	5200	2600	1560	1300	970	780	620	
Fz		0.010	0.023	0.038	0.046	0.058	0.076	0.094		
11.1	FEED	101.6	101.6	127	127	127	127	127		
	Vc	78	78	78	78	78	78	78		
	RPM	8170	4090	2450	2040	1530	1230	980		
11.1	Fz	0.013	0.025	0.043	0.048	0.061	0.076	0.097		
	FEED	228.6	203.2	203.2	203.2	177.8	177.8	177.8		
	Vc	49	49	49	49	49	49	49		
11.1	RPM	5200	2600	1560	1300	970	780	620		
	Fz	0.010	0.023	0.038	0.046	0.058	0.076	0.094		
	FEED	101.6	101.6	127	127	127	127	127		



Unit Definitions

Vc = Surface Meters per Minute
 Fz = Millimeters Per Tooth
 RPM = Revolutions per Minute

Feed = Millimeters per Minute

Ae = Width of Cut
 Ap = Depth of Cut
 D = Tool Diameter

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Material Group	Material Subgroup	Material Description	Parameter	Diameter (Ø)							
				3	6	10	12	16	20	25	
M	14.1		Vc	43	43	43	43	43	43	43	
			RPM	4460	2230	1340	1110	840	670	530	
			Fz	0.010	0.018	0.025	0.048	0.048	0.074	0.091	
			FEED	101.6	76.2	76.2	101.6	76.2	101.6	101.6	
K	15	Grey cast iron	Vc	56	56	56	56	56	56	56	
			RPM	5940	2970	1780	1490	1110	890	710	
			Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094	
			FEED	127	127	127	152.4	127	127	127	
	16		Grey cast iron	Vc	56	56	56	56	56	56	56
				RPM	5940	2970	1780	1490	1110	890	710
				Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094
				FEED	127	127	127	152.4	127	127	127
	17	Nodular cast iron		Vc	56	56	56	56	56	56	56
				RPM	5940	2970	1780	1490	1110	890	710
				Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094
				FEED	127	127	127	152.4	127	127	127
	18		Nodular cast iron	Vc	56	56	56	56	56	56	56
				RPM	5940	2970	1780	1490	1110	890	710
				Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094
				FEED	127	127	127	152.4	127	127	127
	19	Malleable cast iron		Vc	56	56	56	56	56	56	56
				RPM	5940	2970	1780	1490	1110	890	710
				Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094
				FEED	127	127	127	152.4	127	127	127
	20		Malleable cast iron	Vc	56	56	56	56	56	56	56
				RPM	5940	2970	1780	1490	1110	890	710
				Fz	0.010	0.020	0.036	0.051	0.058	0.074	0.094
				FEED	127	127	127	152.4	127	127	127



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Material Group	Material Subgroup	Material Description	Parameter	Diameter (Ø)							
				3	6	10	12	16	20	25	
N	21	Aluminum-wrought alloy	Vc	210	210	210	210	210	210	210	
			RPM	22280	11140	6690	5570	4180	3340	2670	
			Fz	0.020	0.043	0.069	0.076	0.107	0.135	0.168	
			FEED	914.4	939.8	914.4	863.6	889	914.4	914.4	
	22		Aluminum-wrought alloy	Vc	210	210	210	210	210	210	210
				RPM	22280	11140	6690	5570	4180	3340	2670
				Fz	0.020	0.043	0.069	0.076	0.107	0.135	0.168
				FEED	914.4	939.8	914.4	863.6	889	914.4	914.4
	23	Aluminum-wrought alloy		Vc	210	210	210	210	210	210	210
				RPM	22280	11140	6690	5570	4180	3340	2670
				Fz	0.020	0.043	0.069	0.076	0.107	0.135	0.168
				FEED	914.4	939.8	914.4	863.6	889	914.4	914.4
	24		Aluminum-cast, alloyed	Vc	210	210	210	210	210	210	210
				RPM	22280	11140	6690	5570	4180	3340	2670
				Fz	0.020	0.043	0.069	0.076	0.107	0.135	0.168
				FEED	914.4	939.8	914.4	863.6	889	914.4	914.4
	25	Aluminum-cast, alloyed		Vc	210	210	210	210	210	210	210
				RPM	22280	11140	6690	5570	4180	3340	2670
				Fz	0.020	0.043	0.069	0.076	0.107	0.135	0.168
				FEED	914.4	939.8	914.4	863.6	889	914.4	914.4



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