



# CHAMFER MILL

## Chamfer Mill Cutting Data

HaasTooling.com

### Haas Chamfer Tools

#### How To Use This Chart:

- 1) Select your material in the colored ISO chart.
- 2) Select your Cutting Diameter in the columns.
- 3) Start with the middle range of the recommended sfm (vc) and feed (ipt)  
-Adjust the sfm and/or feedrate based on your cutting conditions.

ISO	VDI 3323	Material Description		Insert Grade N30	OD (0.060-0.650) (INCH)
K	K10	Grey cast iron	●	Cutting Speed (vc = sfm)	361 - 623
				Feed (fz = ipt)	0.004 - 0.012
N	N20	Non-ferrous metals	●	Cutting Speed (vc = sfm)	1050 - 1739
				Feed (fz = ipt)	0.008 - 0.016

● Optimal    ○ Secondary