

# Speeds and Feeds



## Carbide Roughing End Mills (Hybrid AlCrN Coated) P/N 03-0680 - 03-0684

### Side Milling

ISO	Material Description	Depth of Cut (ap)	Width of Cut (ae)	Parameter	Diameter (inch)				
					0.375	0.500	0.625	0.750	1.000
				Number of Flutes	3	4	4	4	5
P	CARBON STEELS ALLOY STEELS CAST IRON <HRc 30	1.5D (ap)		SFM	950	1100	1030	1070	1320
				RPM	9677	8404	6295	5450	5042
				IPT	.0033	.0030	.0039	.0044	.0035
				IPM	95.81	100.85	98.21	95.92	88.24
	ALLOY STEELS TOOL STEELS HRc 30 - HRc 38	1.5D (ap)		SFM	785	825	825	905	990
				RPM	7997	6303	5042	4609	3782
				IPT	.0015	.0013	.0016	.0016	.0012
				IPM	35.98	32.78	32.27	29.50	22.69
H	HARDENED STEELS HRc 38 - HRc 45	1.5D (ap)		SFM	525	575	570	560	660
				RPM	5348	4393	3484	2852	2521
				IPT	.0015	.0013	.0015	.0015	.0012
				IPM	24.07	22.84	20.90	17.11	15.13
	HARDENED STEELS HRc 45 - HRc 55	1.0D (ap)		SFM	205	230	205	230	275
				RPM	2088	1757	1253	1171	1051
				IPT	.0019	.0015	.0013	.0013	.0012
				IPM	11.90	10.54	6.52	6.09	6.30

