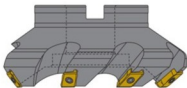
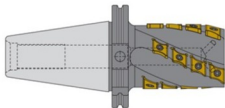


RECOMMENDED FEEDS & SPEEDS

VITESSES DE COUPE ET AVANCES RECOMMANDÉES

VELOCIDADES Y AVANCES RECOMENDADOS



MATERIALS MATERIALES	CAST IRON FONTES FUNDICION		STEELS ACIERS ACEROS			STAINLESS STEELS ACIERS INOXIDABLE ACEROS INOXIDABLE		INCONEL WASPALLOY HASTALLOY	TITANIUM	ALUMINUM ALUMINIO	
	GREY GRIS GRIS	NUDULAR	up to: 240 BHN 80 Kg / mm ²	240-300 BHN 80-100 Kg / mm ²	300-400 BHN 100-140 Kg / mm ²	300 SERIES 304, 316	400 SERIES 15-8 PH 17-4 PH	INCONEL WASPALLOY HASTALLOY	6AL 4 V	6061 T6 7075 T6	
	500-1000 SFM 150-300 M/min	400-600 SFM 120-240 M/min	500-1000 SFM 150-300 M/min	400-600 SFM 120-240 M/min	300-600 SFM 90-180 M/min	300-700 SFM 90-210 M/min	400-800 SFM 120-240 M/min	100-200 SFM 30-60 M/min	200-300 SFM 60-90 M/min	1500-5000 SFM 450-1515 M/min	
Tool Ø Inches	Feeds & Speeds Inches -Metric		Feeds & Speeds Inches -Metric		Feeds & Speeds Inches -Metric		Feeds & Speeds Inches -Metric	Feeds & Speeds Inches -Metric	Feeds & Speeds Inches -Metric		
Tool Ø mm	Feeds & Speeds Inches -Metric		Feeds & Speeds Inches -Metric		Feeds & Speeds Inches -Metric		Feeds & Speeds Inches -Metric	Feeds & Speeds Inches -Metric	Feeds & Speeds Inches -Metric		
1	RPM	2,290	1,910	2,290	1,910	1,720	1,525	1,910	575	880	7,640
25	Feed inches	9 → 18	7 → 15	9 → 18	7 → 15	7 → 14	6 → 12	7 → 15	3 → 6	4 → 10	60 → 120
	Feed mm	230 → 460	180 → 380	230 → 460	180 → 380	180 → 360	150 → 305	180 → 380	75 → 150	100 → 250	1,525 → 3,050
1-1/4	RPM	1,830	1,520	1,830	1,520	1,375	1,220	1,520	460	705	6,115
32	Feed inches	10 → 20	6 → 13	10 → 20	6 → 13	5 → 12	7 → 14	6 → 13	3 → 6	4 → 10	60 → 120
	Feed mm	250 → 500	150 → 330	250 → 500	150 → 330	130 → 305	180 → 360	150 → 330	75 → 150	100 → 250	1,525 → 3,050
1-1/2	RPM	1,525	1,275	1,525	1,275	1,145	1,015	1,275	385	585	5,085
40	Feed inches	12 → 22	10 → 20	12 → 22	10 → 20	8 → 16	8 → 16	10 → 20	3 → 7	4 → 11	60 → 120
	Feed mm	300 → 560	250 → 500	300 → 560	250 → 500	200 → 410	200 → 410	250 → 500	75 → 180	100 → 275	1,525 → 3,050
2	RPM	1,145	955	1,145	955	860	765	955	290	440	3,820
50	Feed inches	10 → 22	8 → 18	10 → 22	8 → 18	6 → 14	7 → 14	8 → 18	4 → 8	5 → 12	60 → 200
	Feed mm	250 → 560	200 → 460	250 → 560	200 → 460	150 → 360	180 → 360	200 → 460	100 → 200	130 → 300	1,525 → 5,080
2-1/2	RPM	915	764	915	764	690	610	764	230	350	3,055
63	Feed inches	11 → 18	10 → 20	11 → 18	10 → 20	8 → 15	7 → 14	10 → 20	3 → 7	6 → 12	60 → 200
	Feed mm	280 → 460	255 → 500	280 → 460	255 → 500	200 → 380	180 → 360	250 → 500	75 → 180	150 → 300	1,525 → 5,080
3	RPM	785	635	785	635	575	508	635	190	295	—
80	Feed inches	14 → 24	11 → 21	14 → 24	11 → 21	8 → 16	7 → 15	11 → 21	3 → 8	6 → 14	—
	Feed mm	355 → 600	280 → 530	355 → 610	280 → 530	200 → 400	180 → 380	280 → 530	75 → 200	150 → 355	—
4	RPM	575	475	575	475	430	380	475	145	220	—
100	Feed inches	10 → 20	9 → 18	10 → 20	9 → 18	7 → 14	7 → 12	9 → 18	3 → 8	5 → 12	—
	Feed mm	250 → 500	230 → 460	250 → 500	230 → 460	180 → 360	180 → 305	230 → 460	75 → 200	130 → 300	—

IF MACHINE SPEEDS ARE LOWER THAN SPEEDS SUGGESTED THE CHIP LOAD PER TOOTH SHOULD PREVAIL.

WARNING: Any cutting tool may break or shatter. The wearing of safety glasses is required by law. Grinding of this product may produce potentially hazardous dust. Use adequate ventilation.

SI LES VITESSES DES MACHINES SONT INFÉRIEURES AUX VITESSES DE COUPE SUGGÉRÉES, L'AVANCE PAR DENT PRÉVAUT.

AVERTISSEMENT : Tout outil peut briser ou éclater. La loi oblige le port de lunettes protectrices. Meuler ce produit peut causer des poussières dangereuses. S'assurer d'une ventilation adéquate.

SI LAS VELOCIDAD DE LA MÁQUINA ES INFERIOR A LAS VELOCIDADES RECOMENDADAS, L'AVANCE PER LIBIOS PREVALECE.

ADVERTENCIA : Todo utensil se posible romperse. Usar lentes de seguridad. Afilar este producto se posible producir peligroso polvo. Usar adecuada ventilación.