






MINICUT PATENTED - SUPER COBALT END MILL
Recommended Feeds & Speeds
Vitesse et avances Sugérées
Velocidades y Avances Recomendados

MATERIAL SPEED LIST NO.		Titanium Titan Titanio	Titanium Titan Titanio	Inconel Stainless Steels Inox Aceros Inoxidables	Steels-Aciars Acero - Stähle	ALUMINIUM ALUMINIO	HSM-UGV Alta Velocidad ALUMINIUM ALUMINIO						
		6AL4V	5553		300 - 400BHN								
		50-80 SFM	30-60 SFM	30-60 SFM	60-80 SFM	1000-2000 SFM	2000-4000 SFM						
		955 CY906 CY997 CY998	CY996 CY997 CY998	985 816	985 816	930 / 930P X930P / SF930 XSF930 / SC950	RPM						
θ	n / v_f												
3/8	n	570	570	510	210	480	480	640	640	12730	12730	22000	22000
	v_f	2.3	3.0	2.0	2.6	1.8	2.4	2.5	3.3	76	100	98	128
1/2	n	480	480	420	420	400	400	480	480	10600	10600	21200	21200
	v_f	2.2	2.8	2.0	2.5	1.8	2.4	2.8	3.6	95	124	127	165
5/8	n	320	320	290	290	300	300	390	390	7950	7950	15900	15900
	v_f	2.8	3.6	2.5	3.3	2.3	3.0	3.0	4.0	95	124	179	232
3/4	n	290	240	260	260	240	240	320	320	6360	6360	15900	15900
	v_f	3.2	4.2	2.8	3.7	2.6	3.4	3.8	5.0	95	124	167	217
1	n	230	230	200	200	190	190	240	240	5100	5100	12730	12730
	v_f	4.0	5.3	3.6	4.7	3.4	4.4	4.3	5.5	107	140	153	222
1 1/4	n	180	180	160	160	150	150	190	190	3970	3970	9950	9950
	v_f	4.7	6.1	4.3	5.5	4.0	5.1	4.5	6.0	107	140	149	144
1 1/2	n	150	150	130	130	120	120	160	160	3180	3180	7950	7950
	v_f	4.2	5.5	3.5	4.5	3.2	4.1	4.5	6.0	105	136	142	134
2	n	130	130	120	120	100	100	120	120	2540	6400	6400	6400
	v_f	4.0	5.2	2.7	3.5	2.5	3.2	3.5	4.6	91	119	124	161

- 6 FLUTES ARE RECOMMENDED FOR PROFILING
 INCREASE FEEDS BY 30% ON TIALN2 COATED TOOLS

- POUR DÉTOURAGE, 6 DENTS SONT RECOMMANDÉES
 AUGMENTER LES AVANCES DE 30% SUR OUTILS REVÊTUS TIALN2

- 6 LIBIOS RECOMENDADOS PARA EL PERFILEADO
 AUMENTAR AVANCES 30% POR FRESAS IN TIALN2

FEEDS: REDUCTION FACTORS FOR LONG LENGTH TOOLS

AVANCES : FACTEURS DE RÉDUCTION POUR SÉRIES LONGUES

AVANCES : FACTORES DE REDUCCIÓN PARA SERIA LARGA

3 X θ	-	75%
4 X θ	-	45%
5 X θ	-	35%
6 X θ	-	25%