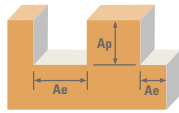


FRACTIONAL Turbo-Carb



Series 56B Fractional	Hardness	Ae x DC	Ap x DC	Vc (sfm)	DC • in									
					1/32	1/16	1/8	3/16	1/4	3/8	1/2	3/4		
H TOOL STEELS MOLD AND DIE STEEL 300M, 4340, 52100, HP-9-4-20, M50, A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 375 Bhn or ≤ 40 HRc	Rough 	≤ 0.4	≤ 0.1	625	RPM	76400	38200	19100	12733	9550	6367	4775	3183
					(500-750)	Fz	0.0006	0.0015	0.0030	0.0040	0.0050	0.0080	0.0100	0.0120
					Feed (ipm)	92	115	115	102	96	102	96	76	
		HSM 	≤ 0.4	≤ 0.03	950	RPM	116128	58064	29032	19355	14516	9677	7258	4839
					(760-1140)	Fz	0.0007	0.0017	0.0033	0.0044	0.0060	0.0088	0.0110	0.0130
					Feed (ipm)	163	197	192	170	174	170	160	126	
	≤ 475 Bhn or ≤ 50 HRc	Rough 	≤ 0.4	≤ 0.05	750	RPM	91680	45840	22920	15280	11460	7640	5730	3820
					(600-900)	Fz	0.0005	0.0011	0.0023	0.0030	0.0038	0.0060	0.0075	0.0085
					Feed (ipm)	92	101	105	92	87	92	86	65	
		HSM 	≤ 0.4	≤ 0.02	1150	RPM	140576	70288	35144	23429	17572	11715	8786	5857
					(920-1380)	Fz	0.0006	0.0012	0.0025	0.0033	0.0042	0.0066	0.0082	0.0100
					Feed (ipm)	169	169	176	155	148	155	144	117	
≤ 655 Bhn or ≤ 60 HRc	Rough 	≤ 0.4	≤ 0.04	500	RPM	61120	30560	15280	10187	7640	5093	3820	2547	
				(400-600)	Fz	0.0004	0.0008	0.0017	0.0023	0.0029	0.0045	0.0057	0.0063	
				Feed (ipm)	49	49	52	47	44	46	44	32		
	HSM 	≤ 0.4	≤ 0.01	1000	RPM	122240	61120	30560	20373	15280	10187	7640	5093	
				(800-1200)	Fz	0.0005	0.0009	0.0019	0.0025	0.0032	0.0050	0.0063	0.0071	
				Feed (ipm)	122	110	116	102	98	102	96	72		

Bhn (Brinell) HRc (Rockwell C) HSM (High Speed Machining)
 rpm = Vc x 3.82 / DC
 ipm = Fz x 2 x rpm
 reduce speed and feed for materials harder than listed
 reduce feed and Ae when finish milling (.02 x DC maximum)
 feed rates listed have chip thinning adjustments included where applicable
 refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)