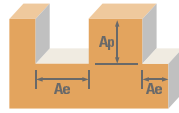










Single End Roughers (Coarse Pitch)



Series 61 Fractional	Hardness	Ae x DC	Ap x DC	Vc (sfm)	DC • in						
					1/4	3/8	1/2	3/4	1		
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	Profile 	≤ 0.5	≤ 1.5	500	RPM	7640	5093	3820	2547	1910
					(400-600)	Fz	0.0006	0.0011	0.0014	0.0017	0.0020
						Feed (ipm)	13.8	16.8	21.4	17.3	19.1
		Slot 	1	≤ 1	400	RPM	6112	4075	3056	2037	1528
					(320-480)	Fz	0.0006	0.0011	0.0014	0.0017	0.0020
						Feed (ipm)	11.0	13.4	17.1	13.9	15.3
	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	Profile 	≤ 0.5	≤ 1.5	365	RPM	5577	3718	2789	1859	1394
					(292-438)	Fz	0.0004	0.0008	0.0011	0.0013	0.0015
						Feed (ipm)	6.7	8.9	12.3	9.7	10.5
		Slot 	1	≤ 1	295	RPM	4508	3005	2254	1503	1127
					(236-354)	Fz	0.0004	0.0008	0.0011	0.0013	0.0015
						Feed (ipm)	5.4	7.2	9.9	7.8	8.5
K	CAST IRONS Gray, Malleable, Ductile	Profile 	≤ 0.5	≤ 1.5	365	RPM	5577	3718	2789	1859	1394
					(292-438)	Fz	0.0008	0.0015	0.0020	0.0024	0.0028
						Feed (ipm)	13.4	16.7	22.3	17.8	19.5
		Slot 	1	≤ 1	295	RPM	4508	3005	2254	1503	1127
					(236-354)	Fz	0.0008	0.0015	0.0020	0.0024	0.0028
						Feed (ipm)	10.8	13.5	18.0	14.4	15.8
H	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	Profile 	≤ 0.5	≤ 1.5	345	RPM	5272	3514	2636	1757	1318
					(276-414)	Fz	0.0006	0.0009	0.0015	0.0018	0.0021
						Feed (ipm)	9.5	9.5	15.8	12.7	13.8
		Slot 	1	≤ 1	275	RPM	4202	2801	2101	1401	1051
					(220-330)	Fz	0.0006	0.0009	0.0015	0.0018	0.0021
						Feed (ipm)	7.6	7.6	12.6	10.1	11.0

Bhn (Brinell) HRC (Rockwell C)
 rpm = (Vc x 3.82) / DC
 ipm = Fz x number of flutes x rpm
 reduce speed and feed for materials harder than listed
 refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)