

FRACTIONAL

Series M155



| Series M155 | | Hardness | Vc (sfm) | | DC • in | | | | |
|--------------------|--|-----------------------------|------------|------------|---------|---------|--------|--------|--------|
| | | | | | 0.126 | 0.158 | 0.197 | 0.236 | 0.264 |
| S | Titanium Alloys | | 100 | RPM | 3032 | 2425 | 1940 | 1617 | 1448 |
| | Pure Titanium, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V | ≤ 350 Bhn or ≤ 38 HRc | (80-120) | Fr | 0.00185 | 0.00231 | 0.0029 | 0.0035 | 0.0039 |
| | | | | Feed (ipm) | 5.6 | 5.6 | 5.6 | 5.6 | 5.6 |
| N | Aluminum Alloys | | 450 | RPM | 13643 | 10914 | 8730 | 7278 | 6516 |
| | 2017, 2024, 356, 6061, 7075 | ≤ 150 Bhn or ≤ 7 HRc | (360-540) | Fr | 0.00550 | 0.00687 | 0.0086 | 0.0103 | 0.0115 |
| | | | | Feed (ipm) | 75.0 | 75.0 | 75.0 | 75.0 | 75.0 |
| | Copper Alloys | | 350 | RPM | 10611 | 8489 | 6790 | 5660 | 5068 |
| | Alum Bronze, C110, Muntz Brass | ≤ 140 Bhn or ≤ 3 HRc | (280-420) | Fr | 0.00547 | 0.00683 | 0.0085 | 0.0102 | 0.0114 |
| | | | | Feed (ipm) | 58.0 | 58.0 | 58.0 | 58.0 | 58.0 |
| Plastics | | 575 | RPM | 17433 | 13946 | 11155 | 9299 | 8326 | |
| Polycarbonate, PVC | | (460-690) | Fr | 0.00631 | 0.00789 | 0.0099 | 0.0118 | 0.0132 | |
| | | | Feed (ipm) | 110.0 | 110.0 | 110.0 | 110.0 | 110.0 | |

Bhn (Brinell) HRc (Rockwell C) HRb (Rockwell B)

$rpm = Vc \times 3.82 / DC$

$ipm = Fr \times rpm$ (Fr x maximum available rpm when recommendation exceeds machine limit)

reduce speed and feed for materials harder than listed

refer to the KYOCERA SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)