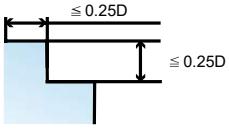
SSM/SCDM Chamfer End Mill

SCDM
Specification page
P31-32

WORK MATERIAL	MILD STEELS, CARBON STEELS, CAST IRON SS400、S55C、FC250 (~750N/mm²)		ALLOY STEELS, TOOL STEELS SCM、SKT、SKS、SKD (~30HRC)		HARDENED STEELS, PREHARDENED STEELS SKT、SKD、NAK55、HPM1 (30~38HRC)		STAINLESS STEELS, HARDENED STEELS SUS304、SKD (38~45HRC)		HARDENED STEELS, TITANIUM ALLOY STEELS (45~55HRC)		MAGNALIUM ALLOY, TITANIUM, TITANIUM ALLOY	
MILL DIA. (mm)	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)	SPEED (min^{-1})	FEED (mm/min)
Cutting Type	Chamfer	Hole Chamfer/ Centering	Chamfer	Hole Chamfer/ Centering	Chamfer	Hole Chamfer/ Centering	Chamfer	Hole Chamfer/ Centering	Chamfer	Hole Chamfer/ Centering	Chamfer	Hole Chamfer/ Centering
Vc	80-140	40-70	60-100	30-50	30-80	15-40	20-50	10-25	15-40	7.5-20	120-200	60-100
Diameter (mm)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)	fz (mm/z)	fz (mm/rev)
6	0.05	0.075	0.045	0.0675	0.045	0.0675	0.035	0.0525	0.03	0.045	0.07	0.105
8	0.06	0.09	0.055	0.0825	0.055	0.0825	0.04	0.06	0.035	0.0525	0.08	0.12
10	0.07	0.105	0.065	0.0975	0.065	0.0975	0.045	0.0675	0.04	0.06	0.09	0.135
12	0.08	0.12	0.075	0.1125	0.075	0.1125	0.05	0.075	0.045	0.0675	0.1	0.15
DEPTH OF CUT												

www.speedtigertools.com