TSTE/TTE 2 Flutes Slotting

WORK MATERIAL	COPPER, COPPER ALLOY		MILD STEELS, CARBON STEELS, SS400、S55C、FC250、NAK55		HARDENED STEELS, PREHARDENED STEELS, STAINLESS STEELS SKT、SKD61、NAK80、HPM1、DH			
			~32HRC		33~41HRC		42~50HRC	
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)
1	47,500	280	17,500	96	12,500	72	11,000	52
1.5	32,000	256	12,500	96	8,900	72	7,900	52
2	24,000	248	9,700	104	7,000	72	6,300	56
2.5	20,000	280	8,200	128	6,100	72	5,300	56
3	16,000	320	6,900	136	5,300	80	4,400	60
3.5	14,000	336	6,000	152	4,600	96	3,800	64
4	12,000	360	5,400	168	4,200	100	3,500	72
4.5	10,500	400	5,100	192	3,900	104	3,200	76
5	9,500	432	4,800	216	3,500	104	3,000	80
5.5	8,800	432	4,400	216	3,200	104	2,700	80
6	7,900	424	4,000	216	2,900	104	2,500	80
6.5	7,500	424	3,700	216	2,700	104	2,300	80
7	6,900	424	3,400	216	2,500	104	2,100	80
7.5	6,400	424	3,200	216	2,300	104	2,000	80
8	5,900	416	3,000	208	2,200	100	1,900	80
8.5	5,600	416	2,800	208	2,000	100	1,700	80
9	5,300	408	2,600	208	1,900	100	1,500	80
9.5	5,100	408	2,500	208	1,800	100	1,400	76
10	4,700	400	2,400	200	1,700	100	1,500	76
11	4,400	400	2,200	200	1,600	100	1,100	76
12	4,000	408	2,000	200	1,400	100	1,200	76
16	3,000	320	1,500	160	1,100	92	800	64
18	2,700	288	1,300	144	900	80	700	56
20	2,400	240	1,200	120	800	72	600	48
DEPTH OF CUT								



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