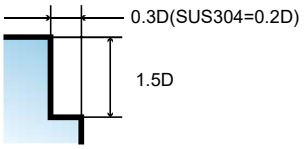
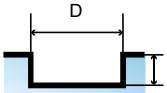
TSTE/TTE 3 Flutes Slotting

TSTE/TTE
Specification page
P19

WORK MATERIAL	COPPER, ALUMINUM ALLOY		MILD STEELS, CARBON STEELS, SS400、S55C、FC250、NAK55		HARDENED STEELS, PREHARDENED STEELS, STAINLESS STEELS SKT、SKD61、NAK80、HPM1、DH			
			~32HRC		HRC33~41		HRC42~50	
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	420	17,500	144	12,500	108	11,000	78
1.5	32,000	384	12,500	144	8,900	108	7,900	78
2	24,000	372	9,700	156	7,000	108	6,300	84
2.5	20,000	420	8,200	192	6,100	108	5,300	84
3	16,000	480	6,900	204	5,300	120	4,400	90
3.5	14,000	504	6,000	228	4,600	144	3,800	96
4	12,000	540	5,400	252	4,200	150	3,500	108
4.5	10,500	600	5,100	288	3,900	156	3,200	114
5	9,500	648	4,800	324	3,500	156	3,000	120
5.5	8,800	648	4,400	324	3,200	156	2,700	120
6	7,900	636	4,000	324	2,900	156	2,500	120
6.5	7,500	636	3,700	324	2,700	156	2,300	120
7	6,900	636	3,400	324	2,500	156	2,100	120
7.5	6,400	636	3,200	324	2,300	156	2,000	120
8	5,900	624	3,000	312	2,200	150	1,900	120
8.5	5,600	624	2,800	312	2,000	150	1,700	120
9	5,300	612	2,600	312	1,900	150	1,500	120
9.5	5,100	612	2,500	312	1,800	150	1,400	114
10	4,700	600	2,400	300	1,700	150	1,500	114
11	4,400	600	2,200	300	1,600	150	1,100	114
12	4,000	612	2,000	300	1,400	150	1,200	114
16	3,000	480	1,500	240	1,100	138	800	96
18	2,700	432	1,300	216	900	120	700	84
20	2,400	360	1,200	180	800	108	600	72

DEPTH OF CUT





Ø1~2.5=0.5D
Ø3~12=1D
(SKD, SCM=0.5D)

www.speedtigertools.com