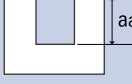




List 3619 - EXOCARB® WXL®: 2 Flute, Square End, Stub Length

Slotting

Hardness	-		<32 HRC		33-41 HRC		42-50 HRC							
Work Material	Copper		Mild Steels		Hardened Steels Pre-hardened Steels									
Cutting Speed	495 SFM		245 SFM		175 SFM		150 SFM							
Depth of Cut	<table border="1" style="display: inline-table; margin-right: 20px;"> <thead> <tr> <th>Dia</th> <th>aa</th> </tr> </thead> <tbody> <tr> <td>D<1/8</td> <td>0.3D</td> </tr> <tr> <td>1/8≤D</td> <td>0.5D</td> </tr> </tbody> </table> 								Dia	aa	D<1/8	0.3D	1/8≤D	0.5D
Dia	aa													
D<1/8	0.3D													
1/8≤D	0.5D													
Mill Diameter	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min						
1/16	25,000	10.7	15,000	6.2	10,700	4.6	9,200	3.2						
5/64	24,200	12.9	12,000	6.6	8,600	4.5	7,300	3.3						
3/32	20,200	14.3	10,000	7.2	7,100	4.1	6,100	3.1						
7/64	17,300	15.5	8,600	8.3	6,100	4.5	5,200	3.3						
1/8	15,100	17.5	7,500	8.6	5,300	4.7	4,600	3.5						
5/32	12,100	18.8	6,000	9.6	4,300	5.2	3,700	3.8						
3/16	10,100	21.1	5,000	11.0	3,600	5.1	3,000	3.7						
1/4	7,600	22.2	3,700	11.2	2,700	5.3	2,300	4.0						
5/16	6,000	21.9	3,000	10.7	2,100	4.8	1,800	3.8						
3/8	5,000	20.7	2,500	10.7	1,800	5.1	1,500	4.1						
7/16	4,300	20.2	2,100	9.9	1,500	4.8	1,300	4.5						
1/2	3,800	20.0	1,900	9.8	1,300	4.7	1,200	3.8						
5/8	3,000	16.5	1,500	8.3	1,000	4.2	900	3.6						
3/4	2,500	13.8	1,200	6.9	900	4.1	800	3.2						

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
3. Use a suitable cutting fluid with high smoke retardant.

ABOUT OSG

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