



List 3720 - EXOCARB® WXL®: 2 Flute, Stub Length

Slotting

Hardness	-		<32 HRC		33-41 HRC		42-50 HRC											
Work Material	Copper Copper Alloys		Mild Steels Carbon Steels		Hardened Steels, Pre-hardened Steels Stainless Steels													
Cutting Speed	52-682 SFM*		41-323 SFM*		41-241 SFM*		41-208 SFM*											
Depth of Cut			<table border="1"> <tr> <th>Dia</th> <th>aa</th> </tr> <tr> <td>D<1</td> <td>0.1D</td> </tr> <tr> <td>1≤D<3</td> <td>0.3D</td> </tr> <tr> <td>3≤D</td> <td>0.5D</td> </tr> </table>		Dia	aa	D<1	0.1D	1≤D<3	0.3D	3≤D	0.5D						
	Dia	aa																
D<1	0.1D																	
1≤D<3	0.3D																	
3≤D	0.5D																	
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min										
0.1	25,000	2.4	25,000	2.0	25,000	1.8	25,000	0.9										
0.2	25,000	3.3	25,000	2.7	25,000	2.2	25,000	1.1										
0.3	25,000	4.1	25,000	3.4	25,000	2.5	25,000	1.7										
0.4	25,000	4.5	25,000	3.7	25,000	2.7	25,000	2.1										
0.5	25,000	4.9	25,000	3.8	25,000	3.5	25,000	2.7										
0.6	25,000	5.5	25,000	4.4	24,500	4.3	21,000	3.0										
0.7	25,000	6.1	25,000	4.9	21,500	4.3	18,500	3.0										
0.8	25,000	7.1	25,000	5.5	19,500	4.3	17,000	3.1										
0.9	25,000	7.9	23,500	5.9	17,000	4.3	15,000	3.1										
1.0	25,000	8.5	22,000	5.9	15,500	4.3	13,500	3.1										
1.1	25,000	8.3	20,000	5.9	14,000	4.3	12,500	3.1										
1.2	25,000	8.3	18,500	5.9	13,500	4.3	11,500	3.1										
1.3	25,000	8.6	17,500	5.9	12,500	4.3	11,000	3.1										
1.4	25,000	9.2	16,000	5.9	11,500	4.3	10,000	3.1										
1.5	25,000	9.8	15,500	5.9	11,000	4.3	9,900	3.1										
1.6	25,000	10.1	15,000	5.9	10,500	4.3	9,400	3.1										
1.7	25,000	10.8	14,000	5.9	9,900	4.3	8,800	3.1										
1.8	25,000	11.4	13,500	6.3	9,400	4.3	8,500	3.1										
1.9	25,000	12.1	12,500	6.3	8,800	4.3	7,900	3.3										
2.0	25,000	12.5	12,000	6.3	8,700	4.3	7,900	3.5										
2.1	25,000	13.9	11,500	6.7	8,300	4.3	7,400	3.5										
2.2	25,000	14.4	11,000	6.7	8,200	4.3	7,200	3.5										
2.3	25,000	14.7	11,000	7.1	8,000	4.3	7,000	3.5										
2.4	25,000	16.3	10,500	7.1	7,900	4.3	6,900	3.5										
2.5	24,500	16.9	10,500	7.9	7,600	4.3	6,600	3.5										
2.6	23,500	18.5	9,800	7.9	7,400	4.9	6,300	3.5										
2.7	23,000	18.5	9,500	7.9	7,100	4.9	6,100	3.5										
2.8	22,000	18.5	9,100	8.3	6,900	4.9	5,800	3.7										
2.9	21,500	18.5	8,800	8.3	6,700	4.9	5,700	3.7										
3.0	21,000	21.3	8,900	9.1	6,800	5.1	5,700	3.9										
3.1	20,000	21.7	8,700	9.4	6,700	5.1	5,600	3.9										
3.2	19,500	22.0	8,400	9.4	6,500	5.7	5,400	4.1										
3.3	19,000	22.0	8,100	9.8	6,300	5.7	5,200	4.1										
3.4	18,000	22.0	7,900	9.8	6,100	5.7	5,100	4.1										
3.5	18,000	22.0	7,800	9.8	6,000	6.1	5,000	4.1										
3.6	17,500	22.8	7,600	10.6	5,900	6.1	4,900	4.3										
3.7	16,500	22.8	7,400	10.6	5,700	6.1	4,700	4.3										
3.8	16,000	23.2	7,300	11.0	5,700	6.1	4,600	4.3										
3.9	15,500	23.2	7,100	11.0	5,500	6.3	4,500	4.3										
4.0	15,500	23.6	7,000	11.0	5,500	6.3	4,500	4.5										
4.1	15,500	25.2	6,900	11.4	5,400	6.3	4,400	4.5										
4.2	15,000	25.2	6,800	11.4	5,300	6.3	4,400	4.5										
4.3	14,000	25.2	6,700	12.2	5,200	6.3	4,300	4.5										
4.4	14,000	26.4	6,600	12.6	5,100	6.7	4,200	4.9										
4.5	14,000	26.4	6,600	12.6	5,100	6.7	4,200	4.9										
4.6	13,500	27.6	6,500	13.0	4,900	6.7	4,100	4.9										
4.7	13,500	27.6	6,500	13.8	4,900	6.7	4,100	4.9										
4.8	13,500	28.0	6,400	13.8	4,800	6.7	4,100	4.9										
4.9	13,500	28.0	6,300	14.2	4,700	6.7	4,000	4.9										
5.0	12,500	28.3	6,200	14.6	4,600	6.7	3,900	5.1										
5.1	12,500	28.3	6,100	14.6	4,500	6.7	3,900	5.1										
5.2	12,000	28.3	6,000	14.6	4,400	6.7	3,800	5.1										
5.3	12,000	28.3	5,900	14.6	4,400	6.7	3,800	5.1										
5.4	11,500	28.3	5,800	14.6	4,300	6.7	3,600	5.1										
5.5	11,500	28.3	5,700	14.6	4,200	6.7	3,500	5.1										
5.6	11,500	28.3	5,600	14.6	4,100	6.7	3,500	5.1										

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.
 *Maximum speed will vary by diameter.

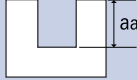
CONTINUED ➔





List 3720 - EXOCARB® WXL®: 2 Flute, Stub Length (Continued)

Slotting

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Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min										
5.7	11,000	28.3	5,500	14.6	4,000	6.7	3,400	5.1										
5.8	11,000	28.0	5,400	14.6	3,900	6.7	3,300	5.1										
5.9	10,500	28.0	5,300	14.6	3,800	6.7	3,300	5.1										
6.0	10,000	28.0	5,200	14.6	3,800	6.7	3,200	5.1										

1. Use a rigid and precise machine and holder.
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