



## List 3721 - EXOCARB® WXL®: 2 Flute, Stub Length

### Slotting

Hardness	-		<32 HRC		33-41 HRC		42-50 HRC											
Work Material	Copper Copper Alloy		Mild Steels Carbon Steels		Hardened Steels, Pre-hardened Steels Stainless Steels													
Depth of Cut			<table border="1"> <tr> <th>Dia</th> <th>aa</th> </tr> <tr> <td>D&lt;1</td> <td>0.1D</td> </tr> <tr> <td>1≤D&lt;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	2.0	25,000	2.2	25,000	1.8	25,000	0.9										
0.2	25,000	2.8	25,000	2.8	25,000	2.3	25,000	1.1										
0.3	25,000	3.3	25,000	3.4	25,000	2.5	25,000	1.7										
0.4	25,000	3.7	25,000	3.7	25,000	2.8	25,000	2.1										
0.5	25,000	3.9	25,000	3.8	25,000	3.5	22,000	2.4										
0.6	25,000	4.5	25,000	4.4	19,500	3.5	17,000	2.4										
0.7	25,000	4.9	24,000	4.7	17,000	3.5	15,000	2.4										
0.8	25,000	5.7	21,500	4.7	15,500	3.5	13,500	2.6										
0.9	25,000	6.4	19,000	4.7	13,500	3.5	12,000	2.6										
1.0	25,000	7.3	17,500	4.7	12,500	3.5	11,000	2.6										
1.1	25,000	7.8	16,000	4.7	11,500	3.5	9,900	2.6										
1.2	25,000	8.3	15,000	4.7	10,500	3.5	9,300	2.6										
1.3	25,000	8.5	14,000	4.7	9,900	3.5	8,700	2.6										
1.4	25,000	9.3	13,000	4.7	9,200	3.5	8,100	2.6										
1.5	25,000	9.8	12,500	4.7	8,900	3.5	7,900	2.6										
1.6	25,000	10.2	12,000	4.7	8,500	3.5	7,500	2.6										
1.7	25,000	10.9	11,000	4.7	7,900	3.5	7,000	2.6										
1.8	25,000	11.2	10,500	5.1	7,500	3.5	6,800	2.7										
1.9	25,000	12.1	10,000	5.1	7,100	3.5	6,300	2.7										
2.0	24,000	12.2	9,700	5.1	7,000	3.5	6,300	2.8										
2.1	23,000	13.0	9,300	5.5	6,600	3.5	5,900	2.8										
2.2	22,500	13.0	9,000	5.5	6,500	3.5	5,700	2.8										
2.3	22,000	13.0	8,800	5.9	6,400	3.5	5,600	2.8										
2.4	20,500	13.8	8,600	5.9	6,300	3.5	5,500	2.8										
2.5	20,000	13.8	8,200	6.3	6,100	3.5	5,300	2.8										
2.6	19,000	15.0	7,900	6.3	5,900	3.9	5,000	2.8										
2.7	18,000	15.0	7,600	6.3	5,700	3.9	4,900	2.8										
2.8	17,500	15.0	7,300	6.7	5,500	3.9	4,700	3.0										
2.9	17,000	15.0	7,100	6.7	5,300	3.9	4,500	3.0										
3.0	16,000	15.7	6,900	6.7	5,300	3.9	4,400	3.0										
3.1	15,500	16.1	6,700	7.1	5,100	3.9	4,300	3.0										
3.2	15,000	16.5	6,500	7.1	5,000	4.3	4,200	3.1										
3.3	14,500	16.5	6,300	7.5	4,800	4.3	4,000	3.1										
3.4	14,000	16.5	6,100	7.5	4,600	4.3	3,900	3.1										
3.5	14,000	16.5	6,000	7.5	4,600	4.7	3,800	3.1										
3.6	13,500	16.9	5,900	7.9	4,500	4.7	3,700	3.3										
3.7	12,500	16.9	5,700	7.9	4,400	4.7	3,600	3.3										
3.8	12,500	17.3	5,600	8.3	4,400	4.7	3,600	3.3										
3.9	12,000	17.3	5,500	8.3	4,200	4.9	3,500	3.3										
4.0	12,000	17.7	5,400	8.3	4,200	4.9	3,500	3.5										
4.1	11,500	18.9	5,300	8.7	4,100	4.9	3,400	3.5										
4.2	11,500	18.9	5,300	8.7	4,100	4.9	3,300	3.5										
4.3	11,000	18.9	5,200	9.1	4,000	4.9	3,300	3.5										
4.4	11,000	19.7	5,100	9.4	3,900	5.1	3,200	3.7										
4.5	10,500	19.7	5,100	9.4	3,900	5.1	3,200	3.7										
4.6	10,500	20.5	5,000	9.8	3,800	5.1	3,200	3.7										
4.7	10,500	20.5	5,000	10.2	3,800	5.1	3,100	3.7										
4.8	10,500	20.9	4,900	10.2	3,700	5.1	3,100	3.7										
4.9	10,000	20.9	4,900	10.6	3,600	5.1	3,100	3.7										
5.0	9,500	21.3	4,800	10.6	3,500	5.1	3,000	3.9										
5.1	9,500	21.3	4,700	10.6	3,500	5.1	3,000	3.9										
5.2	9,300	21.3	4,600	10.6	3,400	5.1	2,900	3.9										
5.3	9,200	21.3	4,600	10.6	3,400	5.1	2,900	3.9										
5.4	9,000	21.3	4,500	10.6	3,300	5.1	2,800	3.9										
5.5	8,800	21.3	4,400	10.6	3,200	5.1	2,700	3.9										
5.6	8,700	21.3	4,300	10.6	3,100	5.1	2,600	3.9										
5.7	8,500	21.3	4,200	10.6	3,100	5.1	2,600	3.9										
5.8	8,400	20.9	4,200	10.6	3,000	5.1	2,600	3.9										
5.9	8,200	20.9	4,100	10.6	2,900	5.1	2,500	3.9										

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

DRILLING

THREADING

MILLING

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INDEX





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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										
6.0	7,900	20.9	4,000	10.6	2,900	5.1	2,500	3.9										
6.5	7,500	20.9	3,700	10.6	2,700	5.1	2,300	3.9										
7.0	6,900	20.9	3,400	10.6	2,500	5.1	2,100	3.9										
7.5	6,400	20.9	3,200	10.6	2,300	5.1	2,000	3.9										
8.0	5,900	20.5	3,000	10.2	2,200	4.9	1,900	3.9										
8.5	5,600	20.5	2,800	10.2	2,000	4.9	1,700	3.9										
9.0	5,300	20.1	2,600	10.2	1,900	4.9	1,500	3.9										
9.5	5,100	20.1	2,500	10.2	1,800	4.9	1,400	3.7										
10.0	4,700	19.7	2,400	9.8	1,700	4.9	1,500	3.7										
11.0	4,400	19.7	2,200	9.8	1,600	4.9	1,100	3.7										
12.0	4,000	20.1	2,000	9.8	1,400	4.9	1,200	3.7										
16.0	3,000	15.7	1,500	7.9	1,100	4.5	800	3.1										
18.0	2,700	14.2	1,300	7.1	900	3.9	700	2.8										
20.0	2,400	11.8	1,200	5.9	800	3.5	600	2.4										

1. Use a rigid and precise machine and holder.
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