



## List 3722: 2 Flute, Regular 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													
Cutting Speed	52-522 SFM		33-251 SFM		33-186 SFM		33-159 SFM											
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										
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1. Use a rigid and precise machine and holder.
2. Use a suitable cutting fluid with high smoke retardant.
3. When the length of tool extension from the machine is long, reduce the speed and feed.





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5.9	8,200	20.9	4,100	10.6	2,900	5.1	2,500	3.9										
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										

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