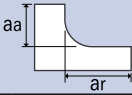




List 4770 & 4670: Multi-Flute, Stub Length, Corner Radius

Hardness		-	-	-	-	-	-	-	-	45 HRC	65 HRC	70 HRC							
Work Material		Stainless Steel	Colbalt-Chromium Alloys (Stellite)	Titanium Alloy	Ni-Based Alloy (Inconel 718)	Hardened Steel													
Cutting Speed		195-260 SFM	165-230 SFM	135-190 SFM	70-130 SFM	165-230 SFM	135-190 SFM	70-130 SFM											
Depth of Cut		 <table border="1" data-bbox="906 415 1159 478"> <tr> <th>Dia</th> <th>aa</th> <th>ar</th> </tr> <tr> <td>R≤6</td> <td>Max: 0.2 x CR</td> <td rowspan="2">0.5D</td> </tr> <tr> <td>R>6</td> <td>Max: 0.5 x D</td> </tr> </table>										Dia	aa	ar	R≤6	Max: 0.2 x CR	0.5D	R>6	Max: 0.5 x D
Dia	aa	ar																	
R≤6	Max: 0.2 x CR	0.5D																	
R>6	Max: 0.5 x D																		
Diameter	Radius	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min				
-	6	1	4240	60.2	3700	52.4	3200	45.3	1910	27.2	3700	52.4	3200	45.3	1910	27.2			
-	-	1.5	3700	44.1	3200	37.8	2700	31.5	1600	18.9	3200	37.8	2700	31.5	1600	18.9			
-	-	1/32	3972	56.4	3514	49.8	3025	42.8	1820	25.9	3514	49.8	3025	42.8	1820	25.9			
1/4	-	1/16	3514	41.9	3025	35.7	2536	29.6	1497	17.7	3025	35.7	2536	29.6	1466	17.3			
-	-	3/64	3178	56.3	2811	49.7	2420	42.9	1442	25.4	2811	49.7	2420	42.9	1442	25.4			
5/16	-	3/32	2811	33.2	2420	28.5	2029	23.9	1197	14.2	2420	28.5	2029	23.9	1173	13.9			
-	-	1	3180	56.3	2780	49.2	2400	42.5	1430	25.2	2780	49.2	2400	42.5	1430	25.2			
-	-	2	2800	33.1	2400	28.3	2000	23.6	1200	14.2	2400	28.3	2000	23.6	1200	14.2			
3/8	-	3/64	2648	67.6	2358	60.2	2030	51.8	1201	30.7	2342	59.8	2016	51.5	1201	30.7			
-	-	3/32	2342	40.3	2030	34.8	1690	28.4	998	16.9	2016	34.6	1690	28.4	977	16.6			
-	-	1	2540	72.0	2220	63	1900	53.9	1150	32.7	2220	63	1900	53.9	1150	32.7			
-	-	2	2200	42.1	1900	36.2	1600	29.9	960	18.1	1900	36.2	1600	29.9	960	18.1			
-	-	1	2120	100.0	1850	87.4	1600	75.6	960	45.3	1850	87.4	1600	75.6	960	45.3			
-	-	2	1900	58.7	1600	50	1300	41.7	800	25.2	1600	50	1300	41.7	800	25.2			
1/2	-	1/16	1986	93.7	1757	83.0	1512	71.4	901	42.5	1757	83.0	1521	71.9	901	42.5			
-	-	1/8	1757	54.3	1512	47.3	1268	40.7	748	23.6	1521	47.5	1268	40.7	733	23.1			
-	-	1	1590	110.2	1380	95.7	1200	83.1	720	50	1380	95.7	1200	83.1	720	50			
-	-	3	1400	65.7	1200	56.3	1000	46.9	600	28.3	1200	56.3	1000	46.9	600	28.3			
-	-	1	1270	111.8	1110	98	1000	88.2	570	50.4	1110	98	1000	88.2	570	50.4			
-	-	3	1100	70.1	1000	60.2	800	50	480	29.9	1000	60.2	800	50	480	29.9			

1. This tool is recommended for the roughing of additive manufacturing and mold overlay surfaces.
2. Please use machines and holders that are rigid and highly accurate.
3. The values listed above are for reference. Please set the cutting condition in accordance with the actual machining environment.
4. Please reduce the feed rate when the depth of cut is greater than specified.
5. Please adjust the speed, feed and depth of cut accordingly when the overhang length is longer than specified.
6. Please use a suitable fluid with high smoke retardant properties.
7. During dry (no fluid) milling, please use air blow to remove disposable chips from the milling area and to eliminate chip packing.
8. Please use water-soluble coolant when machining stainless steel, cobalt-chromium based alloy, titanium alloy, and Ni-based alloy.
9. Tool runout should be kept to a minimum for maximum accuracy.
10. When the cutting load fluctuates in areas such as the corners, please reduce the rotational speed.

ABOUT OSG

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