



- List 78005 - PHOENIX[®] PRC: SA**
- List 78003 - PHOENIX[®] PRC: SS**
- List 78004 - PHOENIX[®] PRC: Bore**
- List 78002 - PHOENIX[®] PRC: Bore**
- List 52602 - PHOENIX[®] PRC: ASF**
- List 78017 - PHOENIX[®] PRC: SF**

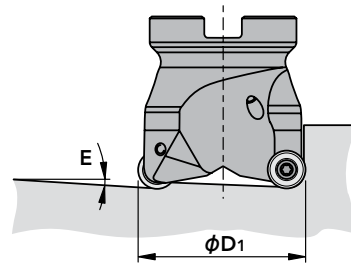
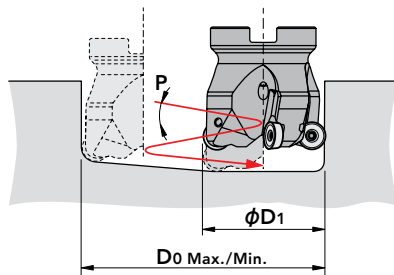
Work Material	Tensile Strength - Hardness	Milling Speed Vc (SFM)	Insert Size					
			RPH_10...		RPH_12...		RPH_16...	
			Face Milling		Face Milling		Face Milling	
			Feed Per Tooth fz (in/t)	Depth of Cut Aa (in)	Feed Per Tooth fz (in/t)	Depth of Cut Aa (in)	Feed Per Tooth fz (in/t)	Depth of Cut Aa (in)
P Mild Steels, Carbon Steels (1010, 1018) Carbon Steels, Alloy Steels (1050, 4140) Die Steels (H13, D2)	~180HB	655 (330-985)	0.010 (0.004 - 0.014)	0.078	0.012 (0.004 - 0.016)	0.093	0.014 (0.004 - 0.020)	0.125
	~280HB	590 (330-820)	0.008 (0.004 - 0.012)	0.078	0.010 (0.004 - 0.014)	0.093	0.012 (0.004 - 0.018)	0.125
	~280HB	495 (260-655)	0.008 (0.004 - 0.012)	0.078	0.010 (0.004 - 0.014)	0.093	0.012 (0.004 - 0.018)	0.125
M Stainless Steels (Dry) (304SS, 420SS) Stainless Steels (Wet) (304SS, 420SS)	~250HB	525 (265 - 655)	0.010 (0.004 - 0.014)	0.078	0.012 (0.004 - 0.016)	0.093	0.014 (0.004 - 0.020)	0.125
	~250HB	395 (200 - 590))	0.010 (0.004 - 0.014)	0.078	0.012 (0.004 - 0.016)	0.093	0.014 (0.004 - 0.020)	0.125
K Cast Iron (FC250) Ductile Cast Iron (60-40-18)	~350N/mm ²	720 (330-1150)	0.010 (0.002 - 0.016)	0.078	0.012 (0.004 - 0.020)	0.093	0.014 (0.004 - 0.023)	0.125
	~800N/mm ²	495 (330-720)	0.008 (0.004 - 0.012)	0.078	0.010 (0.004 - 0.014)	0.093	0.012 (0.004 - 0.018)	0.125
N Aluminum Alloys (6061, 7075)	~13%Si	1970 (985-4920)	0.016 (0.008 - 0.031)	0.078	0.023 (0.008 - 0.039)	0.093	0.031 (0.012 - 0.059)	0.125
S Heat Resistant Alloys (Inconel 718) Titanium Alloy (Ti-6Al-4V)	-	130 (85-195)	0.006 (0.002 - 0.010)	0.078	0.010 (0.002 - 0.012)	0.093	0.010 (0.002 - 0.016)	0.125
	-	260 (165-395)	0.008 (0.004 - 0.012)	0.078	0.010 (0.004 - 0.014)	0.093	0.012 (0.004 - 0.018)	0.125
H Pre-hardened Steel (P20, Stavax) Die Cast Steels (A2, S7) Hardened Steels (D2)	40-43 HRC	395 (130-495)	0.006 (0.002 - 0.010)	0.059	0.010 (0.002 - 0.012)	0.059	0.010 (0.002 - 0.016)	0.059
	43-48HRC	260 (130-395)	0.006 (0.002 - 0.010)	0.039	0.010 (0.002 - 0.012)	0.039	0.010 (0.002 - 0.016)	0.039
	50-55HRC	195 (100-295)	0.006 (0.002 - 0.010)	0.020	0.010 (0.002 - 0.012)	0.020	0.010 (0.002 - 0.016)	0.020





Maximum Ramping Angle (E) & Helical Angle (P)

Insert Size	RPH_10...				RPH_12...				RPH_16...			
Diameter (inch)	Ramping Angle	Helical Milling (inch)		Helical Angle	Ramping Angle	Helical Milling (inch)		Helical Angle	Ramping Angle	Helical Milling (inch)		Helical Angle
D1	E	D0 Min	D0 Max	P	E	D0 Min	D0 Max	P	E	D0 Min	D0 Max	P
1.000	2.0°	1.488	1.606	1.8°	-	-	-	-	-	-	-	-
1.250	3.0°	1.988	2.106	1.5°	4.0°	1.752	2.028	1.7°	-	-	-	-
1.500	3.3°	2.488	2.606	1.1°	2.8°	2.252	2.528	1.4°	3.0°	2.016	2.370	2.0°
2.000	2.3°	3.488	3.606	0.9°	2.5°	3.252	3.528	1.1°	4.0°	3.016	3.370	1.5°
2.500	2.2°	4.488	4.606	0.7°	1.8°	4.252	4.528	0.9°	2.8°	4.016	4.370	1.1°
3.000	-	-	-	-	1.3°	5.252	5.528	0.7°	2.0°	5.016	5.370	0.9°
4.000	-	-	-	-	0.9°	7.252	7.528	0.5°	1.5°	7.016	7.370	0.7°
5.000	-	-	-	-	1.0°	9.252	9.528	0.4°	1.1°	9.016	9.370	0.45°
6.000	-	-	-	-	-	-	-	-	1.0°	11.016	11.370	0.4°



Maximum Depth of Cut (Aa)

Insert Size	Maximum Depth of Cut (Aa)	
	4 Indexes Per Insert	8 Indexes Per Insert
	(in)	(in)
RPH_10...	0.177	0.055
RPH_12...	0.217	0.067
RPH_16...	0.295	0.091

