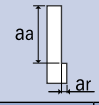




## List 580: Single End, Regular Length, 2 Flute

## List 582: Double End, Regular Length, 2 Flute

### Side Milling

Hardness	<145 Brinell		<20 HRC		20-30 HRC		30-40 HRC		40-50 HRC		-	
Work Material	Mild Steels Hard Brass Bronze Cast Iron		Med. Carbon Steels Med. Strength Titanium Alloys Med. Strength Stainless Steels		High Carbon Steel Titanium Alloys High Strength Stainless Steels		Heat Resistant High Alloys Austenitic Alloys Nickel Base Alloys		Heat Resistant High Alloys High Strength Stainless Steels Titanium Alloys		Aluminum Aluminum Alloys	
Cutting Speed	125-145 SFM		95-110 SFM		50-65 SFM		30-50 SFM		16-32 SFM		160-390 SFM	
Depth of Cut	$a_a = 1.5D$ $a_r = 0.1D$ 											
Mill Dia.	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
3	4,365	4.1	3,315	3.0	1,860	1.3	1,400	0.8	800	0.4	8,895	7.8
4	3,275	5.1	2,485	3.5	1,395	1.6	1,000	1.0	630	0.4	6,670	9.5
5	2,620	5.8	1,990	3.9	1,115	1.8	800	1.0	500	0.5	5,335	10.5
6	2,185	5.8	1,660	3.8	930	1.8	710	1.1	400	0.6	4,450	9.8
8	1,640	7.3	1,245	4.8	700	2.2	500	1.1	315	0.6	3,335	12.7
10	1,310	8.3	995	5.4	560	2.5	400	1.3	280	0.6	2,670	13.3
12	1,090	8.2	830	5.1	465	2.5	315	1.5	200	0.8	2,220	13.2
14	935	7.4	710	4.9	400	2.4	280	1.6	180	0.8	1,900	11.8
16	820	6.9	620	4.6	350	2.4	250	1.6	160	0.8	1,670	11.3
18	730	6.7	550	4.4	310	2.2	225	1.6	140	0.8	1,480	11.2
20	655	6.5	500	3.9	280	2.2	200	1.6	140	0.8	1,335	10.3
22	595	6.3	450	3.5	255	2.0	180	1.4	112	0.8	1,210	10.2
24	545	6.0	415	3.3	235	1.9	160	1.3	100	0.8	1,110	9.8
25	525	5.8	400	3.2	225	1.8	160	1.3	100	0.6	1,070	9.4
26	500	5.5	385	3.1	215	1.7	160	1.3	90	0.6	1,025	9.0
28	465	5.1	355	2.8	200	1.6	140	1.1	80	0.6	950	8.8
30	435	4.8	330	2.6	185	1.5	140	1.1	70	0.6	890	8.3
32	410	4.8	310	2.5	175	1.4	125	1.0	63	0.5	835	7.8
35	375	4.3	285	2.3	160	1.3	110	0.9	63	0.5	760	7.5
36	365	4.2	275	2.2	155	1.3	110	0.8	63	0.5	740	7.2
40	330	4.1	250	2.0	140	1.1	100	0.8	56	0.4	670	6.6
45	290	3.6	220	1.8	125	1.0	90	0.7	50	0.4	595	5.9
50	260	3.2	200	1.6	110	0.9	80	0.7	50	0.4	535	5.3

In case of deeper operation, slow down feed by 20-50%