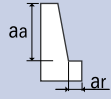


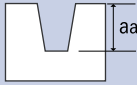


List 597: 10° Taper on Side - 3 Flute

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 Austenitic Alloys Nickel Base Alloys	Aluminum Aluminum Alloys						
Cutting Speed	80-120 SFM	60-80 SFM	45-60 SFM	25-45 SFM	15-20 SFM	150-350 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
3/32	4,075	5.7	2,850	4.0	2,140	3.1	1,425	2.1	715	0.9	10,185	14.4
1/8	3,055	7.2	2,140	5.0	1,600	3.7	1,070	2.5	535	1.1	7,640	18.1
1/4	1,530	5.8	1,070	3.6	800	2.8	535	2.0	270	0.9	3,820	13.5

Slotting

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 Austenitic Alloys Nickel Base Alloys	Aluminum Aluminum Alloys						
Cutting Speed	80-120 SFM	60-80 SFM	45-60 SFM	25-45 SFM	5 - 12 SFM	150-350 SFM						
Depth of Cut	$a_a = 1/3D$ 											
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
3/32	4,075	2.5	2,850	2.0	2,140	1.5	1,425	1.0	345	0.2	10,185	7.2
1/8	3,055	3.2	2,140	2.5	1,600	1.8	1,070	1.3	260	0.2	7,640	8.0
1/4	1,530	4.7	1,070	4.1	800	3.0	535	1.0	130	0.2	3,820	10.0

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