



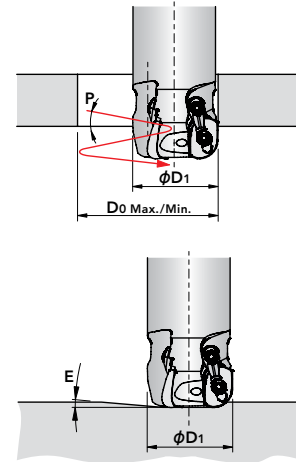
## List 6420 - PHOENIX<sup>®</sup> PDR: ss

## List 6450 - PHOENIX<sup>®</sup> PDR: Bore

Work Material		Tensile Strength - Hardness	Milling Speed Vc (SFM)	Insert Size							
				ADMT20...							
				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)			
OAL=120	OAL=170	OAL=100	OAL=200		OAL=300	OAL=400					
P	Mild Steels, Carbon Steels (1010, 1018)	~180 HB	590 (295 - 720)	0.027 (0.012 - 0.040)	0.118	0.079	0.024 (0.012 - 0.040)	0.118	0.118	0.079	0.079
	Carbon Steels, Alloy Steels (1050, 4140)	~280 HB	590 (295 - 720)	0.027 (0.012 - 0.040)	0.118	0.079	0.024 (0.012 - 0.040)	0.118	0.118	0.079	0.079
	Die Steels (H13, D2)	~280 HB	495 (295 - 590)	0.024 (0.012 - 0.040)	0.118	0.079	0.020 (0.012 - 0.040)	0.118	0.079	0.079	0.079
K	Cast Iron (FC250)	~350 N/mm <sup>2</sup>	590 (330 - 820)	0.031 (0.012 - 0.059)	0.118	0.118	0.027 (0.012 - 0.059)	0.118	0.118	0.079	0.079
	Ductile Cast Iron (60-40-18)	~800 N/mm <sup>2</sup>	495 (330 - 820)	0.027 (0.012 - 0.047)	0.118	0.118	0.024 (0.012 - 0.047)	0.118	0.118	0.079	0.079

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

Insert Size	ADMT20...				
Diameter (mm)	Ramping Angle	Helical Milling (mm)		Helical Angle	Plunging (mm)
D1	E	D0 Min	D0 Max	P	Z
40	5°	50	78	1.4°	3
50	3°	70	98	1.1°	3
63	2°	96	124	0.9°	3
80	1°	130	158	0.7°	3
100	0.5°	170	198	0.5°	3
125	0.5°	220	248	0.4°	3



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