



List 9182: 2 Flute, Corner Radius, Long Neck, CBN, Stub Length

Standard Milling

Hardness			<50 HRC		50-60 HRC		60-68 HRC	
Work Material	Standard Depth of Cut		Hardened Steels					
Cutting Speed			155-361 SFM		155-309 SFM		119-240 SFM	
Depth of Cut (mm)			aa=1D	ar=1D	aa=0.5D	ar=0.5D	aa=0.4D	ar=0.4D
Mill Dia.	aa	ar	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min
0.5	0.02	0.1	25,000	19.5	25,000	19.7	25,000	20.1
1.0	0.02	0.1	25,000	29.5	22,310	25.5	17,460	20.7
1.5	0.03	0.2	16,830	26.8	14,890	24.1	11,650	17.7
2.0	0.03	0.2	12,760	20.6	11,290	18.4	8,840	12.7
3.0	0.05	0.3	8,400	13.2	7,430	11.6	5,820	9.0

1. Use a rigid and precise machine and holder.
2. We suggest using air blow or MQL (mist).
3. When using low speed machines, use the maximum speed and adjust feed rate.
4. During heavy load operations such as corner processing, reduce the speed and feed.
5. The run out of the end mill should be within 10 microns (.0004") after chucking.

