



List HP460

Side Milling

Hardness	-		UP TO 30 HRC		-		-		35-45 HRC		45-55 HRC					
Work Material	Medium Carbon Steels Mild Steels		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Cast Iron		Titanium		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Hardened Steels					
Cutting Speed (SFM)	180		120		180		80		78		60					
Depth of Cut	<table border="1"> <tr> <td>aa</td> <td>ar</td> </tr> <tr> <td>1.5D</td> <td>0.1D</td> </tr> </table>												aa	ar	1.5D	0.1D
aa	ar															
1.5D	0.1D															
Mill Dia. (Inch)	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)				
1/4	2,880	12.7	1,920	8.0	2,880	12.7	1,222	3.8	1,191	3.4	960	1.4				
5/16	2,160	12.7	1,440	8.0	2,160	12.7	978	3.8	960	3.6	720	1.4				
3/8	1,832	17.6	1,221	8.6	1,832	17.6	815	5.3	768	3.6	611	1.5				
1/2	1,440	17.0	960	8.5	1,440	17.0	611	5.1	595	3.4	480	1.4				
5/8	1,080	18.8	720	8.5	1,080	18.8	489	5.6	480	3.6	360	1.4				
3/4	916	20.5	611	10.1	916	20.5	407	6.2	384	3.6	305	1.5				
1	696	16.6	456	8.5	696	16.6	306	5.0	300	3.6	228	1.4				

Side Milling

Hardness	-		UP TO 30 HRC		-		-		35-45 HRC		45-55 HRC					
Work Material	Medium Carbon Steels Mild Steels		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Cast Iron		Titanium		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Hardened Steels					
Cutting Speed (SFM)	180		120		180		80		78		60					
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Mill Dia. (mm)	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	5,760	6.1	3,840	4.0	5,760	6.1	2,587.4	1.8	2,640	1.8	1,920	0.7				
4	4,320	8.5	2,880	5.7	4,320	8.5	1,940.6	2.6	1,920	2.4	1,440	0.9				
5	3,480	10.4	2,400	7.3	3,480	10.4	1,552.4	3.1	1,560	3.9	1,200	1.2				
6	2,880	12.8	1,920	8.0	2,880	12.8	1,293.7	3.8	1,272	3.5	960	1.4				
8	2,160	12.8	1,440	8.0	2,160	12.8	970.3	3.8	960	3.5	720	1.4				
10	1,680	16.1	1,140	8.0	1,680	16.1	776.2	4.8	768	3.5	576	1.4				
12	1,440	17.0	960	8.5	1,440	17.0	646.9	5.1	636	3.5	480	1.4				
16	1,080	18.9	720	8.5	1,080	18.9	485.1	5.7	480	3.5	360	1.4				
20	864	19.4	576	9.4	864	19.4	388.1	5.8	384	3.5	288	1.4				
25	696	16.5	456	8.5	696	16.5	310.5	5.0	300	3.5	228	1.4				

ABOUT OSG

DRILLING

THREADING


MILLING

HOLDERS


INDEX



Slotting

Hardness	Up to 20 HRC		20-35 HRC		-		-		35-45 HRC		45-55 HRC									
Work Material	Medium Carbon Steels Mild Steels		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Cast Iron		Titanium		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Hardened Steels									
Cutting Speed (SFM)	150		102		150		70		66		52									
Depth of Cut 	<table border="1" style="display: inline-table;"> <tr><th>Dia</th><th>aa</th></tr> <tr><td>D < 1/2</td><td>1.0D</td></tr> <tr><td>D ≥ 1/2</td><td>0.5D</td></tr> </table>				Dia	aa	D < 1/2	1.0D	D ≥ 1/2	0.5D	<table border="1" style="display: inline-table;"> <tr><th>aa</th></tr> <tr><td>0.5D</td></tr> </table>								aa	0.5D
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D < 1/2	1.0D																			
D ≥ 1/2	0.5D																			
aa																				
0.5D																				
Mill Dia. (Inch)	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)								
1/4	2,290	8.9	1,632	5.6	2,290	8.9	1070	2.7	1,008	2.2	816	1.0								
5/16	1,836	9.5	1,224	5.6	1,836	9.5	856	2.9	816	2.4	612	1.0								
3/8	1,527	11.7	1,038	6.0	1,527	11.7	713	3.5	648	2.4	529	1.1								
1/2	1,145	11.0	816	6.1	1,145	11.0	535	3.3	504	2.2	408	1.0								
5/8	912	12.7	612	6.1	912	12.7	428	3.8	408	2.4	312	1.0								
3/4	744	13.2	492	6.6	744	13.2	357	4.0	324	2.4	265	1.1								
1	600	11.3	384	6.1	600	11.3	267	3.4	252	2.4	192	1.0								

Slotting

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Work Material	Medium Carbon Steels Mild Steels		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Cast Iron		Titanium		Pre-hardened Steels Stainless Steels Die & Alloy Steels		Hardened Steels									
Cutting Speed (SFM)	150		102		150		70		66		52									
Depth of Cut 	<table border="1" style="display: inline-table;"> <tr><th>Dia</th><th>aa</th></tr> <tr><td>D < 12</td><td>1.0D</td></tr> <tr><td>D ≥ 12</td><td>0.5D</td></tr> </table>				Dia	aa	D < 12	1.0D	D ≥ 12	0.5D	<table border="1" style="display: inline-table;"> <tr><th>aa</th></tr> <tr><td>0.5D</td></tr> </table>								aa	0.5D
	Dia	aa																		
D < 12	1.0D																			
D ≥ 12	0.5D																			
aa																				
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Mill Dia. (Inch)	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	4,920	4.7	3,296	2.6	4,920	4.7	2,264	1.4	2,133	1.1	1,680	0.5								
4	3,720	6.1	2,472	3.4	3,720	6.1	1,698	1.8	1,680	1.7	1,320	0.6								
5	3,000	8.0	1,978	4.3	3,000	8.0	1,358	2.4	1,320	2.0	1,008	0.7								
6	2,448	9.4	1,632	5.7	2,448	9.4	1,132	2.8	1,080	2.4	816	0.9								
8	1,836	9.4	1,224	5.7	1,836	9.4	849	2.8	816	2.4	612	0.9								
10	1,428	10.9	972	5.7	1,428	10.9	679	3.3	648	2.4	492	0.9								
12	1,224	11.8	816	6.1	1,224	11.8	566	3.5	540	2.4	408	0.9								
16	912	12.8	612	6.1	912	12.8	424	3.8	408	2.4	312	0.9								
20	744	13.2	492	6.6	744	13.2	340	4.0	324	2.4	240	0.9								
25	600	11.3	384	6.1	600	11.3	272	3.4	252	2.4	192	0.9								

