

## 2 FLUTE, SHORT, SLOTTING

100120, 100320



MATERIAL	NON-ALLOYED STEELS ALLOY STEELS CAST IRON		ALLOY STEELS HEAT RESISTANT STEELS		STAINLESS STEELS		HARDENED STEELS		HARDENED STEELS	
HARDNESS	~HRc30		HRc30 ~ HRc45		HRc30 ~ HRc45		HRc45 ~ HRc55		HRc55 ~ HRc65	
STRENGTH	~1000N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1000 ~ 1500N/mm <sup>2</sup>		1500 ~ 2000N/mm <sup>2</sup>		2000N/mm <sup>2</sup> ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	11560	190	7560	120	6300	90	5040	35		
3	8920	210	5560	140	4620	120	3360	40	1900	40
4	7560	300	4620	180	3880	150	2940	40	1480	40
5	6300	320	3780	190	3160	160	2320	50	1260	40
6	5560	350	3360	220	2840	180	2000	55	1100	40
8	4200	380	2520	200	2100	180	1680	75	840	40
10	3260	330	2000	160	1680	160	1360	60	680	35
12	2740	280	1680	130	1360	130	1160	55	560	35
16	2200	220	1360	110	1060	110	900	40	440	20
20	1680	170	1060	80	840	80	680	30	320	20
25	1360	130	840	70	680	60	540	20	260	15

(UP TO  $\#3:0.2D$ )

R.P.M = rev./min, Feed = mm/min