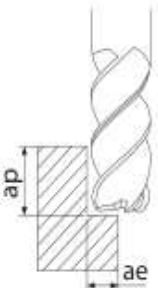


4 Flute end mill

Processing mode	Material	Dia(mm)	φ1	φ2	φ4	φ6	φ8	φ12	φ16
	carbon steel cast iron	Speed(min ⁻¹)	25500	13000	6600	4400	3300	2200	1700
		Feed(mm/min)	335	345	580	620	625	630	600
	alloy steel	Speed(min ⁻¹)	22000	11000	5600	3700	2800	1900	1400
		Feed(mm/min)	290	290	395	455	455	470	460
	Pre hardened steel (30-45 HRC)	Speed(min ⁻¹)	12000	7200	4200	3000	2200	1500	1100
		Feed(mm/min)	105	125	150	160	160	165	140
	stainless steel	Speed(min ⁻¹)	22000	11000	5600	3700	2800	1900	1400
		Feed(mm/min)	130	145	165	165	170	175	155