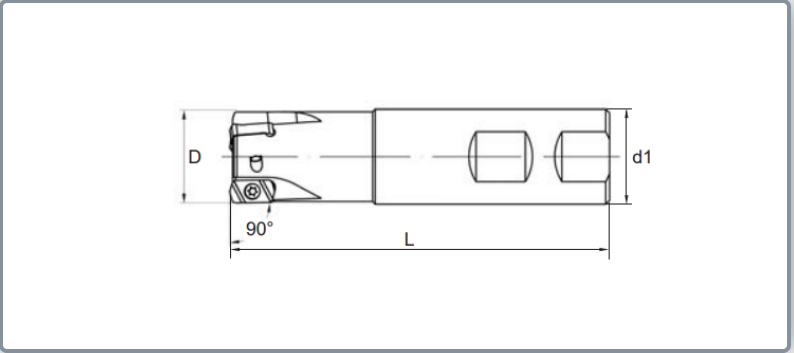


ACCUSIZE HFEM HIGH FEED END MILL

Recommended Cutting Parameters



Low / Medium Carbon Steel (HB ≈ 200)				
Cutter Size	Cutting Speed (m/min ft/min)	Feed per Tooth (mm in)	Max. Depth of Cut (mm in)	Spindle Speed (rpm)
5/8"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2900
3/4"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2500
1"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1900
1-1/4"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1500
1-1/2"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1300
2"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1000
Low Alloy Steel (HB < 200)				
Cutter Size	Cutting Speed (m/min ft/min)	Feed per Tooth (mm in)	Max. Depth of Cut (mm in)	Spindle Speed (rpm)
5/8"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2900
3/4"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2500
1"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1900
1-1/4"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1500
1-1/2"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1300
2"	120 – 140 (395 – 460)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1000
Alloy Steel (HB ≈ 200)				
Cutter Size	Cutting Speed (m/min ft/min)	Feed per Tooth (mm in)	Max. Depth of Cut (mm in)	Spindle Speed (rpm)
5/8"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2600

3/4"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2200
1"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1700
1-1/4"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1300
1-1/2"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1100
2"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	900

Stainless Steel				
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Cutter Size	Cutting Speed (m/min ft/min)	Feed per Tooth (mm in)	Max. Depth of Cut (mm in)	Spindle Speed (rpm)
5/8"	80 – 100 (260 – 330)	0.03 – 0.06 (0.0012 – 0.0024)	0.3 – 0.7 (0.012 – 0.028)	1700
3/4"	80 – 100 (260 – 330)	0.03 – 0.06 (0.0012 – 0.0024)	0.3 – 0.7 (0.012 – 0.028)	1400
1"	80 – 100 (260 – 330)	0.03 – 0.06 (0.0012 – 0.0024)	0.3 – 0.7 (0.012 – 0.028)	1100
1-1/4"	80 – 100 (260 – 330)	0.03 – 0.06 (0.0012 – 0.0024)	0.3 – 0.7 (0.012 – 0.028)	850
1-1/2"	80 – 100 (260 – 330)	0.03 – 0.06 (0.0012 – 0.0024)	0.3 – 0.7 (0.012 – 0.028)	700
2"	80 – 100 (260 – 330)	0.03 – 0.06 (0.0012 – 0.0024)	0.3 – 0.7 (0.012 – 0.028)	500

Grey Cast Iron (HB ≈ 110)				
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Cutter Size	Cutting Speed (m/min ft/min)	Feed per Tooth (mm in)	Max. Depth of Cut (mm in)	Spindle Speed (rpm)
5/8"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2600
3/4"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	2200
1"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1700
1-1/4"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1300
1-1/2"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.0024)	0.5 – 1 (0.02 – 0.04)	1100
2"	100 – 120 (330 – 395)	0.04 – 0.06 (0.0016 – 0.024)	0.5 – 1 (0.02 – 0.04)	900