

Recommendations of using for miniature round corner milling cutters code 8550

Material to machine	R	0,1 to 0,25	0,30 to 0,60	0,60 to 1,0	1,25 to 1,50	1,75 to 2	2,25 to 2,5	3	4	5
STEEL 500 to 700 N/mm <sup>2</sup>	speed m/mn	5	10	15	25	30	30	35	35	35
	RPM	4550	3539	2986	2843	2582	2033	1858	1393	1115
	feed mm/mn	45	55	60	60	60	60	60	60	60
STEEL 800 to 1000 N/mm <sup>2</sup> STAINLESS STEEL	speed m/mn	3	8	13	20	25	25	30	30	30
	RPM	2730	2831	2588	2275	2152	1694	1592	1194	955
	feed mm/mn	35	45	50	50	50	50	50	50	50
HARDENED STEEL	speed m/mn	3	5	10	15	20	20	25	25	25
	RPM	2730	1769	1990	1706	1721	1355	1327	995	796
	feed mm/mn	20	25	35	35	35	35	35	35	35
COPPER - ALUMINIUM	speed m/mn	10	15	25	35	45	50	60	60	60
	RPM	9099	5308	4976	3981	3873	3388	3185	2389	1911
	feed mm/mn	100	100	100	100	100	100	100	100	100

