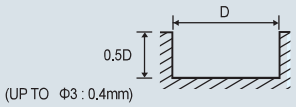
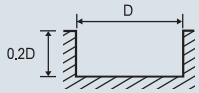
SM503 Series

End Cutting	Slotting															
Work Material	Carbon Steels, Alloy Steels, Tool Steels						Cast Iron		Stainless Steels		Copper Alloys		Titanium Alloys		Inconel	
Hardness	≤ 20 HRc		20~30HRc		30~45HRc		-		-		-		-		-	
Strength	1000N / mm²		800~1000N / mm²		1500~1500N / mm²		-		-		-		-		-	
Cutting Diameter (metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	10,080	950	7,750	740	5,550	395	6,700	520	5,550	320	8,300	360	5,550	395	2,200	100
4	7,550	1,400	5,850	1,100	4,200	595	5,050	550	4,200	320	6,200	400	4,200	595	1,650	105
6	5,050	1,650	3,850	1,250	2,800	700	3,350	660	2,800	370	4,100	440	2,800	700	1,150	130
8	3,750	1,700	2,950	1,330	2,100	710	2,500	665	2,100	375	3,100	500	2,100	710	850	120
10	3,050	1,650	2,300	1,250	1,650	655	2,000	630	1,650	355	2,500	530	1,650	665	650	120
12	2,500	1,500	2,000	1,200	1,350	605	1,650	570	1,350	320	2,000	550	1,350	605	555	110

RPM = rev. / min.
FEED = mm / min.





End Cutting	Side Millin															
Work Material	Carbon Steels, Alloy Steels, Tool Steels						Cast Iron		Stainless Steels		Copper Alloys		Titanium Alloys		Inconel	
Hardness	≤ 20 HRc		20~30HRc		30~45HRc		-		-		-		-		-	
Strength	1000N / mm²		800~1000N / mm²		1500~1500N / mm²		-		-		-		-		-	
Cutting Diameter (metric)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
2	10,080	1,080	7,750	850	5,550	450	6,700	605	5,550	365	8,300	390	5,550	450	2,200	110
4	7,550	1,630	5,850	1,260	4,200	680	5,050	630	4,200	365	6,200	440	4,200	680	1,650	125
6	5,050	1,910	3,850	1,470	2,800	810	3,350	755	2,800	430	4,100	490	2,800	810	1,150	150
8	3,750	1,950	2,950	1,500	2,100	810	2,500	770	2,100	430	3,100	550	2,100	810	850	140
10	3,050	1,890	2,300	1,400	1,650	775	2,000	720	1,650	415	2,500	570	1,650	775	650	140
12	2,500	1,700	2,000	1,340	1,350	700	1,650	665	1,350	365	2,000	620	1,350	700	555	125

RPM = rev. / min.
FEED = mm / min.