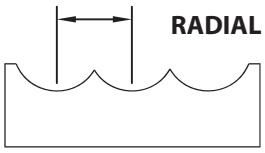
Roughing

(Reference series: 950MX)

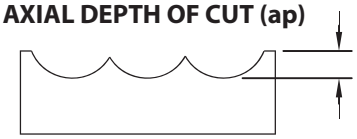
	RPM		CHIPLOAD PER TOOTH (Fz)	
DIAMETER	40 - 50 HRC	50 - 60 HRC	40 - 50 HRC	50 - 60 HRC
1.0mm	20,000 - 40,000	20,000 - 40,000	.013 - .018	.010 - .013
1.5mm	20,000 - 40,000	20,000 - 40,000	.025 - .038	.020 - .025
2.0mm	20,000 - 32,000	20,000 - 30,000	.038 - .050	.025 - .038
3.0mm	18,000 - 24,000	15,000 - 20,000	.050 - .065	.038 - .050
4.0mm	12,000 - 16,000	10,000 - 14,000	.075 - .100	.050 - .075
6.0mm	9,000 - 12,000	7,500 - 10,000	.100 - .125	.065 - .100
8.0mm	7,000 - 10,000	6,000 - 8,500	.125 - .165	.088 - .125
10.0mm	6,000 - 8,000	5,000 - 7,000	.150 - .190	.110 - .150
12.0mm	4,500 - 6,000	4,000 - 5,500	.200 - .250	.140 - .200
16.0mm	3,500 - 5,000	3,000 - 4,500	.225 - .275	.165 - .225
20.0mm	3,000 - 4,000	2,500 - 3,500	.250 - .300	.190 - .250
25.0mm	2,300 - 3,000	2,000 - 2,500	.275 - .325	.215 - .275

Semi-Finishing and Finishing

	RPM		CHIPLOAD PER TOOTH (Fz)	
DIAMETER	40 - 50 HRC	50 - 60 HRC	40 - 50 HRC	50 - 60 HRC
1.0mm	20,000 - 40,000	20,000 - 40,000	.010 - .013	.008 - .010
1.5mm	20,000 - 40,000	20,000 - 40,000	.020 - .025	.013 - .020
2.0mm	20,000 - 40,000	20,000 - 40,000	.025 - .038	.020 - .030
3.0mm	20,000 - 40,000	20,000 - 36,000	.038 - .050	.025 - .038
4.0mm	20,000 - 32,000	20,000 - 25,000	.050 - .075	.038 - .050
6.0mm	18,000 - 25,000	15,000 - 18,000	.065 - .100	.050 - .075
8.0mm	14,000 - 19,000	12,000 - 14,000	.088 - .125	.065 - .100
10.0mm	12,000 - 16,000	10,000 - 12,000	.110 - .150	.075 - .110
12.0mm	9,000 - 12,000	7,500 - 9,000	.140 - .200	.100 - .150
16.0mm	6,500 - 9,000	5,000 - 7,000	.165 - .225	.125 - .175
20.0mm	5,500 - 7,500	4,000 - 6,000	.190 - .250	.150 - .200
25.0mm	4,000 - 6,000	3,500 - 5,500	.215 - .275	.175 - .225



RADIAL STEP OVER (ae)



AXIAL DEPTH OF CUT (ap)

Roughing	
Axial (ap)	15% - 25% of Dia.
Radial (ae)	20% - 30% of Dia.

Semi-Finishing	
Axial (ap)	5% - 8% of Dia.
Radial (ae)	2% - 5% of Dia.

Finishing	
Axial (ap)	1% - 3% of Dia.
Radial (ae)	.5% - 1% of Dia.

High pressure air is recommended for clearing chips away from the cut.

NOTE - ABOVE ARE STARTING PARAMETERS ONLY. HIGHER RESULTS MAY BE ACHIEVED WITH OPTIMUM CONDITIONS.