



List 3620 - EXOCARB® WXL®: Stub Length, 2 Flute

List 3621 - EXOCARB® WXL®: Regular Length, 2 Flute

Slotting

Hardness	-		<32 HRC		33-41 HRC		42-50 HRC							
Work Material	Copper Copper Alloy		Mild Steels Carbon Steels		Hardened Steels Pre-hardened Steels, Stainless Steels									
Cutting Speed	495 SFM		245 SFM		175 SFM		150 SFM							
Depth of Cut	<table border="1" style="display: inline-table; margin-right: 20px;"> <tr> <th>Dia</th> <th>aa</th> </tr> <tr> <td>D<1/8</td> <td>0.3D</td> </tr> <tr> <td>1/8≤D</td> <td>0.5D</td> </tr> </table>								Dia	aa	D<1/8	0.3D	1/8≤D	0.5D
Dia	aa													
D<1/8	0.3D													
1/8≤D	0.5D													
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min						
1/16	25,000	10.2	14,700	5.8	10,500	4.4	8,900	3.0						
5/64	24,000	12.2	11,800	6.2	8,300	4.2	7,200	3.1						
3/32	20,500	13.8	9,800	6.7	7,000	3.9	6,000	3.0						
7/64	17,500	15.0	8,400	7.7	6,000	4.3	5,100	3.2						
1/8	15,000	16.5	7,300	8.0	5,200	4.5	4,600	3.4						
5/32	12,000	17.7	5,900	9.0	4,200	4.9	3,700	3.7						
3/16	10,500	20.9	4,900	10.2	3,700	5.1	3,100	3.7						
7/32	8,700	21.3	4,300	10.6	3,100	5.1	2,600	3.9						
1/4	7,500	20.9	3,700	10.6	2,700	5.1	2,300	3.9						
9/32	6,900	20.9	3,400	10.6	2,500	5.1	2,100	3.9						
5/16	5,900	20.5	3,000	10.2	2,200	4.9	1,900	3.9						
3/8	5,100	20.1	2,500	10.2	1,800	4.9	1,500	4.0						
7/16	4,400	19.7	2,100	9.4	1,600	4.9	1,300	4.4						
1/2	4,000	20.1	1,900	9.4	1,400	4.9	1,200	3.7						
5/8	3,000	15.7	1,500	7.9	1,100	4.5	900	3.5						
3/4	2,600	13.6	1,200	6.5	900	3.9	800	3.1						

1. Use a rigid and precise machine and holder.
2. When chattering occurs, reduce the speed and feed simultaneously.
3. Use a suitable cutting fluid with high smoke retardant.

