



List 470: Regular Length - Multiple Flute - Center Hole

Side Milling

Hardness	<20 HRC		20-30 HRC		30-40 HRC		40-50 HRC		-										
Work Material	Medium Tensile Steels (up to 115 x 103 Lb/in ²) Mild Steel Forgings Cast Iron Brass and Bronze Copper		High Tensile Steels (115 x 103~145 x 103 Lb/in ²) Unalloyed Titanium Heat Resistant Ferritic Low Alloys		High Tensile Steels (145 x 103 ~200 x 103 Lb/in ²) Tool Steels Medium Strength Stainless Steels and Titanium Alloys		Heat Resistant High Alloys High Strength Stainless Steels and Titanium Alloys		Aluminum Alloyed Aluminum Plastics Woods										
Cutting Speed	80-100 SFM		60-75 SFM		40-55 SFM		26-40 SFM		195-330 SFM										
Depth of Cut	<table border="1"> <thead> <tr> <th>Dia</th> <th>aa</th> <th>ar</th> </tr> </thead> <tbody> <tr> <td>1/2 ≤ D ≤ 1-1/8</td> <td>1.5D</td> <td>0.3D</td> </tr> <tr> <td>1-1/4 ≤ D ≤ 2</td> <td>1D</td> <td>0.3D</td> </tr> </tbody> </table>										Dia	aa	ar	1/2 ≤ D ≤ 1-1/8	1.5D	0.3D	1-1/4 ≤ D ≤ 2	1D	0.3D
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Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min									
1/4	1,320	2.1	1,000	1.3	750	0.9	500	0.5	4,000	8.9									
5/16	1,060	2.4	800	1.5	600	1.0	400	0.5	3,150	9.9									
3/8	950	2.3	710	1.5	530	1.0	355	0.6	2,800	10.5									
1/2	670	3.0	500	1.9	375	1.1	250	0.8	2,000	12.4									
5/8	600	3.4	400	2.1	300	1.4	200	0.8	1,600	14.0									
3/4	475	3.5	355	2.3	265	1.4	180	0.9	1,400	14.8									
7/8	375	3.5	280	2.3	212	1.4	140	0.9	1,120	14.8									
1	335	3.4	250	2.1	190	1.4	125	0.8	1,000	14.0									
1-1/8	300	3.1	224	2.0	170	1.3	112	0.8	900	13.3									
1-1/4	265	3.8	200	2.4	150	1.5	100	1.0	800	15.8									
1-1/2	212	3.4	160	2.1	118	1.4	80	0.9	630	14.0									
1-3/4	190	3.1	140	2.0	106	1.3	71	0.8	560	13.3									
2	170	2.9	125	1.8	95	1.1	63	0.8	500	11.8									

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