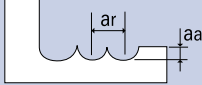




- List 521:** Single End, Regular Length, 2 Flute
- List 523:** Double End, Regular Length, 2 Flute
- List 526:** Single End, Regular Length, 2 Flute, Extension Type
- List 544:** Single End, Regular Length, 4 Flute
- List 621:** Ball End, Regular Length, 2 Flute
- List 644:** Ball End, Regular Length, Multiple Flute

Profiling

Hardness	<145 Brinell		<20 HRC		20-30 HRC		30-40 HRC		40-50 HRC		-	
Work Material	Mild Steels Hard Brass Bronze Cast Iron		Medium Carbon Steels Medium Strength Titanium Alloys Medium Strength Stainless Steels		High Carbon Steel Titanium Alloys High Strength Stainless Steels		Heat Resistant High Alloys Austenitic Alloys Nickel Base Alloys		Heat Resistant High Alloys High Strength Stainless Steels Titanium Alloys		Aluminum Aluminum Alloys	
Cutting Speed	80-150 SFM		80-110 SFM		50-65 SFM		30-50 SFM		16-32 SFM		80-390 SFM	
Depth of Cut	<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> a_a $2FL = 1/2D$ $4FL = 1/4D$ </div> <div style="text-align: center;"> $a_r = 0.1D$ </div> <div style="text-align: center;">  </div> </div>											
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	Speed RPM	Feed in/min
1/8	3,515	4.0	2,900	2.9	1,800	1.5	1,250	0.9	800	0.4	7,180	7.2
3/16	2,340	5.2	1,935	3.9	1,120	1.8	800	1.1	500	0.5	4,790	9.1
1/4	1,760	5.6	1,450	4.2	900	2.0	630	1.3	400	0.6	3,590	9.6
5/16	1,400	6.2	1,160	4.7	710	2.3	500	1.4	315	0.6	2,875	11.0
3/8	1,170	6.2	970	4.6	630	2.4	450	1.5	280	0.6	2,390	10.1
7/16	1,000	6.7	830	5.0	500	2.5	355	1.5	224	0.6	2,050	10.9
1/2	880	6.6	725	4.6	450	2.4	315	1.5	200	0.8	1,795	10.8
9/16	780	6.3	645	4.6	400	2.4	280	1.6	180	0.8	1,595	10.0
5/8	700	6.0	580	4.4	355	2.4	250	1.6	160	0.8	1,435	9.6
3/4	585	5.6	485	3.9	315	2.3	225	1.6	140	0.8	1,195	9.0
7/8	500	5.3	415	3.3	250	2.0	180	1.5	110	0.8	1,025	8.7
1	440	4.9	360	2.9	224	1.8	160	1.3	100	0.8	900	8.1
1-1/8	390	4.3	320	2.5	200	1.6	140	1.1	90	0.8	800	7.6
1-1/4	350	4.2	290	2.3	180	1.5	125	1.0	80	0.6	720	6.8
1-1/2	295	3.7	240	2.0	140	1.1	100	0.8	63	0.5	600	6.0

Reduce Speeds and Feeds by 10% for List 526
In case of deeper operation, slow down feed by 20-50%

