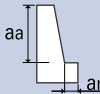





## List 593: 2° Taper on Side - 3 Flute

## List 594: 3° Taper on Side - 3 Flute

### Side Milling

Hardness	<145 Brinell	<20 HRC	20-30 HRC	30-40 HRC	40-50 HRC	-						
Work Material	Mild Steels Hard Brass Bronze Cast Iron	Med. Carbon Steels Med. Strength Titanium Alloys Med. Strength Stainless Steels	High Carbon Steel Titanium Alloys High Strength Stainless Steels	High Carbon Steel Titanium Alloys High Strength Stainless Steels	High Carbon Steel Titanium Alloys High Strength Stainless Steels	Aluminum Aluminum Alloys						
Cutting Speed	130-150 SFM	105-120 SFM	65-80 SFM	20-50 SFM	15-20 SFM	400-590 SFM						
Depth of Cut	$a_a = 1.5D$ $a_r = 0.1D$ 											
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
5/64	6,845	9.7	5,500	7.8	3,545	5.0	1,710	2.4	855	1.1	24,200	33.3
3/32	5,700	8.1	4,585	6.4	2,955	4.1	1,425	2.1	715	0.9	20,170	28.5
1/8	4,280	10.1	3,440	8.0	2,215	5.2	1,070	2.4	535	1.1	15,130	35.6
3/16	2,850	9.4	2,295	7.5	1,480	4.8	715	2.3	355	1.1	10,085	33.3
1/4	2,140	7.5	1,720	6.0	1,110	3.9	525	1.8	270	0.8	7,560	26.7
3/8	1,425	13.5	1,145	10.7	740	6.9	355	3.3	180	1.5	5,040	47.6
1/2	1,070	12.0	860	9.6	550	6.2	270	3.0	135	1.4	3,780	42.3
5/8	855	10.6	690	8.5	440	5.5	215	2.6	105	1.2	3,025	37.5

### Slotting

Hardness	<145 Brinell	<20 HRC	20-30 HRC	30-40 HRC	40-50 HRC	-						
Work Material	Mild Steels Hard Brass Bronze Cast Iron	Med. Carbon Steels Med. Strength Titanium Alloys Med. Strength Stainless Steels	High Carbon Steel Titanium Alloys High Strength Stainless Steels	High Carbon Steel Titanium Alloys High Strength Stainless Steels	High Carbon Steel Titanium Alloys High Strength Stainless Steels	Aluminum Aluminum Alloys						
Cutting Speed	80-120 SFM	60-80 SFM	45-60 SFM	25-45 SFM	8-20 SFM	150-350 SFM						
Depth of Cut	$a_a = 1/3D$ 											
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
5/64	4,890	3.2	3,420	2.4	2,670	1.5	1,710	1.2	685	0.3	12,225	7.0
3/32	4,075	3.1	2,850	2.4	2,140	1.5	1,425	0.9	570	0.3	10,190	7.2
1/8	3,055	3.2	2,140	2.5	1,600	1.9	1,070	1.2	430	0.3	7,640	7.3
3/16	2,040	3.1	1,425	2.7	1,070	1.8	715	1.2	285	0.3	5,095	7.5
1/4	1,530	3.6	1,070	3.2	800	2.2	535	0.9	215	0.3	3,820	7.9
3/8	1,020	4.4	715	3.3	535	2.6	355	1.5	140	0.5	2,545	9.7
1/2	765	4.1	535	2.8	400	2.2	270	1.5	105	0.5	1,910	8.7
5/8	610	3.4	430	2.6	320	2.0	215	1.2	85	0.3	1,530	7.9