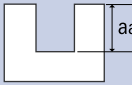


List 3870 - EXOCARB® WXL®: 2 Flute, Corner Radius, Regular Length

List 3770 - EXOCARB® WXL®: 2 Flute, Corner Radius, Regular Length

Slotting

Hardness	<20 HRC		20-30 HRC		30-38 HRC		38-45 HRC		45-55 HRC		55-60 HRC																													
Work Material	Mild Steel Carbon Steels		Alloy Steels Tool Steels		Hardened Steels Pre-hardened Steels		Hardened Steels Pre-hardened Steels		Hardened Steels		Hardened Steels																													
Cutting Speed	275 SFM		220 SFM		180 SFM		150 SFM		100 SFM		65 SFM																													
Depth of Cut	<table border="1"> <thead> <tr> <th>Dia</th> <th>a_a</th> </tr> </thead> <tbody> <tr> <td>D<1</td> <td>0.1D</td> </tr> <tr> <td>1≤D<3</td> <td>0.3D</td> </tr> <tr> <td>3<D</td> <td>0.5D</td> </tr> </tbody> </table>				Dia	a _a	D<1	0.1D	1≤D<3	0.3D	3<D	0.5D					<table border="1"> <thead> <tr> <th>Dia</th> <th>a_a</th> </tr> </thead> <tbody> <tr> <td>D<1</td> <td>0.2D</td> </tr> <tr> <td>1≤D<3</td> <td>0.2D</td> </tr> <tr> <td>3<D</td> <td>0.5D</td> </tr> </tbody> </table>				Dia	a _a	D<1	0.2D	1≤D<3	0.2D	3<D	0.5D	<table border="1"> <thead> <tr> <th>Dia</th> <th>a_a</th> </tr> </thead> <tbody> <tr> <td>D<1</td> <td>0.1D</td> </tr> <tr> <td>1≤D<3</td> <td>0.2D</td> </tr> <tr> <td>3<D</td> <td>0.5D</td> </tr> </tbody> </table>				Dia	a _a	D<1	0.1D	1≤D<3	0.2D	3<D	0.5D
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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	Speed RPM	Feed in/min																												
0.2	25,000	2.7	25,000	2.7	25,000	2.3	25,000	1.1	25,000	1.0	25,000	1.0																												
0.3	25,000	3.5	25,000	3.5	25,000	2.4	25,000	1.7	32,340	1.3	21,020	1.3																												
0.4	25,000	3.8	25,000	3.8	25,000	2.7	25,000	2.2	24,260	1.7	15,770	1.3																												
0.5	25,000	3.8	25,000	4.1	25,000	3.5	25,000	2.7	19,410	1.7	12,610	1.3																												
0.6	25,000	3.4	25,000	5.0	25,000	4.2	24,260	3.1	16,170	1.7	10,510	1.2																												
0.8	25,000	5.0	25,000	6.6	21,830	4.9	18,190	3.5	12,130	1.7	7,880	1.2																												
1.0	25,000	6.5	21,350	7.2	17,470	4.9	14,550	3.4	9,700	1.7	6,310	1.2																												
1.5	17,790	6.5	14,230	6.6	11,640	4.6	9,700	3.2	6,470	2.0	4,200	1.2																												
2.0	13,340	6.4	10,670	6.2	8,730	4.4	7,280	3.2	4,850	2.0	3,150	1.1																												
3.0	8,890	9.5	7,120	6.6	5,820	4.3	4,850	3.3	3,230	2.1	2,100	1.3																												
4.0	6,670	10.4	5,340	8.0	4,370	5.0	3,640	3.6	2,430	2.2	1,580	1.2																												
5.0	5,340	12.5	4,270	9.2	3,490	5.0	2,910	3.7	1,940	2.2	1,260	1.2																												
6.0	4,450	12.2	3,560	9.2	2,910	5.0	2,430	3.8	1,620	2.3	1,050	1.0																												
8.0	3,340	11.7	2,670	9.2	2,180	4.9	1,820	3.7	1,210	2.1	790	1.0																												
10.0	2,670	11.1	2,130	9.0	1,750	4.9	1,460	3.6	970	2.0	630	1.0																												
12.0	2,220	11.1	1,780	9.0	1,460	4.9	1,210	3.6	810	1.8	530	0.8																												
14.0	1,910	11.0	1,520	8.6	1,250	4.3	1,040	3.7	690	1.6	450	0.7																												
16.0	1,670	10.3	1,330	7.8	1,090	3.9	910	3.1	610	1.4	390	0.6																												
18.0	1,480	9.3	1,190	7.0	970	3.4	810	2.9	540	1.2	350	0.6																												
20.0	1,330	8.3	1,070	6.2	870	3.0	730	2.5	490	1.2	320	0.5																												
22.0	1,210	7.6	970	5.6	790	2.7	660	2.3	440	1.0	290	0.4																												
24.0	1,110	7.0	890	5.2	730	2.6	610	2.1	400	1.0	260	0.4																												
25.0	1,070	6.6	850	5.0	700	2.6	580	2.1	390	0.8	250	0.4																												
30.0	890	5.5	710	4.1	580	2.0	490	1.7	320	0.8	210	0.4																												

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.

