

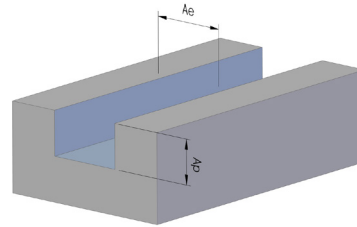
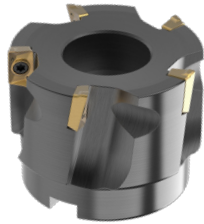
								SQUARE SHOULDER MILLING			
				Fz (INCH PER TOOTH)*		APMX					
ISO	MATERIAL	HARDNESS	Vc (SFM)*	-PF /-AL	-PM /-PR	APKT11T3	APKT1604				
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 275 BHN or ≤ 28 HRC	550-900	0.003 - 0.009	0.003 - 0.012	0.315	0.472				
	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 17-4 PH	≤ 375 BHN or ≤ 40 HRC	450-850	0.003 - 0.0075	0.003 - 0.010	0.315	0.472				
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F, 440F	≤ 275 BHN or ≤ 28 HRC	350 - 875	0.003 - 0.009	0.003 - 0.012	0.315	0.472				
	STAINLESS STEELS (DIFFICULT) 304, 304L, 316, 316L	≤ 275 BHN or ≤ 28 HRC	250 - 800	0.003 - 0.0075	0.003 - 0.010	0.315	0.472				
K	GRAY IRONS Class 20, 30, 40, 50, 60, G3000, G3500	≤ 220 BHN or ≤ 19 HRC	400 - 1000	0.004 - 0.010	0.004 - 0.012	0.315	0.472				
	DUCTILE IRONS D&M series, 250, 300, 350, 400, 60-40-18, 65-45-12	≤ 260 BHN or ≤ 26 HRC	300 - 800	0.004 - 0.012	0.004 - 0.012	0.315	0.472				
N	NON-FERROUS Aluminum, Aluminum cast, Brass, Copper, Bronze, Non Metallic	≤ 271 BHN or ≤ 28 HRC	600-1200	0.004 - 0.014	0.004 - 0.016	0.315	0.472				
H	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 555 BHN or ≤ 55 HRC	190 - 500	0.003 - 0.007	0.003 - 0.009	0.315	0.472				
S	HR SUPER ALLOYS Inconel 718, Waspaloy, Hastelloy, Inconel 625, Stellite 31, Haynes 25, Rene 41	≤ 275 BHN or ≤ 28 HRC	70-220	0.002 - 0.006	0.002 - 0.007	0.315	0.472				
	TITANIUM 6AL-4V, ASTM 1, 2, 3, 6AL-2S	≤ 275 BHN or ≤ 28 HRC	230-450	0.003 - 0.0085	0.003 - 0.010	0.315	0.472				

*Speeds & feeds are starting recommendations only. Factors such as machine type, fixture, tooling rigidity, available horsepower, coolant delivery method and others will affect the performance significantly.

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by Ultra-Dex



				SQUARE SLOT MILLING			
				Fz (INCH PER TOOTH)*		APMX	
ISO	MATERIAL	HARDNESS	Vc (SFM)*	-PF /-AL	-PM /-PR	APKT11T3	APKT1604
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 275 BHN or ≤ 28 HRC	550-900	0.003 - 0.006	0.003 - 0.010	0.315	0.472
	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 17-4 PH	≤ 375 BHN or ≤ 40 HRC	450-850	0.003 - 0.006	0.003 - 0.0085	0.315	0.472
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F, 440F	≤ 275 BHN or ≤ 28 HRC	350 - 875	0.003 - 0.007	0.003 - 0.010	0.315	0.472
	STAINLESS STEELS (DIFFICULT) 304, 304L, 316, 316L	≤ 275 BHN or ≤ 28 HRC	250 - 800	0.003 - 0.006	0.003 - 0.010	0.315	0.472
K	GRAY IRONS Class 20, 30, 40, 50, 60, G3000, G3500	≤ 220 BHN or ≤ 19 HRC	400 - 1000	0.004 - 0.008	0.004 - 0.010	0.315	0.472
	DUCTILE IRONS D&M series, 250, 300, 350, 400, 60-40-18, 65-45-12	≤ 260 BHN or ≤ 26 HRC	300 - 800	0.004 - 0.008	0.004 - 0.010	0.315	0.472
N	NON-FERROUS Aluminum, Aluminum cast, Brass, Copper, Bronze, Non Metallic	≤ 271 BHN or ≤ 28 HRC	600-1200	0.004 - 0.011	0.004 - 0.014	0.315	0.472
H	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 555 BHN or ≤ 55 HRC	190 - 500	0.003 - 0.006	0.003 - 0.007	0.315	0.472
S	HR SUPER ALLOYS Inconel 718, Waspaloy, Hastelloy, Inconel 625, Stellite 31, Haynes 25, Rene 41	≤ 275 BHN or ≤ 28 HRC	70-220	0.002 - 0.006	0.002 - 0.007	0.315	0.472
	TITANIUM 6AL-4V, ASTM 1, 2, 3, 6AL-2S	≤ 275 BHN or ≤ 28 HRC	230-450	0.003 - 0.006	0.003 - 0.008	0.315	0.472

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