

Curfaca East



2, 3 & 4 Flute Solid Carbide CNC AITIN Coated Spiral Router Bits / End Mills For Steel & Stainless Steel

Motorial	Per Minute							Food	Doto	Incho	Dor M	linuta									
Material	(35111)	4 /4 0				401 /4								2/01			1/01			Tool Reference #	#'s Dia
		1/16" - 1/8" (3mm)			3/16" (4mm)			1/4" (bmm)			5/16"			3/8"			1/2"			2 Flute	
		2 Flute	3 Flute	4 Flute	2 Flute	3 Flute	4 Flute	2 Flute	3 Flute	4 Flute	2 Flute	3 Flute	4 Flute	2 Flute	3 Flute	4 Flute	2 Flute	3 Flute	4 Flute	51461	1/8"
		12,200 RPM*			8,200 RPM*			6,100 RPM*			5,000 RPM*			4,100 RPM*			3,100 RPM*			51463	3/16
Steel: Low Carbon	400"	29"	43"	58"	32"	48"	64"	28"	43"	56"	30"	45"	60"	32"	48"	64"	29"	43"	58"	51465	1/4"
		7 600 PDM*								2 100 DDM*						1.000 DDM*			51466	1/4"	
			,600 RPIVI	•	;	5, I UU RPIN	1	3	3,800 RPIV	• 	3	5, I UU RPIVI	^	4	2,500 RPIV	• 		1,900 RPIV	^	51467	3/8"
Steel: Medium Carbon	250"	18"	27"	36"	20"	30"	40"	18"	27"	36"	18"	27"	36"	19"	28"	38"	19"	28"	38"	51468	1/2"
		6,100 RPM*			4,100 RPM*			3,100 RPM*			2,500 RPM*			2,000 RPM*			1,500 RPM*			51674	1/10
Tool Steel: Hardened	200"	4"	6"	8"	4"	6"	8"	4"	6"	8"	4"	6"	8"	4"	6"	8"	4"	6"	8"	51675	3/16
		10 700 PDM*			7 100 PDM*			5 200 PDM*			4 200 DDM*			2 600 PDM*			2 600 PDM*			51676	1/4"
					7,100 KPWI*			5,300 KPIVI*			4,300 KPIVI*			3,000 KPIVI"			2,000 KPIVI"			51677	3/8"
Stainless Steel:	350"	18"	27"	36"	20"	30"	40"	18"	27"	36"	18"	27"	36"	19"	28"	38"	19"	28"	38"	3 Flute	;
301, 303, 410																				51460	1/8"
		6.700 RPM*		4.100 RPM*			3.400 RPM*			2.700 RPM*			2.200 RPM*			1.700 RPM*			51462	3/16	
Stainless Steel	220"	18"	27"	36"	20"	30"	40"	18"	27"	36"	18"	27"	36"	10"	28"	38"	10"	28"	38"	51464	
	220	10	21	50	20	00	10			00	10	21	00		20	50	15	20	50	51612	4mm
304, 316, 17-4 PH																				51614	6mm
		5,300 RPM*		4,700 RPM*			2,700 RPM*			2,100 RPM*			1,800 RPM*			1,300 RPM*			4 Flute		
Titanium Alloys	175"	18"	27"	36"	20"	30"	40"	18"	27"	36"	18"	27"	36"	19"	28"	38"	19"	28"	38"	51602	1/8"
		10.700 RPM*		1*	7,100 RPM*			5,300 RPM*			4,300 RPM*			3,600 RPM*			2,600 RPM*			51604	1/4"
Cast Iron: Grav CG	350"	18"	27"	36"	20"	30"	40"	18"	27"	36"	18"	27"	36"	19"	28"	38"	19"	28"	38"		
		7 600 BPM*		5 100 BPM*			3 800 BPM*			3 100 RPM*			2 500 BPM*			1 900 BPM*					
			,000 11 10		, ,	5,100 m W			,			,			.,			1,000 11 10			
Cast Iron: Ductile	250"	18"	27"	36"	20"	30"	40"	18"	27"	36"	18"	27"	36"	19"	28"	38"	19"	28"	38"		

*RPM: Revolutions Per Minute

Simple Machining Calculations: To find **RPM:** (SFM x 3.82) / diameter of tool To find **SFM:** 0.262 x diameter of tool x RPM To find **Feed Rate IPM:** RPM x # of flutes x chip load To find **Chip Load:** Feed Rate IPM / (RPM x # of Flutes)

Depth of Cut:1 x D Use recommended feed rate2 x D Reduce feed rate by 25%3 x D Reduce feed rate by 50%