

Recommended Machining Conditions for FFT3-03 Fast Feed Endmills

Workpiece Material						Carbide Grade	D.O.C. a _p (inch)	Cutting Speed v _c (sfm)	Feed f _z (ipt)	Coolant
ISO Class DIN/ ISO 513	Description	ISCAR Mat. Group*	Hardness, HB	Typical Materials						
				AISI/SAE/ASTM	DIN W.-Nr.					
P	non-alloy steel and cast steel, free cutting steel	1-5	130-180	1020	1.0402	IC808	.008-.023	400-660	.011-.031	dry/wet
						IC830		360-590	.011-.031	
	low alloy and cast steel (less than 5% of alloying elements)	6-8	260-300	4340	1.6582	IC808		330-590	.011-.027	
						IC830		300-520	.011-.027	
		9	HRC 35-42**	3135	1.5710	IC808		330-520	.011-.023	
						IC830		300-490	.011-.023	
	high alloyed steel, cast steel and tool steel	10-11	200-220	H13	1.2344	IC808		260-490	.011-.023	
						IC830		230-460	.011-.023	
	stainless steel and cast steel	12-13	200	420	1.4021	IC808		260-490	.011-.023	
						IC830		230-490	.011-.023	
M	stainless steel and cast steel	14	200	304L	1.4306	IC808	.008-.023	330-520	.011-.023	dry
						IC830		260-390	.011-.023	
						IC5820		330-520	.011-.023	
						IC882		260-420	.011-.023	
K	gray cast iron (GG)	15-16	250	class 40	0.6025 (GG25)	IC808	.008-.023	490-650	.011-.023	dry
	nodular cast iron (GGG)	17-18	200	class 65-45-12	0.7050 (GGG50)	IC808		460-490	.011-.023	
S	high temperature alloys and titanium	33-35	340	inconel 718	2.4668	IC882	.008-.020	60-100	.008-.015	wet
						IC5820		80-115	.008-.015	
						IC808		80-115	.008-.015	
						IC830		80-100	.008-.015	
		36-37	HRC 30-32	AMS R56400	3.7165 (Ti6Al4V ELI)	IC882		80-115	.008-.020	
						IC5820		80-130	.008-.020	
						IC808		80-115	.008-.020	
						IC830		60-100	.008-.020	
H	hardened steel	38	HRC 45-49	HARDOX 450 plate		IC808	.008-.020	160-250	.008-.015	dry/wet
	chilled cast iron	40	400	Ni-hard 1	0.9625			260-330	.008-.020	
	cast iron	41	500	A532 IID	0.9645			160-250	.008-.015	

* ISCAR material group in accordance with VDI 3323 standard
** Quenched and tempered
For machining under unstable conditions, the recommended cutting data should be reduced by 20-30%

Application Range FFT3-03

