

3 FLUTE END MILL (Series E453)

Material	Cast Iron, Nodular Cast Iron		Carbon Steel, Alloy Steel -750N/Mm ²		Carbon Steel, Alloy Steel -30 HRC		Pre-hardened Steel, Quenched and Tempered Steel -40 HRC		Stainless Steel		Pre-Hardened Steel, Quenched and Tempered Steel -50 HRC	
	Diameter	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)
1	20000	200	20000	200	20000	165	20000	165	20000	70	20000	125
2	15000	330	15000	330	15000	300	15000	290	11150	85	13000	185
3	14000	565	14000	565	13000	525	10600	435	7500	110	8500	340
4	10800	580	10800	580	10000	535	80000	430	5500	115	6500	350
5	8200	600	8200	600	7600	560	6400	465	4500	115	5000	365
6	7000	615	7000	615	6400	575	5300	480	3700	125	4200	375
8	5200	615	5200	615	4800	565	4000	470	2800	125	3200	380
10	4200	605	4200	605	3800	560	3200	315	2200	125	2500	580
12	3500	605	3500	605	3200	560	2650	315	1850	125	2100	580
14	3000	565	3000	565	2700	525	2300	435	1600	125	1800	340
16	2600	565	2600	565	2400	525	2000	435	1400	110	1600	340
18	2300	560	2300	560	2100	515	1800	430	1250	105	1400	335
20	2050	560	2050	560	1900	515	1600	430	1100	105	1250	335

4 FLUTE END MILL (Series E454)

Material	Cast Iron, Nodular Cast Iron		Carbon Steel, Alloy Steel -750N/Mm ²		Carbon Steel, Alloy Steel -30 HRC		Pre-hardened Steel, Quenched and Tempered Steel -40 HRC		Stainless Steel		Pre-Hardened Steel, Quenched and Tempered Steel -50 HRC	
	Diameter	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)	Feed (mm/min)	RPM (min ⁻¹)
1	20000	250	20000	250	20000	200	20000	200	20000	90	20000	150
2	15000	400	15000	400	15000	360	15000	350	11150	100	13000	225
3	14000	680	14000	680	13000	630	10600	525	7500	120	8500	410
4	10800	700	10800	700	10000	640	80000	535	5500	125	6500	420
5	8200	730	8200	730	7600	670	6400	560	4500	125	5000	440
6	7000	750	7000	750	6400	690	5300	575	3700	135	4200	450
8	5200	740	5200	740	4800	680	4000	565	2800	135	3200	460
10	4200	730	4200	730	3800	670	3200	530	2200	135	2500	435
12	3500	730	3500	730	3200	670	2650	560	1850	135	2100	435
14	3000	680	3000	680	2700	630	2300	525	1600	125	1800	410
16	2600	680	2600	680	2400	630	2000	525	1400	120	1600	410
18	2300	670	2300	670	2100	620	1800	515	1250	105	1400	405
20	2050	670	2050	670	1900	620	1600	515	1100	105	1250	405

MAX-MILL
(General Machining)

ALI-MAX
(Aluminium Machining)

HARD-MAX
(Hardened Steels)

MAX-V
(Exotic Materials)

HM Series
(up to HRC65)

Eco-Mill
(up to HRC45)

P-Mill
(General Machining)

Ali-Mill
(Aluminium Machining)

HSS 8% COBALT