

## HSS CO8 End Mills Data Sheet

Workpiece	unalloys steel		carbon steel		carbon steel		cast steel		alloyed steel		tool steel, hardened and tempered steel		Front cutting
	SS41, S15C,	30mm/min Spindle Speed rpm	FC20 FC30	S50C, S15C,	25mm/min Spindle Speed rpm	FC20 FC30	SCM, SNC, SNCM	20mm/min Spindle Speed rpm	mm/min Feed Speed	mm/min Feed Speed	SKD, SUS304, NAK55HPM	15mm/min Spindle Speed rpm	
3	3000	100	110	2600	110	2100	30	1500	20	20	1500	20	W=0.5D, D=1/2D  2F with short length Depth of cut: 1/2D  4F with short length Depth of cut: 1/4D  Over above depth, decrease the feed speed by 20--26%
4	2400	100	110	2000	110	1600	30	1200	20	1200	20		
6	1600	130	140	1300	140	1060	40	800	30	800	30		
8	1200	140	150	1000	150	800	50	600	40	600	40		
10	960	150	160	800	160	630	50	480	50	480	50		
12	800	120	130	670	130	530	50	400	60	400	60		
14	680	100	120	570	120	450	50	340	60	340	60		
16	600	100	110	500	110	400	60	300	60	300	60		
18	530	100	105	440	105	350	60	265	60	265	60		
20	480	90	100	400	100	320	60	240	50	240	50		
22	440	90	100	360	100	290	60	220	50	220	50		
25	380	80	90	320	90	255	50	190	40	190	40		
28	340	70	80	280	80	230	60	170	40	170	40		
30	320	70	70	265	70	210	50	160	30	160	30		
32	300	60	70	250	70	200	40	150	30	150	30		
35	270	60	65	230	65	180	40	135	30	135	30		
40	240	50	60	200	60	160	30	120	30	120	30		
45	210	50	55	175	55	140	30	100	20	100	20		
50	190	40	50	160	50	125	30	95	20	95	20		

