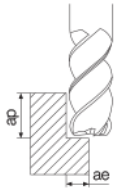
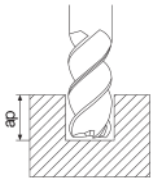
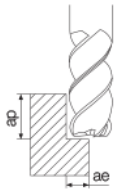
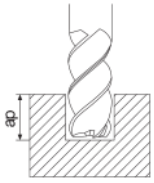
2FESW

Applications	Workpiece Material	Application	Outside Dia. Dc (mm)	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø13
 Shouldering (ap×ae) (inch) 0.0394Dc×0.0079Dc  Slotting (ae) (inch) 0.0079Dc	Carbon Steel	Shouldering	Spindle RPM	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (IPM)	25.984	25.197	25.197	25.197	20.472	17.717	16.142	13.780
		Slotting	Spindle RPM	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (IPM)	25.984	25.197	25.197	25.197	20.472	17.717	16.142	13.780
	Alloy Steel	Shouldering	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	16.535	16.929	16.929	16.929	13.780	11.811	10.630	9.055
		Slotting	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	16.535	16.929	16.929	16.929	13.780	11.811	10.630	9.055
	Pre-hardened Steel (30~45HRC)	Shouldering	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	16.535	16.929	16.929	16.929	13.780	11.811	10.630	9.055
		Slotting	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	16.535	16.929	16.929	16.929	13.780	11.811	10.630	9.055
	Stainless Steel	Shouldering	Spindle RPM	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500
			Feed Rate (IPM)	12.598	12.598	12.598	12.598	10.236	9.055	8.268	7.087
		Slotting	Spindle RPM	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500
			Feed Rate (IPM)	12.598	12.598	12.598	12.598	10.236	9.055	8.268	7.087

* Cutting with coolant is recommended for stainless steel.

3FESW

Applications	Workpiece Material	Application	Outside Dia. Dc (mm)	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø13
 Shouldering (ap×ae) (inch) 0.0394Dc×0.0079Dc  Slotting (ae) (inch) 0.0079Dc	Carbon Steel	Shouldering	Spindle RPM	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (IPM)	31.890	31.496	31.496	31.496	25.591	22.047	20.079	17.717
		Slotting	Spindle RPM	11,000	8,000	6,400	5,300	4,000	3,200	2,700	2,500
			Feed Rate (IPM)	31.890	31.496	31.496	31.496	25.591	22.047	20.079	17.717
	Alloy Steel	Shouldering	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	20.866	20.866	20.866	20.866	16.929	14.567	13.386	11.811
		Slotting	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	20.866	20.866	20.866	20.866	16.929	14.567	13.386	11.811
	Pre-hardened Steel (30~45HRC)	Shouldering	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	20.866	20.866	20.866	20.866	16.929	14.567	13.386	11.811
		Slotting	Spindle RPM	7,400	5,600	4,500	3,700	2,800	2,200	1,900	1,700
			Feed Rate (IPM)	20.866	20.866	20.866	20.866	16.929	14.567	13.386	11.811
	Stainless Steel	Shouldering	Spindle RPM	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500
			Feed Rate (IPM)	15.748	15.748	15.748	15.748	12.598	11.024	10.236	9.055
		Slotting	Spindle RPM	6,400	4,800	3,800	3,200	2,400	1,900	1,600	1,500
			Feed Rate (IPM)	15.748	15.748	15.748	15.748	12.598	11.024	10.236	9.055

* Cutting with coolant is recommended for stainless steel.