

Hole Finishing

HSR™ Application Data • Series 050281



■ Series 050281 • Uncoated • Carbide-Tipped • Helical Flute • Grade K10F™ • Metric

Material Group								
		Cutting Speed – vc Range – m/min			Recommended Feed Rate per Rev			
		min		max	Tool Diameter	12,70–15,00	15,00–20,00	20,00–32,00
P	1	50	–	70	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	2	40	–	60	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	3	40	–	60	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	4	30	–	40	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	5	20	–	30	mm/r	0,50–0,90	0,60–1,05	0,60–1,10
	6	10	–	20	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
M	1	10	–	20	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
	2	10	–	20	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
	3	10	–	20	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
K	1	30	–	50	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	2	30	–	50	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	3	30	–	40	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
N	1	130	–	150	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	2	140	–	160	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	3	140	–	160	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	4	130	–	150	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	5	120	–	140	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
	6	150	–	170	mm/r	0,60–1,20	0,70–1,30	0,80–1,40
S	1	10	–	20	mm/r	0,30–0,50	0,30–0,60	0,35–0,65
	2	10	–	20	mm/r	0,30–0,50	0,30–0,60	0,35–0,65
	3	30	–	40	mm/r	0,35–0,65	0,40–0,80	0,50–0,90
	4	30	–	40	mm/r	0,35–0,65	0,40–0,80	0,50–0,90