

Hole Finishing

HSR™ Application Data • Series 456681



■ Series 456681 • Cermet-Tipped • Helical Flute • Grade CERMET-DCFD™ • Metric

Material Group		  				
		Cutting Speed — vc Range — m/min			Recommended Feed Rate per Rev	
		min		max	Tool Diameter	
P	1	110	–	130	mm/r	12,70–15,00
	2	110	–	130	mm/r	0,50–0,90
	3	100	–	120	mm/r	0,60–1,05
	4	60	–	80	mm/r	0,50–0,90
	5	30	–	50	mm/r	0,60–1,05
	6	30	–	40	mm/r	0,35–0,65
						15,00–20,00
						0,50–0,90
						0,60–1,05
						0,50–0,90
						0,60–1,05
						0,40–0,80