

SE504 , SR504 SERIES ▶ Slotting

Workpiece	Alloy Steels, Cast Iron		Stainless Steels 300 Series		Stainless Steels 400 Series		Titanium		Inconel	
	Hardness									
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	40,500	300	20,000	250	28,000	160	23,925	225	9330	60
1.5	27,000	300	13,000	180	18,500	160	15,730	185	6135	50
2	20,300	300	10,000	150	14,000	160	12,010	165	4685	45
2.5	16,200	300	8,000	120	11,000	165	9,490	155	3700	40
3	13,500	275	6,690	105	9,350	145	8,045	135	3135	35
4	10,100	370	5,050	135	7,000	185	6,005	195	2340	50
5	8,090	410	4,050	165	5,600	230	4,815	360	1875	60
6	6,750	480	3,350	190	4,700	265	4,030	415	1570	70
8	5,050	620	2,500	250	3,500	340	3,000	545	1170	95
10	4,050	780	2,050	320	2,800	430	2,430	695	945	120
12	3,370	750	1,680	310	2,350	435	2,010	685	780	115
14	2,890	670	1,400	280	2,000	405	1,700	820	715	150
16	2,500	630	1,250	265	1,750	370	1,500	950	600	180
18	2,250	630	1,100	260	1,550	365	1,320	1,245	515	250
20	2,000	620	1,000	260	1,400	365	1,200	1,875	480	390

RPM = rev/min
FEED = mm/min



SE504, SR504 SERIES ▶ Side Cutting

Workpiece	Alloy Steels, Cast Iron		Stainless Steels 300 Series		Stainless Steels 400 Series		Titanium		Inconel	
	Hardness									
Diameter (mm)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1	40,500	335	20,000	280	28,000	180	23,925	260	9570	65
1.5	27,000	335	13,000	200	18,500	180	15,730	215	6290	55
2	20,300	335	10,000	170	14,000	180	12,010	195	4805	50
2.5	16,200	335	8,000	135	11,000	185	9,490	180	3795	45
3	13,500	310	6,690	115	9,350	160	8,045	155	3215	40
4	10,100	415	5,050	150	7,000	205	6,005	335	2520	60
5	8,090	460	4,050	185	5,600	260	4,815	410	2020	75
6	6,750	540	3,350	215	4,700	295	4,030	470	1690	85
8	5,050	700	2,500	280	3,500	380	3,000	620	1260	110
10	4,050	880	2,050	360	2,800	485	2,430	790	1020	145
12	3,370	845	1,680	350	2,350	490	2,010	780	845	140
14	2,890	755	1,400	315	2,000	455	1,700	925	715	170
16	2,500	710	1,250	295	1,750	415	1,500	1075	600	205
18	2,250	710	1,100	290	1,550	410	1,320	1410	515	275
20	2,000	700	1,000	290	1,400	410	1,200	2120	480	430

RPM = rev/min
FEED = mm/min

