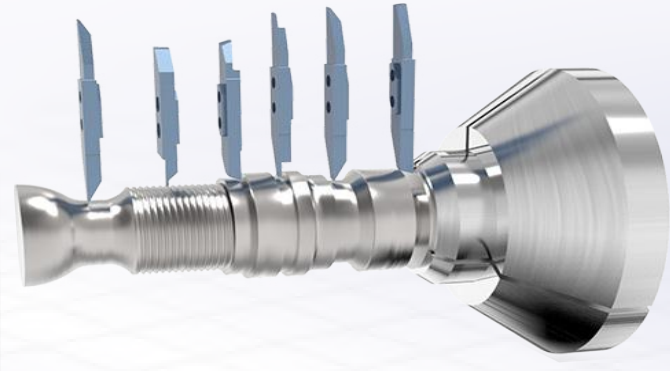
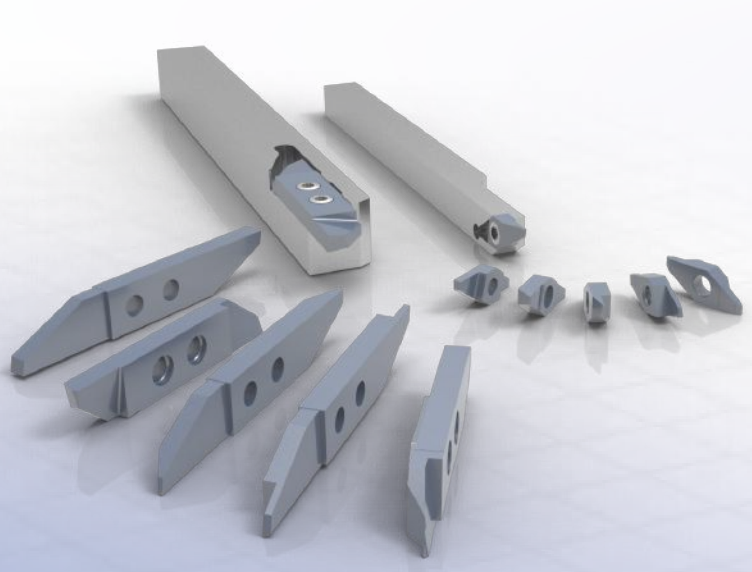


Speeds And Feeds Multidec CUT



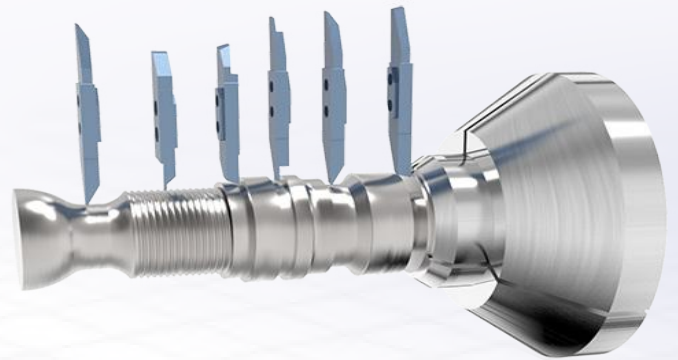
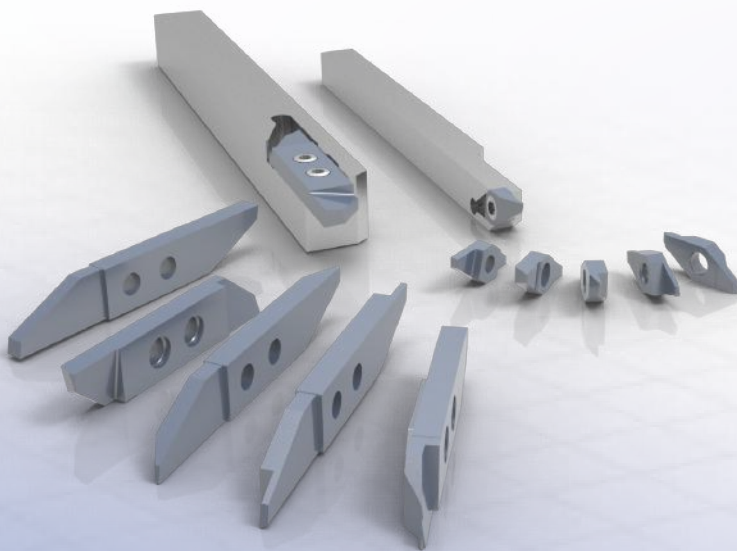
CUT	Steel Unalloyed			Steel Low Alloyed			Steel High Alloyed		
Hardness (HB)-(HRC)	125-300 HB			180-250 HB			200-350 HB		
Category	I			II			III		
Machining Method	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing
Feeds	f(in/rev)								
	.004-.010	.0008-.006	.0002-.003	.004-.010	.0008-.006	.0002-.003	.004-.010	.0008-.006	.0002-.003
Depth of cut	ap(in)								
	<.197	<.118	<.079	<.197	<.118	<.079	<.157	<.098	<.059
Cutting speeds	vc(ft/min)								
Carbide grade									
UHM 20	130-360	190-390	190-460	190-330	190-390	190-430	130-290	190-360	190-390
UHM 20 HPX	490-650	590-720	650-850	260-490	330-590	520-720	230-330	290-490	390-590
UHM 20 TX+	-	-	-	260-430	330-490	520-620	230-290	290-430	390-490
UHM 30	100-230	160-260	160-330	100-200	130-260	130-290	-	100-230	100-60
UHM 30 HX	160-460	160-590	160-720	160-430	160-20	160-650	130-390	160-460	160-590
UHM 30 TX+	-	-	-	-	-	-	-	-	-
High speed steel									
HSS	80-100	80-115	80-130	65-100	65-115	65-115	50-65	50-80	50-100
HSS HX	100-130	115-130	115-160	50-115	50-130	50-150	65-100	65-100	65-115



Speeds And Feeds Multidec CUT



CUT	Stainless Steel			Stainless Steel			Titanium		
Hardness (HB)-(HRC)	180-220 HB			220-330 HB			-		
Category	V			VI			IV		
Machining Method	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing
Feeds	f(in/rev)								
	.004-.008	.0004-.005	.0002-.003	.004-.008	.0004-.05	.0002-.003	.004-.010	.0008-.003	.0002-.002
Depth of cut	ap(in)								
	<.157	<.098	<.059	<.157	<.098	<.059	<.157	<.098	<.059
Cutting speeds	vc(ft/min)								
Carbide grade									
UHM 20	130-330	130-360	130-390	100-230	100-260	100-260	130-190	160-230	190-260
UHM 20 HPX	300-490	360-590	520-650	230-300	300-390	360-490	160-330	190-390	190-460
UHM 20 TX+	300-430	360-520	520-590	230-300	300-390	360-490	160-330	190-390	190-460
UHM 30	-	100-230	100-260	-	65-130	65-130	-	80-190	100-230
UHM 30 HX	130-330	130-460	130-590	100-190	130-230	130-290	100-290	130-330	130-390
UHM 30 TX+	-	-	-	-	-	-	-	-	-
High speed steel									
HSS	50-65	50-80	50-100	30-65	50-65	50-80	30-65	50-65	50-80
HSS HX	65-100	65-100	65-115	65-100	65-100	65-115	65-100	65-100	65-115



Speeds And Feeds Multidec CUT



CUT	Aluminum			Brass			Hard Materials		
Hardness (HB)-(HRC)	60-130 HB			-			45-70 HRC		
Category	VII			VIII			X		
Machining Method	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing	▼ Roughing	▼▼ Medium Cut	▼▼▼ Micro Finishing
Feeds	f(in/rev)								
	.004-.012	.0008-.010	.0002-.008	.004-.012	.0008-.006	.0002-.004	-	-	-
Depth of cut	ap(in)								
	.197	.118	.079	.197	.118	.079	-	-	-
Cutting speeds	vc(ft/min)								
Carbide grade									
UHM 20	330-4920	390-6560	520-8200	260-980	330-1310	390-1640	-	-	-
UHM 20 HPX	-	-	-	-	-	-	-	-	-
UHM 20 TX+	-	-	-	-	-	-	-	-	-
UHM 30	160-3280	190-3940	260-9840	130-330	160-460	160-520	-	-	-
UHM 30 HX	230-4920	260-6560	330-9840	160-490	160-650	160-820	-	-	-
UHM 30 TX+	-	-	-	-	-	-	-	-	-
High speed steel									
HSS	100-260	130-260	160-290	100-160	100-190	130-230	-	-	-
HSS HX	130-290	160-330	160-390	130-190	130-260	160-290	-	-	-

