

HPCJET Operating Data

	Material	Process	Type	Cutting Tool dia.	Hardness	Pressure	Speed (n)	Ae (mm)	Ap (mm)	Fz (mm)
N	Al-Si 9%	Drilling	Drill	0.3	100-120 HB	15	22000	0.3	0.025	0.002
	Al-Si 9%	Drilling	Drill	0.3	100-120 HB	20	25000	0.3	0.027	0.002
	Al-Si 9%	Drilling	Drill	0.3	100-120 HB	40	35000	0.3	0.027	0.002
	Al-Si 9%	Drilling	Drill	0.3	100-120 HB	70	45000	0.3	0.027	0.002
	Al-Si 9%	Drilling	Drill	0.5	100-120 HB	15	22000	0.5	0.05	0.003
	Al-Si 9%	Drilling	Drill	0.5	100-120 HB	20	25000	0.5	0.05	0.003
	Al-Si 9%	Drilling	Drill	0.5	100-120 HB	40	35000	0.5	0.1	0.003
	Al-Si 9%	Drilling	Drill	0.5	100-120 HB	70	45000	0.3	0.027	0.003
	Al-Si 9%	Drilling	Drill	0.8	100-120 HB	15	22000	0.8	0.1	0.003
	Al-Si 9%	Drilling	Drill	0.8	100-120 HB	20	25000	0.8	0.15	0.003
	Al-Si 9%	Drilling	Drill	0.8	100-120 HB	40	35000	0.8	0.15	0.003
	Al-Si 9%	Drilling	Drill	0.8	100-120 HB	70	45000	0.8	0.027	0.003
	Al-Si 9%	Drilling	Drill	1	100-120 HB	15	22000	1	0.3	0.008
	Al-Si 9%	Drilling	Drill	1	100-120 HB	20	25000	1	0.3	0.008
	Al-Si 9%	Drilling	Drill	1	100-120 HB	40	35000	1	0.3	0.008
	Al-Si 9%	Drilling	Drill	1	100-120 HB	70	45000	1	0.027	0.008
	Al-Si 9%	Drilling	Drill	1.5	100-120 HB	15	22000	1.5	0.15	0.008
	Al-Si 9%	Drilling	Drill	1.5	100-120 HB	20	25000	1.5	0.2	0.008
	Al-Si 9%	Drilling	Drill	1.5	100-120 HB	40	35000	1.5	0.25	0.008
	Al-Si 9%	Drilling	Drill	1.5	100-120 HB	70	45000	1.5	0.027	0.008
	Al-Si 9%	Drilling	Drill	2	100-120 HB	15	22000	2	0.2	0.008
	Al-Si 9%	Drilling	Drill	2	100-120 HB	20	25000	2	0.25	0.008
	Al-Si 9%	Drilling	Drill	2	100-120 HB	40	35000	2	0.3	0.008
	Al-Si 9%	Drilling	Drill	2	100-120 HB	70	45000	2	0.027	0.008
	Al-Si 9%	Drilling	Drill	3	100-120 HB	15	22000	3	0.25	0.008
	Al-Si 9%	Drilling	Drill	3	100-120 HB	20	25000	3	0.3	0.008
	Al-Si 9%	Drilling	Drill	3	100-120 HB	40	35000	3	0.35	0.008
	Al-Si 9%	Drilling	Drill	3	100-120 HB	70	45000	3	0.027	0.008
	Al-Si 9%	Drilling	Drill	4	100-120 HB	15	22000	4	0.2	0.008
	Al-Si 9%	Drilling	Drill	4	100-120 HB	20	25000	4	0.25	0.01
	Al-Si 9%	Drilling	Drill	4	100-120 HB	40	35000	4	0.25	0.01
	Al-Si 9%	Drilling	Drill	4	100-120 HB	70	45000	4	0.027	0.008
	Al-Si 9%	Drilling	Drill	5	100-120 HB	15	22000	5	0.2	0.01
	Al-Si 9%	Drilling	Drill	5	100-120 HB	20	25000	5	0.2	0.01
	Al-Si 9%	Drilling	Drill	5	100-120 HB	40	35000	5	0.2	0.01
	Al-Si 9%	Drilling	Drill	5	100-120 HB	70	45000	5	0.027	0.01
	Al-Si 9%	Drilling	Drill	6	100-120 HB	15	22000	6	0.3	0.01
	Al-Si 9%	Drilling	Drill	6	100-120 HB	20	25000	6	0.3	0.01
	Al-Si 9%	Drilling	Drill	6	100-120 HB	40	35000	6	0.3	0.01
	Al-Si 9%	Drilling	Drill	6	100-120 HB	70	45000	6	0.027	0.01
	Al-Si 9%	Profile Milling	Ball Nose	0.5	100-120 HB	15	22000	0.06	0.05	0.008
	Al-Si 9%	Profile Milling	Ball Nose	0.5	100-120 HB	20	25000	0.06	0.05	0.01
	Al-Si 9%	Profile Milling	Ball Nose	0.5	100-120 HB	40	35000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	0.5	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	0.8	100-120 HB	15	22000	0.06	0.05	0.008
	Al-Si 9%	Profile Milling	Ball Nose	0.8	100-120 HB	20	25000	0.06	0.05	0.01
	Al-Si 9%	Profile Milling	Ball Nose	0.8	100-120 HB	40	35000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	0.8	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	1	100-120 HB	15	22000	0.1	0.075	0.004
	Al-Si 9%	Profile Milling	Ball Nose	1	100-120 HB	20	25000	0.1	0.075	0.004
	Al-Si 9%	Profile Milling	Ball Nose	1	100-120 HB	40	35000	0.11	0.15	0.004
	Al-Si 9%	Profile Milling	Ball Nose	1	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	1.5	100-120 HB	15	22000	0.12	0.08	0.006
	Al-Si 9%	Profile Milling	Ball Nose	1.5	100-120 HB	20	25000	0.13	0.09	0.006
	Al-Si 9%	Profile Milling	Ball Nose	1.5	100-120 HB	40	35000	0.15	0.15	0.006
	Al-Si 9%	Profile Milling	Ball Nose	1.5	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	2	100-120 HB	15	22000	0.15	0.05	0.003
	Al-Si 9%	Profile Milling	Ball Nose	2	100-120 HB	20	25000	0.16	0.05	0.003
	Al-Si 9%	Profile Milling	Ball Nose	2	100-120 HB	40	35000	0.2	0.13	0.003
	Al-Si 9%	Profile Milling	Ball Nose	2	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	2.5	100-120 HB	15	22000	0.15	0.05	0.003
	Al-Si 9%	Profile Milling	Ball Nose	2.5	100-120 HB	20	25000	0.16	0.05	0.003
	Al-Si 9%	Profile Milling	Ball Nose	2.5	100-120 HB	40	35000	0.25	0.13	0.003
	Al-Si 9%	Profile Milling	Ball Nose	2.5	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	3	100-120 HB	15	22000	0.22	0.075	0.004
	Al-Si 9%	Profile Milling	Ball Nose	3	100-120 HB	20	25000	0.25	0.075	0.004
	Al-Si 9%	Profile Milling	Ball Nose	3	100-120 HB	40	35000	0.25	0.15	0.004
	Al-Si 9%	Profile Milling	Ball Nose	3	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	4	100-120 HB	15	22000	0.2	0.08	0.006
	Al-Si 9%	Profile Milling	Ball Nose	4	100-120 HB	20	25000	0.25	0.09	0.006
	Al-Si 9%	Profile Milling	Ball Nose	4	100-120 HB	40	35000	0.27	0.15	0.006
	Al-Si 9%	Profile Milling	Ball Nose	4	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	5	100-120 HB	15	22000	0.25	0.075	0.004
	Al-Si 9%	Profile Milling	Ball Nose	5	100-120 HB	20	25000	0.26	0.075	0.004
	Al-Si 9%	Profile Milling	Ball Nose	5	100-120 HB	40	35000	0.28	0.15	0.004
	Al-Si 9%	Profile Milling	Ball Nose	5	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Profile Milling	Ball Nose	6	100-120 HB	15	22000	0.23	0.08	0.006
	Al-Si 9%	Profile Milling	Ball Nose	6	100-120 HB	20	25000	0.25	0.09	0.006
	Al-Si 9%	Profile Milling	Ball Nose	6	100-120 HB	40	35000	0.25	0.15	0.006
	Al-Si 9%	Profile Milling	Ball Nose	6	100-120 HB	70	45000	0.07	0.13	0.012
	Al-Si 9%	Slot Milling	End-Mill	0.5	100-120 HB	15	22000	0.5	0.1	0.007
	Al-Si 9%	Slot Milling	End-Mill	0.5	100-120 HB	20	25000	0.5	0.1	0.007
	Al-Si 9%	Slot Milling	End-Mill	0.5	100-120 HB	40	35000	0.5	0.1	0.007
	Al-Si 9%	Slot Milling	End-Mill	0.5	100-120 HB	70	45000	0.5	0.1	0.007
	Al-Si 9%	Slot Milling	End-Mill	0.8	100-120 HB	15	22000	0.8	0.16	0.008
	Al-Si 9%	Slot Milling	End-Mill	0.8	100-120 HB	20	25000	0.8	0.16	0.008
	Al-Si 9%	Slot Milling	End-Mill	0.8	100-120 HB	40	35000	0.8	0.16	0.008
	Al-Si 9%	Slot Milling	End-Mill	0.8	100-120 HB	70	45000	0.8	0.16	0.007
	Al-Si 9%	Slot Milling	End-Mill	1	100-120 HB	15	22000	1	0.2	0.02
	Al-Si 9%	Slot Milling	End-Mill	1	100-120 HB	20	25000	1	0.2	0.02
	Al-Si 9%	Slot Milling	End-Mill	1	100-120 HB	40	35000	1	0.2	0.02
	Al-Si 9%	Slot Milling	End-Mill	1	100-120 HB	70	45000	1	0.2	0.007
	Al-Si 9%	Slot Milling	End-Mill	1.5	100-120 HB	15	22000	1.5	0.3	0.02
	Al-Si 9%	Slot Milling	End-Mill	1.5	100-120 HB	20	25000	1.5	0.3	0.02
	Al-Si 9%	Slot Milling	End-Mill	1.5	100-120 HB	40	35000	1.5	0.3	0.02
	Al-Si 9%	Slot Milling	End-Mill	1.5	100-120 HB	70	45000	1.5	0.3	0.007
	Al-Si 9%	Slot Milling	End-Mill	2	100-120 HB	15	22000	2	0.4	0.022
	Al-Si 9%	Slot Milling	End-Mill	2	100-120 HB	20	25000	2	0.4	0.022
	Al-Si 9%	Slot Milling	End-Mill	2	100-120 HB	40	35000	2	0.4	0.022
	Al-Si 9%	Slot Milling	End-Mill	2	100-120 HB	70	45000	2	0.4	0.007
Al-Si 9%	Slot Milling	End-Mill	2.5	100-120 HB	15	22000	2.5	0.5	0.025	
Al-Si 9%	Slot Milling	End-Mill	2.5	100-120 HB	20	25000	2.5	0.5	0.025	
Al-Si 9%	Slot Milling	End-Mill	2.5	100-120 HB	40	35000	2.5	0.5	0.025	
Al-Si 9%	Slot Milling	End-Mill	2.5	100-120 HB	70	45000	2.5	0.5	0.007	
Al-Si 9%	Slot Milling	End-Mill	3	100-120 HB	15	22000	3	0.6	0.025	
Al-Si 9%	Slot Milling	End-Mill	3	100-120 HB	20	25000	3	0.6	0.025	
Al-Si 9%	Slot Milling	End-Mill	3	100-120 HB	40	35000	3	0.6	0.025	
Al-Si 9%	Slot Milling	End-Mill	3	100-120 HB	70	45000	3	0.6	0.007	
Al-Si 9%	Slot Milling	End-Mill	3.5	100-120 HB	15	22000	3.5	0.7	0.025	
Al-Si 9%	Slot Milling	End-Mill	3.5	100-120 HB	20	25000	3.5	0.7	0.025	
Al-Si 9%	Slot Milling	End-Mill	3.5	100-120 HB	40	35000	3.5	0.7	0.025	
Al-Si 9%	Slot Milling	End-Mill	3.5	100-120 HB	70	45000	3.5	0.7	0.007	
Al-Si 9%	Slot Milling	End-Mill	4	100-120 HB	15	22000	4	0.8	0.025	
Al-Si 9%	Slot Milling	End-Mill	4	100-120 HB	20	25000	4	0.8	0.025	
Al-Si 9%	Slot Milling	End-Mill	4	100-120 HB	40	35000	4	0.8	0.025	
Al-Si 9%	Slot Milling	End-Mill	4	100-120 HB	70	45000	4	0.8	0.007	
Al-Si 9%	Slot Milling	End-Mill	4.5	100-120 HB	15	22000	4.5	0.9	0.025	

	Material	Process	Type	Cutting Tool dia.	Hardness	Pressure	Speed (n)	Ae (mm)	Ap (mm)	Fz (mm)
N	Al-Si 9%	Slot Milling	End-Mill	4.5	100-120 HB	20	25000	4.5	0.9	0.025
	Al-Si 9%	Slot Milling	End-Mill	4.5	100-120 HB	40	35000	4.5	0.9	0.025
	Al-Si 9%	Slot Milling	End-Mill	4.5	100-120 HB	70	45000	4.5	0.9	0.007
	Al-Si 9%	Slot Milling	End-Mill	5	100-120 HB	15	22000	5	1	0.022
	Al-Si 9%	Slot Milling	End-Mill	5	100-120 HB	20	25000	5	1	0.022
	Al-Si 9%	Slot Milling	End-Mill	5	100-120 HB	40	35000	5	1	0.022
	Al-Si 9%	Slot Milling	End-Mill	5	100-120 HB	70	45000	5	1	0.007
	Al-Si 9%	Slot Milling	End-Mill	5.5	100-120 HB	15	22000	5.5	1.1	0.022
	Al-Si 9%	Slot Milling	End-Mill	5.5	100-120 HB	20	25000	5.5	1.1	0.022
	Al-Si 9%	Slot Milling	End-Mill	5.5	100-120 HB	40	35000	5.5	1.1	0.022
	Al-Si 9%	Slot Milling	End-Mill	5.5	100-120 HB	70	45000	5.5	1.1	0.007
	Al-Si 9%	Slot Milling	End-Mill	6	100-120 HB	15	22000	6	1.2	0.022
	Al-Si 9%	Slot Milling	End-Mill	6	100-120 HB	20	25000	6	1.2	0.022
	Al-Si 9%	Slot Milling	End-Mill	6	100-120 HB	40	35000	6	1.2	0.022
	Al-Si 9%	Slot Milling	End-Mill	6	100-120 HB	70	45000	6	1.2	0.007
	Al-Si 9%	Shoulder Mill	End-Mill	1	100-120 HB	15	22000	0.2	0.1	0.015
	Al-Si 9%	Shoulder Mill	End-Mill	1	100-120 HB	20	25000	0.2	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	1	100-120 HB	40	35000	0.2	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	1	100-120 HB	70	45000	0.2	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	2	100-120 HB	15	22000	0.4	0.1	0.015
	Al-Si 9%	Shoulder Mill	End-Mill	2	100-120 HB	20	25000	0.4	0.1	0.015
	Al-Si 9%	Shoulder Mill	End-Mill	2	100-120 HB	40	35000	0.4	0.1	0.018
	Al-Si 9%	Shoulder Mill	End-Mill	2	100-120 HB	70	45000	0.4	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	3	100-120 HB	15	22000	0.6	0.1	0.02
	Al-Si 9%	Shoulder Mill	End-Mill	3	100-120 HB	20	25000	0.6	0.15	0.02
	Al-Si 9%	Shoulder Mill	End-Mill	3	100-120 HB	40	35000	0.6	0.25	0.025
	Al-Si 9%	Shoulder Mill	End-Mill	3	100-120 HB	70	45000	0.6	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	4	100-120 HB	15	22000	0.8	0.1	0.015
	Al-Si 9%	Shoulder Mill	End-Mill	4	100-120 HB	20	25000	0.8	0.1	0.015
	Al-Si 9%	Shoulder Mill	End-Mill	4	100-120 HB	40	35000	0.8	0.1	0.015
	Al-Si 9%	Shoulder Mill	End-Mill	4	100-120 HB	70	45000	0.8	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	5	100-120 HB	15	22000	1	0.1	0.02
	Al-Si 9%	Shoulder Mill	End-Mill	5	100-120 HB	20	25000	1	0.13	0.02
	Al-Si 9%	Shoulder Mill	End-Mill	5	100-120 HB	40	35000	1	0.15	0.025
	Al-Si 9%	Shoulder Mill	End-Mill	5	100-120 HB	70	45000	1	0.15	0.017
	Al-Si 9%	Shoulder Mill	End-Mill	6	100-120 HB	15	22000	1.2	0.1	0.02
Al-Si 9%	Shoulder Mill	End-Mill	6	100-120 HB	20	25000	0.8	0.1	0.02	
Al-Si 9%	Shoulder Mill	End-Mill	6	100-120 HB	40	35000	1.2	0.1	0.02	
Al-Si 9%	Shoulder Mill	End-Mill	6	100-120 HB	70	45000	1.2	0.15	0.017	

	Material	Process	Type	Cutting Tool dia.	Hardness	Pressure	Speed (n)	Ae (mm)	Ap (mm)	Fz (mm)
H	SAE 1.2316	Drilling	Drill	0.3	35 HRC	15	22000	0.3	0.07	0.002
	SAE 1.2316	Drilling	Drill	0.3	35 HRC	20	25000	0.3	0.07	0.002
	SAE 1.2316	Drilling	Drill	0.3	35 HRC	40	35000	0.3	0.07	0.002
	SAE 1.2316	Drilling	Drill	0.3	35 HRC	70	45000	0.3	0.07	0.006
	SAE 1.2316	Drilling	Drill	0.5	35 HRC	15	22000	0.5	0.1	0.004
	SAE 1.2316	Drilling	Drill	0.5	35 HRC	20	25000	0.5	0.1	0.004
	SAE 1.2316	Drilling	Drill	0.5	35 HRC	40	35000	0.5	0.1	0.004
	SAE 1.2316	Drilling	Drill	0.5	35 HRC	70	45000	0.5	0.07	0.004
	SAE 1.2316	Drilling	Drill	0.8	35 HRC	15	22000	0.8	0.1	0.006
	SAE 1.2316	Drilling	Drill	0.8	35 HRC	20	25000	0.8	0.1	0.006
	SAE 1.2316	Drilling	Drill	0.8	35 HRC	40	35000	0.8	0.1	0.006
	SAE 1.2316	Drilling	Drill	0.8	35 HRC	70	45000	0.8	0.07	0.006
	SAE 1.2316	Drilling	Drill	1	35 HRC	15	22000	1	0.1	0.006
	SAE 1.2316	Drilling	Drill	1	35 HRC	20	25000	1	0.1	0.006
	SAE 1.2316	Drilling	Drill	1	35 HRC	40	35000	1	0.1	0.006
	SAE 1.2316	Drilling	Drill	1	35 HRC	70	45000	1	0.07	0.006
	SAE 1.2316	Drilling	Drill	1.5	35 HRC	15	22000	1.5	0.1	0.006
	SAE 1.2316	Drilling	Drill	1.5	35 HRC	20	25000	1.5	0.1	0.006
	SAE 1.2316	Drilling	Drill	1.5	35 HRC	40	35000	1.5	0.1	0.006
	SAE 1.2316	Drilling	Drill	1.5	35 HRC	70	45000	1.5	0.07	0.006
	SAE 1.2316	Drilling	Drill	2	35 HRC	15	22000	2	0.1	0.01
	SAE 1.2316	Drilling	Drill	2	35 HRC	20	25000	2	0.1	0.01
	SAE 1.2316	Drilling	Drill	2	35 HRC	40	35000	2	0.1	0.01
	SAE 1.2316	Drilling	Drill	2	35 HRC	70	45000	2	0.07	0.006
	SAE 1.2316	Drilling	Drill	2.5	35 HRC	15	22000	2.5	0.1	0.01
	SAE 1.2316	Drilling	Drill	2.5	35 HRC	20	25000	2.5	0.1	0.01
	SAE 1.2316	Drilling	Drill	2.5	35 HRC	40	35000	2.5	0.1	0.01
	SAE 1.2316	Drilling	Drill	2.5	35 HRC	70	45000	2.5	0.07	0.006
	SAE 1.2316	Drilling	Drill	3	35 HRC	15	22000	3	0.1	0.01
	SAE 1.2316	Drilling	Drill	3	35 HRC	20	25000	3	0.1	0.01
	SAE 1.2316	Drilling	Drill	3	35 HRC	40	35000	3	0.1	0.01
	SAE 1.2316	Drilling	Drill	3	35 HRC	70	45000	3	0.07	0.006
	SAE 1.2316	Drilling	Drill	3.5	35 HRC	15	22000	3.5	0.1	0.01
	SAE 1.2316	Drilling	Drill	3.5	35 HRC	20	25000	3.5	0.1	0.01
	SAE 1.2316	Drilling	Drill	3.5	35 HRC	40	35000	3.5	0.1	0.01
	SAE 1.2316	Drilling	Drill	3.5	35 HRC	70	45000	3.5	0.07	0.006
	SAE 1.2316	Profile Milling	Ball Nose	0.3	35 HRC	15	22000	0.03	0.018	0.01
	SAE 1.2316	Profile Milling	Ball Nose	0.3	35 HRC	20	25000	0.03	0.018	0.01
	SAE 1.2316	Profile Milling	Ball Nose	0.3	35 HRC	40	35000	0.03	0.018	0.01
	SAE 1.2316	Profile Milling	Ball Nose	0.3	35 HRC	70	35000	0.03	0.018	0.01
	SAE 1.2316	Profile Milling	Ball Nose	0.5	35 HRC	15	22000	0.05	0.03	0.012
	SAE 1.2316	Profile Milling	Ball Nose	0.5	35 HRC	20	25000	0.05	0.03	0.012
	SAE 1.2316	Profile Milling	Ball Nose	0.5	35 HRC	40	35000	0.05	0.03	0.012
	SAE 1.2316	Profile Milling	Ball Nose	0.5	35 HRC	70	45000	0.05	0.03	0.01
	SAE 1.2316	Profile Milling	Ball Nose	1	35 HRC	15	22000	0.1	0.06	0.012
	SAE 1.2316	Profile Milling	Ball Nose	1	35 HRC	20	25000	0.1	0.06	0.012
	SAE 1.2316	Profile Milling	Ball Nose	1	35 HRC	40	35000	0.1	0.06	0.012
	SAE 1.2316	Profile Milling	Ball Nose	1	35 HRC	70	45000	0.1	0.06	0.01
	SAE 1.2316	Profile Milling	Ball Nose	1.5	35 HRC	15	22000	0.15	0.09	0.012
	SAE 1.2316	Profile Milling	Ball Nose	1.5	35 HRC	20	25000	0.15	0.09	0.012
	SAE 1.2316	Profile Milling	Ball Nose	1.5	35 HRC	40	35000	0.15	0.09	0.012
	SAE 1.2316	Profile Milling	Ball Nose	1.5	35 HRC	70	45000	0.15	0.09	0.01
	SAE 1.2316	Profile Milling	Ball Nose	2	35 HRC	15	22000	0.2	0.12	0.012
	SAE 1.2316	Profile Milling	Ball Nose	2	35 HRC	20	25000	0.2	0.12	0.012
	SAE 1.2316	Profile Milling	Ball Nose	2	35 HRC	40	35000	0.2	0.12	0.012
	SAE 1.2316	Profile Milling	Ball Nose	2	35 HRC	70	45000	0.2	0.12	0.01
	SAE 1.2316	Profile Milling	Ball Nose	2.5	35 HRC	15	22000	0.25	0.15	0.012
	SAE 1.2316	Profile Milling	Ball Nose	2.5	35 HRC	20	25000	0.25	0.15	0.012
	SAE 1.2316	Profile Milling	Ball Nose	2.5	35 HRC	40	35000	0.25	0.15	0.012
	SAE 1.2316	Profile Milling	Ball Nose	2.5	35 HRC	70	45000	0.25	0.15	0.01
	SAE 1.2316	Profile Milling	Ball Nose	3	35 HRC	15	22000	0.3	0.18	0.012
	SAE 1.2316	Profile Milling	Ball Nose	3	35 HRC	20	25000	0.3	0.18	0.012
	SAE 1.2316	Profile Milling	Ball Nose	3	35 HRC	40	35000	0.3	0.18	0.012
	SAE 1.2316	Profile Milling	Ball Nose	3	35 HRC	70	45000	0.3	0.18	0.01
	SAE 1.2316	Profile Milling	Ball Nose	4	35 HRC	15	22000	0.4	0.24	0.012
	SAE 1.2316	Profile Milling	Ball Nose	4	35 HRC	20	25000	0.4	0.24	0.012
	SAE 1.2316	Profile Milling	Ball Nose	4	35 HRC	40	35000	0.4	0.24	0.012
	SAE 1.2316	Profile Milling	Ball Nose	4	35 HRC	70	45000	0.4	0.24	0.01
	SAE 1.2316	Profile Milling	Ball Nose	5	35 HRC	15	22000	0.5	0.3	0.012
	SAE 1.2316	Profile Milling	Ball Nose	5	35 HRC	20	25000	0.5	0.3	0.012
	SAE 1.2316	Profile Milling	Ball Nose	5	35 HRC	40	35000	0.5	0.3	0.012

