

# TOOL SPEED & FEED INFORMATION

SERIES: Z6TW NACO



6 Flute, 45° Profiling End Mill  
Series: Z6TW NACO

MATERIAL	CONDITION	HIGH SPEED MACHINING	STANDARD MACHINING	CUTTING DIAMETER							
				1/8"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"
<b>HARDENED STEELS</b>	<b>ISO-H</b>			<b>CHIP PER TOOTH</b>							
<b>Hardened Steels</b> 55-65 HRc	Profiling $\leq 1.5 \times D$ doc and $.02 \times D$ woc Profiling $\leq 1.5 \times D$ doc and $.04 \times D$ woc	150-180		0.001	0.002	0.002	0.003	0.003	0.004	0.005	0.0060
			60-80	0.001	0.001	0.002	0.002	0.002	0.003	0.003	0.0035
<b>Hardened Steels</b> 65 HRc and above	Profiling $\leq 1.5 \times D$ doc and $.02 \times D$ woc Profiling $\leq 1.5 \times D$ doc and $.04 \times D$ woc	100-130		0.001	0.002	0.002	0.003	0.003	0.003	0.004	0.0045
			40-60	0.001	0.001	0.002	0.002	0.002	0.002	0.003	0.0030

MATERIAL	CONDITION	HIGH SPEED MACHINING	STANDARD MACHINING	CUTTING DIAMETER - METRIC						
				3mm	6mm	8mm	10mm	12mm	16mm	20mm
<b>HARDENED STEELS</b>	<b>ISO-H</b>			<b>CHIP PER TOOTH</b>						
<b>Hardened Steels</b> 55-65 HRc	Profiling $\leq 1.5 \times D$ doc and $.02 \times D$ woc Profiling $\leq 1.5 \times D$ doc and $.04 \times D$ woc	46 - 60 M/MIN		0.0254	0.0508	0.0508	0.0762	0.0762	0.1016	0.1270
			18 - 24 M/MM	0.0254	0.0254	0.0508	0.0508	0.0508	0.0762	0.0762
<b>Hardened Steels</b> 65 HRc and above	Profiling $\leq 1.5 \times D$ doc and $.02 \times D$ woc Profiling $\leq 1.5 \times D$ doc and $.04 \times D$ woc	30 - 40 M/MIN		0.0254	0.0508	0.0508	0.0762	0.0762	0.0762	0.1016
			12 - 18 M/MIN	0.0254	0.0254	0.0508	0.0508	0.0508	0.0508	0.0762

For light periphery profiling  $\leq .005 \times D$   
increase above profiling chip load by 20-35%