

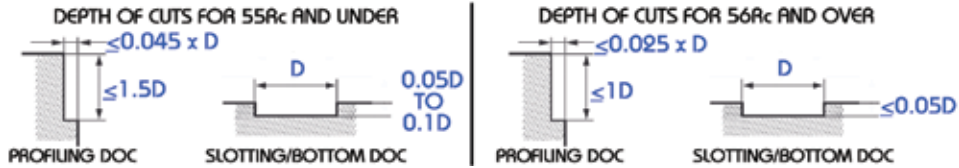
# HARDMILL TECHNICAL DATA

## HARDMILLING RECOMMENDATIONS

RUN HARDMILLS DRY WITH AIR BLAST OR OIL MIST  
HARDMILLS ARE NOT CENTER CUTTING. DO NOT PLUNGE

Material	Tool Steel (-55HRC) AISI H13 ETC		Hardened Steel (55-60HRC) AISI D2 ETC		Hardened Steel (60-65HRC) AISI D2 ETC	
	SFM	Chip Load (inch per tooth)	SFM	Chip Load (inch per tooth)	SFM	Chip Load (inch per tooth)
1/8 & 5/32	250 - 900	.0007 - .001	200 - 500	.0007 - .001	150 - 325	.0006 - .0008
3/16	250 - 900	.001 - .0015	200 - 500	.001 - .0015	150 - 325	.001 - .0014
1/4	250 - 800	.002 - .0025	200 - 500	.002 - .0025	150 - 300	.002 - .0024
5/16	250 - 800	.0025 - .003	250 - 500	.0025 - .003	150 - 250	.0020 - .003
3/8 & 1/2	300 - 850	.0030 - .004	300 - 500	.0030 - .004	150 - 250	.0030 - .004
5/8 & 3/4	350 - 800	.0030 - .004	350 - 500	.0030 - .004	150 - 250	.0030 - .004

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Tolerance – Diameter: +.000/-.002 Shank: -.0001/-.0003 Made from Submicrograin Carbide