

Speed & Feed Guide

Series 2150

HXM | Multi Flute | Square | Metrix

Work Material		M	S2
		316L, X2CrNiMo	Ti6Al4V, ASTM B348
m/min		20 - 40	15 - 35
Depth of Cut		Axial: 0.5 X D Radial:0.1 X D	
Torx type	Diameter (mm)	mm/rev	mm/rev
T4	0.9	0.001 - 0.0015	0.001 - 0.0015
T5	1.0	0.0015 - 0.0025	0.0015 - 0.0025
T6	1.2	0.0025 - 0.0030	0.0025 - 0.0030
T7	1.4	0.0025 - 0.0030	0.0025 - 0.0030
T8	1.6	0.0030 - 0.0045	0.0030 - 0.0045
T10	1.9	0.0050 - 0.0060	0.0050 - 0.0060
T15	2.3	0.0050 - 0.0060	0.0050 - 0.0060
T20	2.7	0.0055 - 0.0065	0.0055 - 0.0065
T25	3.1	0.0073 - 0.0080	0.0073 - 0.0080
T30	3.8	0.0080 - 0.0100	0.0080 - 0.0100

*Helical interpolation only recommended in Titanium Alloys. For helical interpolation, reduce feed by 50-60%. Recommended pitch for helical interpolation = 0.2 to 0.4 X D