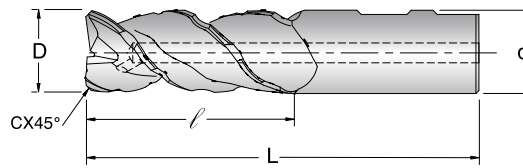


## LIST RPM

**High Speed  
Machining of Aluminium**

**Directional coolant holes**

**Polished Flutes  
PM Super Cobalt**



**Usinage Grande  
Vitesse de L'Aluminium**

**Trous d'arrosage  
directionnels**

**Goujures Polies  
Acier fritté Super Cobalt**

**Para Fresar el Aluminio  
a Alta Velocidad**

**Agujeros de  
lubrificaciòn dirigidos**

**Cuchillos Pulidos  
Acero Sinterizado  
Super Cobalto**

**Zum Aluminiumfräsen mit  
hohen Umdrehungen**

**mit Innenkühlung**

**Polierte Schneiden  
Pulverisierten Stahl  
Super Kobalt**

**Alta Velocita' per  
Lavorazione di Alluminio**

**Fori di refrigerazione  
direzionali**

**Taglienti Lucidati  
Acciaio Sinterizzato  
Super Cobalto**

TOOL NO.	D	d	l	L	Z	Uncoated EDP NO.	TiCN EDP NO.
RPM-1016	10	10	16	66	3	29000	29125
RPM-1022	10	10	22	72	3	29005	29130
RPM-1226	12	12	26	83	3	29010	29135
RPM-1253	12	12	53	110	3	29015	29140
RPM-1426	14	12	26	83	3	29020	29145
RPM-1453	14	12	53	110	3	29025	29150
RPM-1632	16	16	32	92	3	29030	29155
RPM-1663	16	16	63	123	3	29035	29160
RPM-1832	18	16	32	92	3	29040	29165
RPM-1863	18	16	63	123	3	29045	29170
RPM-2038	20	20	38	104	3	29050	29175
RPM-2056	20	20	56	122	3	29055	29180
RPM-2075	20	20	75	141	3	29060	29185
RPM-2545	25	45	25	121	3	29065	29190
RPM-2563	25	25	63	139	3	29070	29195
RPM-2590	25	25	90	166	3	29075	29200
RPM-3253	32	32	53	133	3	29080	29205
RPM-3275	32	32	75	155	3	29085	29210
RPM-3210	32	32	106	186	3	29090	29215
RPM-4056-32	40	32	56	136	3	29095	29220
RPM-4075-32	40	32	75	155	3	29100	29225
RPM-4010-32	40	32	106	186	3	29105	29230
RPM-5050-32	50	32	50	152	3	29110	29235
RPM-5075-32	50	32	75	177	3	29115	29240
RPM-5075	50	50	75	177	3	29120	29245

**Suggested feeds and speeds for HSM – slotting operation**

**Vitesse de coupe et avances pour UGV – operation rainurage**

**Velocidades y avances para alta velocidad – operaciòn de ranurados**

**Empfohlene schneid-und vorschubgeschwindigkeiten – nutenfräs arbeitsvorgang**

**Velocita' di taglio e avanzamenti per alta velocita' – operazione scannelatura**

DIA (mm)	n (RPM)	$V_t$ (SMM)	c (mm/tooth)	$f_n$ (mm/min)	Q cm <sub>3</sub> /min
10	22000	691	0.038	2500	250
12	21200	799	0.051	3230	465
14	20550	903	0.063	3888	762
16	19900	1000	0.076	4547	1164
18	17900	1012	0.082	4394	1424
20	15900	999	0.089	4240	1696
25	12730	999	0.102	3880	2425
32	9950	1000	0.127	3790	3881
40	7950	999	0.151	3600	5760
50	6400	1005	0.164	3155	7888