



CHAMFER MILL

Chamfer Mill Cutting Data

HaasTooling.com

Haas Chamfer Tools

How To Use This Chart:

- 1) Select your material in the colored ISO chart.
- 2) Select your Cutting Diameter in the columns.
- 3) Start with the middle range of the recommended sfm (vc) and feed (ipt)
-Adjust the sfm and/or feedrate based on your cutting conditions.

ISO	VDI 3323	Material Description		Insert Grade HU30	ØD (Ø0.20~Ø0.79) (INCH)	ØD (Ø0.10~Ø1.38) (INCH)
P	P1-9	Low / Non-alloy steel	●	Cutting Speed (vc = sfm)	620 - 1010	620 - 1010
				Feed (fz = ipt)	0.002 - 0.010	0.002 - 0.010
M	M12-14	Stainless steel	●	Cutting Speed (vc = sfm)	330 - 520	330 - 520
				Feed (fz = ipt)	0.002 - 0.008	0.002 - 0.008
K	K15-20	Grey cast iron	●	Cutting Speed (vc = sfm)	360 - 590	360 - 590
				Feed (fz = ipt)	0.004 - 0.012	0.004 - 0.012
N	N21-28	Non-ferrous metals	○	Cutting Speed (vc = sfm)	490 - 1150	490 - 1150
				Feed (fz = ipt)	0.008 - 0.016	0.008 - 0.016

● Optimal ○ Secondary