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Speeds and Feeds for 45° Indexable F45SE12 and E45SE12

Aluminums

SFPM 500-1100 for 6000 series alloys use flood coolant

SFPM 400-800 for 7000 series alloys use flood coolant

Insert SEHT1204AFFN-X83 for fine finishing .004-.01 IPT

Insert SEHT1204AFN-K68 for semi finishing and medium roughing .005-.013 IPT

Insert SEHW1204AFN-K68 for roughing .005-.014 IPT

Steels

Run dry or air blast

SFPM 300-600 for medium to low carbon steels

SFPM 200-500 for high carbon steels

Insert SEHW1204AFTN ACP200 for low to high carbon steels .004-.008 IPT

Stainless Steels

Use air with mist or flood coolant

SFPM 250-500

Insert SEHW1204AFTN ACK300 .004-.008 IPT

Cutting speeds, feeds, and lubrication data are given as starting values only. Parameters should be adjusted to suite your particular and unique application. Cutting tools may shatter and or create dangerous fumes when being used. Appropriate protection is advised.