STELLRAM

Solid Carbide
Rapide End Mill

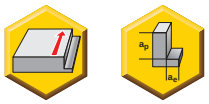
Recommended Feeds

Rapide High Performance / High Speed End Mills

HPA Feeds f_z (mm/tooth) - Slotting / Pocketing

D	Unalloyed Steel <600 N/mm² <180 HBN	Unalloyed Steel 700-950N/mm² 200-280 HBN	Alloyed Steel <600 N/mm² <180 HBN	Alloyed Steel 950-1200N/mm² 280-355 HBN	Alloyed Steel 1200-1400N/mm² 355-415 HBN	Stainless Steel Austenitic + Ferretic 300 Series	Stainless Steel Martensitic 400 Series	Stainless Steel Refractory PH	Cast Irons Grey GG-FT	Cast Irons Spheroidal- Ductile GGG-FGS	Cast Irons Malleable GTS -MN/MP	Aluminium & Alloys <16% Si 116 HBN	Aluminium & Silicon >16% Si 92 HBN	HTA Iron Based Alloys	HTA Cobalt Based Alloys	HTA Nickel Based Alloys	HTA Titanium Based Alloys	Hard Steel >1400 N/mm² >415 HBN	Chilled Cast Iron >1400 N/mm² >400 HBN
Range	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.	Min. - Max.
3,0	-	-	-	-	-	-	-	-	-	-	-	0,017 0,031	0,017 0,027	-	-	-	-	-	-
4,0	-	-	-	-	-	-	-	-	-	-	-	0,022 0,043	0,022 0,037	-	-	-	-	-	-
5,0	-	-	-	-	-	-	-	-	-	-	-	0,027 0,057	0,027 0,049	-	-	-	-	-	-
6,0	-	-	-	-	-	-	-	-	-	-	-	0,032 0,071	0,032 0,061	-	-	-	-	-	-
8,0	-	-	-	-	-	-	-	-	-	-	-	0,042 0,102	0,042 0,087	-	-	-	-	-	-
10,0	-	-	-	-	-	-	-	-	-	-	-	0,051 0,135	0,051 0,114	-	-	-	-	-	-
12,0	-	-	-	-	-	-	-	-	-	-	-	0,060 0,169	0,060 0,142	-	-	-	-	-	-
16,0	-	-	-	-	-	-	-	-	-	-	-	0,078 0,242	0,078 0,202	-	-	-	-	-	-
20,0	-	-	-	-	-	-	-	-	-	-	-	0,095 0,320	0,095 0,266	-	-	-	-	-	-

Note: HTA = High Temperature Alloys

Shoulder Milling / Profiling	Feed Correction Parameters	
	a_e	Correction Factor
	0,05 D	2,30 x f_z
	0,10 D	1,65 x f_z
	0,15 D	1,40 x f_z
	0,20 D	1,25 x f_z
	0,30 D	1,09 x f_z

For a_e less than a_e max, use correction factors stated above.
For a_e max, use feeds stated above.