











# SELECTION GUIDE

# i-Smart MODULAR CARBIDE HEAD END MILLS

ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
<b>XGMF15</b>		CARBIDE MODULAR HEAD, 2 FLUTE BALL NOSE	R3/16	R5/8	<b>616</b>
<b>XGMF17</b>		CARBIDE MODULAR HEAD, 4 FLUTE BALL NOSE	R3/16	R5/8	<b>617</b>
<b>XGMF20</b>		CARBIDE MODULAR HEAD, 4 FLUTE MULTIPLE HELIX CORNER RADIUS	D3/8	D1-1/4	<b>618</b>
<b>XGMF25</b>		CARBIDE MODULAR HEAD, 4 FLUTE MULTIPLE HELIX	D3/8	D1-1/4	<b>619</b>
<b>XGMF29</b>		CARBIDE MODULAR HEAD, 6 FLUTE 45° HELIX	D3/8	D1-1/4	<b>620</b>
<b>ZMC</b>		CARBIDE HOLDER, STRAIGHT NECK TYPE			<b>621</b>
<b>ZMS</b>		STEEL HOLDER, STRAIGHT NECK TYPE			<b>622</b>
<b>ZMT</b>		STEEL HOLDER, TAPER NECK TYPE			<b>623</b>
RECOMMENDED CUTTING CONDITIONS					<b>624</b>

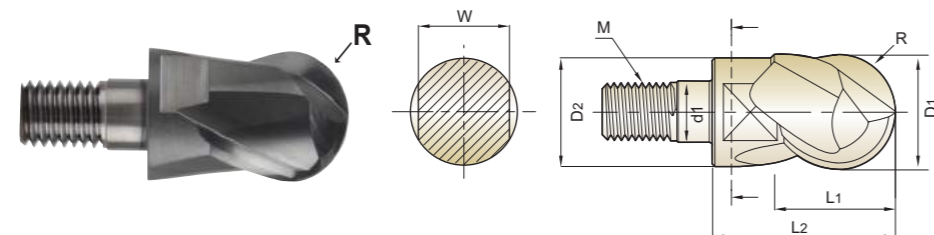
◎ : Excellent ○ : Good

P					H	M	K	N					S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70									
○	◎	◎	◎	○			○							
○	◎	◎	◎	○			○							
◎	◎	◎	◎	○			○							
◎	◎	◎	◎	○		○	○							
◎	◎	◎	◎	○			○							



**XGMF15** SERIES

**CARBIDE MODULAR HEAD, 2 FLUTE BALL NOSE**



Unit: Inch

EDP No.	Radius of Ball Nose	Mill Diameter	Neck Diameter	Length of Cut	Length Below Shank	Coupling Diameter	Wrench Width	Thread	Wrench
	R	D1	D2	L1	L2	d1	W	M	
XGMF15024	R3/16	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF15032	R1/4	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF15040	R5/16	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF15048	R3/8	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF15100	R1/2	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF15116	R5/8	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700

Radius Tolerance(Inch)	Mill Dia. Tolerance(Inch)
±.0004	0--.0008

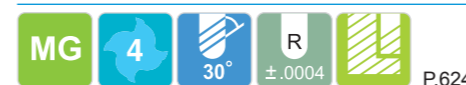
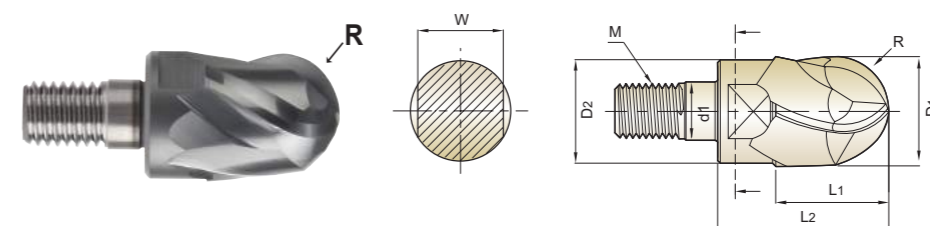
◎ : Excellent ○ : Good

P					H	M	K	N					S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70									
○	◎	◎	◎	○			○							



**XGMF17** SERIES

**CARBIDE MODULAR HEAD, 4 FLUTE BALL NOSE**



Unit: Inch

EDP No.	Radius of Ball Nose	Mill Diameter	Neck Diameter	Length of Cut	Length Below Shank	Coupling Diameter	Wrench Width	Thread	Wrench
	R	D1	D2	L1	L2	d1	W	M	
XGMF17024	R3/16	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF17032	R1/4	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF17040	R5/16	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF17048	R3/8	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF17100	R1/2	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF17116	R5/8	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700

Radius Tolerance(Inch)	Mill Dia. Tolerance(Inch)
±.0004	0--.0008

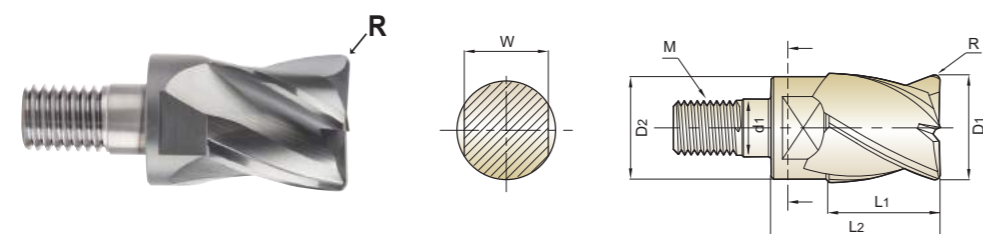
◎ : Excellent ○ : Good

P					H	M	K	N					S	
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70									
○	◎	◎	◎	○			○							



XGMF20 SERIES

CARBIDE MODULAR HEAD, 4 FLUTE MULTIPLE HELIX CORNER RADIUS



Unit: Inch

EDP No.	Corner Radius	Mill Diameter	Neck Diameter	Length of Cut	Length Below Shank	Coupling Diameter	Wrench Width	Thread	Wrench
	R	D1	D2	L1	L2	d1	W	M	
XGMF20024 012	R.012	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20024 020	R.020	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20024 030	R.030	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20024 040	R.040	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20024 050	R.050	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20024 060	R.060	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20024 080	R.080	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF20032 020	R.020	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF20032 030	R.030	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF20032 040	R.040	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF20032 060	R.060	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF20032 080	R.080	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF20040 020	R.020	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF20040 030	R.030	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF20040 040	R.040	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF20040 060	R.060	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF20040 080	R.080	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF20048 030	R.030	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF20048 040	R.040	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF20048 080	R.080	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF20100 030	R.030	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF20100 040	R.040	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF20100 080	R.080	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF20116 030	R.030	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700
XGMF20116 040	R.040	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700
XGMF20116 080	R.080	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700

Corner Radius Tolerance(Inch)	Mill Dia. Tolerance(Inch)
±.0008	0~-.0012

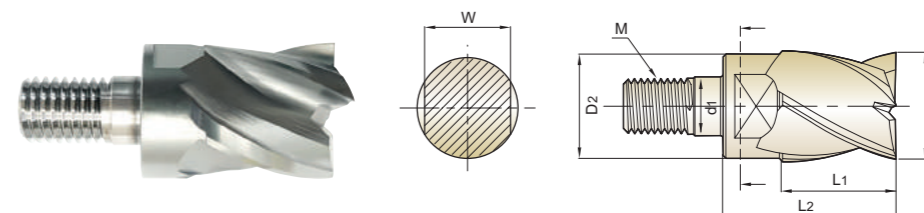
◎ : Excellent ○ : Good

P				H	M	K	N						S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70									
◎	◎	◎	○			○							



XGMF25 SERIES

CARBIDE MODULAR HEAD, 4 FLUTE MULTIPLE HELIX



Unit: Inch

EDP No.	Mill Diameter	Neck Diameter	Length of Cut	Length Below Shank	Coupling Diameter	Wrench Width	Thread	Wrench
	D1	D2	L1	L2	d1	W	M	
XGMF25024	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF25032	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF25040	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF25048	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF25100	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF25116	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700

Mill Dia. Tolerance(Inch)
0~-.0012

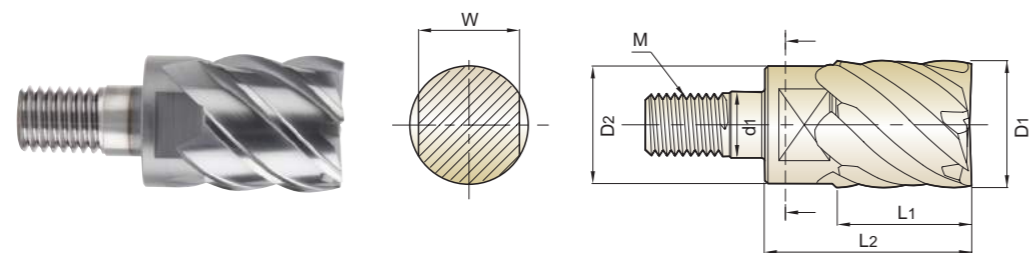
◎ : Excellent ○ : Good

P				H	M	K	N						S
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRc30~40	HRc40~45 HRc45~55	HRc55~70									
◎	◎	◎	◎	○		○							



XGMF29 SERIES

CARBIDE MODULAR HEAD, 6 FLUTE 45° HELIX



Unit: Inch

EDP No.	Mill Diameter	Neck Diameter	Length of Cut	Length Below Shank	Coupling Diameter	Wrench Width	Thread	Wrench
	D1	D2	L1	L2	d1	W	M	
XGMF29024	3/8	.351	3/8	.689	.256	.315	M6	SPIS0810
XGMF29032	1/2	.469	1/2	.835	.256	.394	M6	SPIS0810
XGMF29040	5/8	.591	5/8	1.004	.335	.512	M8	SPIS1300
XGMF29048	3/4	.711	3/4	1.144	.413	.669	M10	SPIS1700
XGMF29100	1	.961	1	1.472	.492	.866	M12	SPIS2200
XGMF29116	1-1/4	1.221	1-1/4	1.772	.669	1.063	M16	SPIS2700

Mill Dia. Tolerance(Inch)
0~- .0012

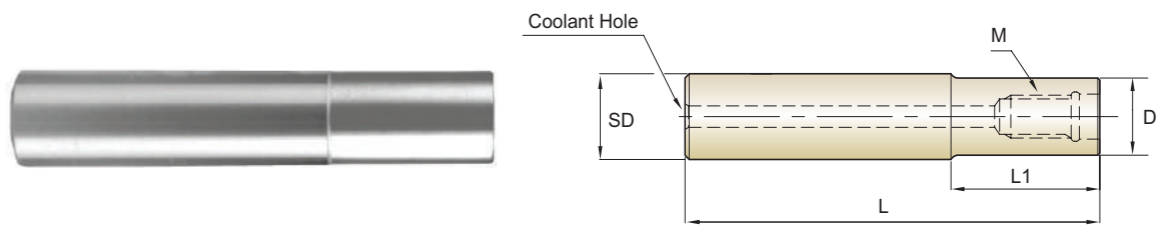
◎ : Excellent ○ : Good

P				H	M	K	N				S		
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels	High Hardened Steels	Stainless Steels	Cast Iron	Copper	Graphite	Aluminum	Acrylic	CFRP	Titanium	High Temperature Alloy
~HB225	HB225~325	HRC30~40	HRC40~45 HRC45~55	HRC55~70									
○	◎	◎	◎	○		○							



ZMC SERIES

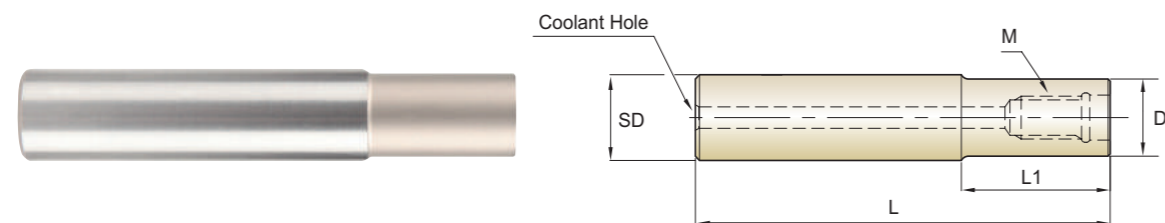
CARBIDE HOLDER, STRAIGHT NECK TYPE



Unit: Inch

EDP No.	Mill Diameter	Shank Diameter	Overall Length	Neck Length	Neck Diameter	Thread Size	Wrench No.	Coolant Hole
		SD	L	L1	D	M		
ZMC024A024	3/8	3/8	2-3/4	25/32	23/64	M6	SPIS0810	5/64
ZMC024B024			3-15/16	1-37/64				
ZMC024C024			5-1/8	2-3/4				
ZMC032A032	1/2	1/2	3-1/8	25/32	29/64	M6	SPIS0810	5/64
ZMC032B032			3-15/16	1-37/64				
ZMC032C032			5-1/8	2-3/4				
ZMC040A040	5/8	5/8	3-15/16	1-37/64	19/32	M8	SPIS1300	1/8
ZMC040B040			5-7/8	3-5/32				
ZMC040C040			7-7/8	4-23/32				
ZMC048A048	3/4	3/4	3-15/16	1-37/64	45/64	M10	SPIS1700	5/32
ZMC048B048			5-7/8	3-5/32				
ZMC048C048			7-7/8	4-23/32				
ZMC048D048			9-13/16	6-19/64				
ZMC100A100	1	1	5-7/8	2-3/4	61/64	M12	SPIS2200	13/64
ZMC100B100			7-7/8	3-15/16				
ZMC100C100			9-13/16	5-29/32				
ZMC100D100			11-13/16	7-7/8				
ZMC116A116	1-1/4	1-1/4	5-7/8	2-3/4	1-9/64	M16	SPIS2700	15/64
ZMC116B116			7-7/8	4-23/32				
ZMC116C116			9-13/16	5-29/32				
ZMC116D116			11-13/16	7-7/8				
ZMC116E116			13-3/4	9-27/32				

**STEEL HOLDER, STRAIGHT NECK TYPE**



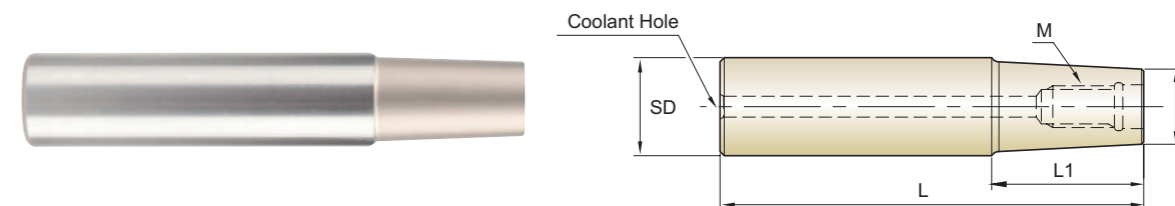
Unit: Inch

EDP No.	Mill Diameter	Shank Diameter	Overall Length	Neck Length	Neck Diameter	Thread Size	Coolant Hole
		SD					
ZMS024A024	3/8	3/8	2-3/4	25/32	23/64	M6	1/8
ZMS032A032	1/2	1/2	3-35/64	1-3/16	29/64	M6	1/8
ZMS040A040	5/8	5/8	3-15/16	1-3/16	19/32	M8	5/32
ZMS048A048	3/4	3/4	3-15/16	1-3/16	45/64	M10	13/64
ZMS100A100	1	1	4-17/32	1-37/64	61/64	M12	13/64
ZMS116A116	1-1/4	1-1/4	4-59/64	1-37/64	1-9/64	M16	15/64

**Wrench**

Model	Wrench No.	Wrench Width	Mill Diameter	Clamping Torque [in·lbs]
	SPIS0810	.315	3/8	57.6
		.394	1/2	57.6
	SPIS1300	.512	5/8	88.6
	SPIS1700	.669	3/4	106.3
	SPIS2200	.866	1	132.9
	SPIS2700	1.063	1-1/4	177.1

**STEEL HOLDER, TAPER NECK TYPE**



Unit: Inch

EDP No.	Mill Diameter	Shank Diameter	Overall Length	Neck Length	Neck Diameter	Thread Size	Coolant Hole
		SD					
ZMT024A032	3/8	1/2	3-15/16	1-31/32	23/64	M6	1/8
ZMT032A040	1/2	5/8	5-1/8	2-3/4	29/64	M6	1/8
ZMT040A048	5/8	3/4	5-29/32	3-35/64	19/32	M8	5/32
ZMT048A100	3/4	1	6-11/16	3-15/16	45/64	M10	13/64
ZMT100A116	1	1-1/4	7-7/8	4-21/64	61/64	M12	13/64
ZMT116A116	1-1/4	1-1/4	7-7/8	4-21/64	1-9/64	M16	15/64

**Wrench**

Model	Wrench No.	Wrench Width	Mill Diameter	Clamping Torque [in·lbs]
	SPIS0810	.315	3/8	57.6
		.394	1/2	57.6
	SPIS1300	.512	5/8	88.6
	SPIS1700	.669	3/4	106.3
	SPIS2200	.866	1	132.9
	SPIS2700	1.063	1-1/4	177.1

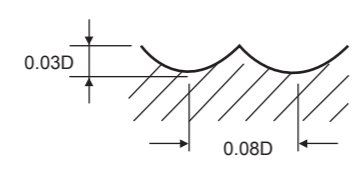


RECOMMENDED CUTTING CONDITIONS

CARBIDE MODULAR HEAD, 2 FLUTE BALL NOSE

XGMF15 SERIES

MATERIAL	P											
	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRC35				HRC35~ HRC45				HRC45~ HRC55			
STRENGTH	~ 1100N/mm <sup>2</sup>				1110 ~ 1500N/mm <sup>2</sup>				1500 ~ 2000N/mm <sup>2</sup>			
DIAMETER	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz
R3/16 x3/8	5860	91.7	575	.008	5610	77.0	551	.007	4720	59.5	463	.006
R1/4 x1/2	4200	65.8	550	.008	4050	55.7	530	.007	3390	42.3	444	.006
R5/16 x5/8	3370	63.2	551	.009	3240	52.4	530	.008	2720	40.6	445	.007
R3/8 x3/4	2800	58.3	550	.010	2710	48.4	532	.009	2270	37.2	446	.008
R1/2 x1	2100	46.5	550	.011	2020	42.5	529	.011	1700	32.5	445	.010
R1-1/8x1-1/4	1680	38.0	550	.011	1620	36.5	530	.011	1360	28.5	445	.010

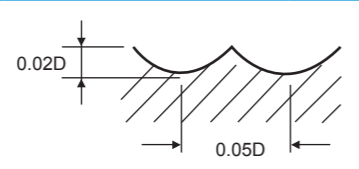


RPM = rev./min. FEED = inch/min.  
Vc = ft/min. fz = inch/tooth

CARBIDE MODULAR HEAD, 4 FLUTE BALL NOSE

XGMF17 SERIES

MATERIAL	P											
	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRC35				HRC35~ HRC45				HRC45~ HRC55			
STRENGTH	~ 1100N/mm <sup>2</sup>				1110 ~ 1500N/mm <sup>2</sup>				1500 ~ 2000N/mm <sup>2</sup>			
DIAMETER	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz
R3/16 x3/8	9600	189.8	942	.005	7720	142.5	758	.005	6990	118.7	686	.004
R1/4 x1/2	7200	158.5	942	.006	5790	118.7	758	.005	5230	89.4	685	.004
R5/16 x5/8	5760	138.2	942	.006	4630	92.6	758	.005	4180	66.9	684	.004
R3/8 x3/4	4800	134.4	942	.007	3860	92.6	758	.006	3480	69.6	683	.005
R1/2 x1	3600	115.2	942	.008	2890	69.4	757	.006	2610	52.2	683	.005
R1-1/8x1-1/4	2880	103.7	942	.009	2310	64.7	756	.007	2090	50.2	684	.006



RPM = rev./min. FEED = inch/min.  
Vc = ft/min. fz = inch/tooth

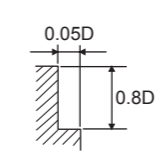


RECOMMENDED CUTTING CONDITIONS

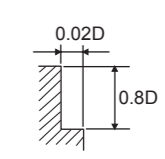
CARBIDE MODULAR HEAD, 4 FLUTE MULTIPLE HELIX  
CORNER RADIUS

XGMF20 SERIES

MATERIAL	P											
	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRC35				HRC35~ HRC45				HRC45~ HRC55			
STRENGTH	~ 1100N/mm <sup>2</sup>				1110 ~ 1500N/mm <sup>2</sup>				1500 ~ 2000N/mm <sup>2</sup>			
DIAMETER	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz
3/8	5300	19.1	520	.001	3440	15	338	.001	2120	7.1	208	.001
1/2	3900	13.4	511	.001	2630	11.8	344	.001	1590	5.1	208	.001
5/8	3100	11.0	507	.001	2120	9.1	347	.001	1290	4.5	211	.001
3/4	2600	9.5	511	.001	1720	7.5	338	.001	1050	3.7	206	.001
1	1950	11.7	511	.002	1290	7.7	338	.002	780	4.7	204	.002
1-1/4	1560	9.4	511	.002	1030	6.2	337	.002	620	3.7	203	.002



\* 1.5xD Axial cutting depth should be for DIA over 5/8inch

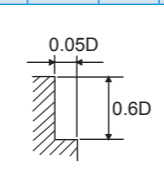


RPM = rev./min. FEED = inch/min.  
Vc = ft/min. fz = inch/tooth

CARBIDE MODULAR HEAD, 4 FLUTE MULTIPLE HELIX

XGMF25 SERIES

MATERIAL	P												M			
	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS				STAINLESS STEELS			
HARDNESS	~ HRC35				HRC35~ HRC45				HRC45~ HRC55							
STRENGTH	~ 1100N/mm <sup>2</sup>				1110 ~ 1500N/mm <sup>2</sup>				1500 ~ 2000N/mm <sup>2</sup>							
DIAMETER	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz
3/8	4280	26.5	420	.002	2620	13	257	.001	1780	3.9	175	.001	2200	13	216	.001
1/2	3240	20.7	424	.002	1980	9.9	259	.001	1370	3.2	179	.001	1610	9.5	211	.001
5/8	2770	17.6	453	.002	1710	8.5	280	.001	1140	2.5	187	.001	1390	8.3	227	.001
3/4	2200	13.9	432	.002	1400	7	275	.001	890	1.8	175	.001	1100	6.4	216	.001
1	1650	16.5	432	.003	1050	6.3	275	.002	680	1.6	178	.001	820	4.9	215	.002
1-1/4	1320	13.2	432	.003	835	5.0	273	.002	530	1.5	173	.001	655	3.9	214	.002



RPM = rev./min. FEED = inch/min.  
Vc = ft/min. fz = inch/tooth



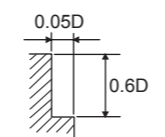
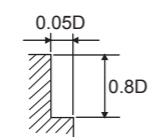
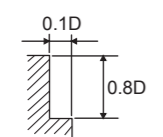
RECOMMENDED CUTTING CONDITIONS

CARBIDE MODULAR HEAD, 6 FLUTE 45° HELIX

XGMF29 SERIES

NORMAL SPEED

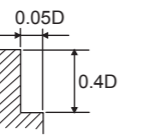
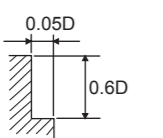
MATERIAL	P											
	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				ALLOY STEELS HEAT RESISTANT STEELS				HARDENED STEELS			
HARDNESS	~ HRC35				HRC35~ HRC45				HRC45~ HRC55			
STRENGTH	~ 1100N/mm <sup>2</sup>				1110 ~ 1500N/mm <sup>2</sup>				1500 ~ 2000N/mm <sup>2</sup>			
DIAMETER	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz
3/8	3705	86.8	364	.004	2560	59.5	251	.004	1105	9.1	108	.001
1/2	2780	58.5	364	.004	1950	40.7	255	.003	840	6.3	110	.001
5/8	2225	44.7	364	.003	1565	31.2	256	.003	670	4.6	110	.001
3/4	1850	37.2	363	.003	1280	25.4	251	.003	545	4.1	107	.001
1	1390	33.4	364	.004	960	23.0	251	.004	420	3.8	110	.002
1-1/4	1110	26.6	363	.004	770	18.5	252	.004	330	3.0	108	.002



RPM = rev./min.  
FEED = inch/min.  
Vc = ft/min.  
fz = inch/tooth

HIGH SPEED

MATERIAL	P							
	NON-ALLOYED STEELS ALLOY STEELS CAST IRON				HARDENED STEELS			
HARDNESS	~ HRC50				HRC50~ HRC60			
STRENGTH	1750N/mm <sup>2</sup>				1750 ~ 2080N/mm <sup>2</sup>			
DIAMETER	RPM	Feed (IPM)	Vc (SFM)	fz	RPM	Feed (IPM)	Vc (SFM)	fz
3/8	11005	260.0	1080	.004	5555	132.3	545	.004
1/2	8330	175.4	1090	.004	4180	87.7	547	.003
5/8	6670	133.9	1091	.003	3340	67.0	547	.003
3/4	5555	112.4	1091	.003	2785	54.2	547	.003
1	4165	100.0	1090	.004	2090	50.2	547	.004
1-1/4	3330	79.9	1090	.004	1670	40.1	547	.004



RPM = rev./min.  
FEED = inch/min.  
Vc = ft/min.  
fz = inch/tooth

