

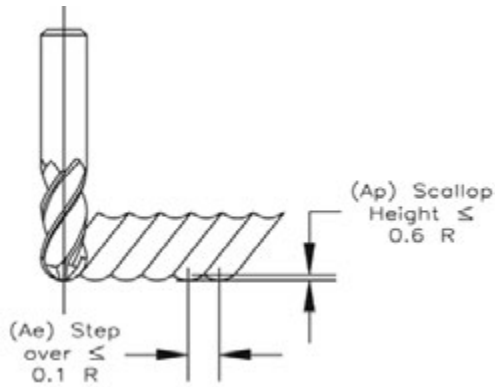
# TuffCut® XT

## 279 Recommended Cutting Data - Contouring

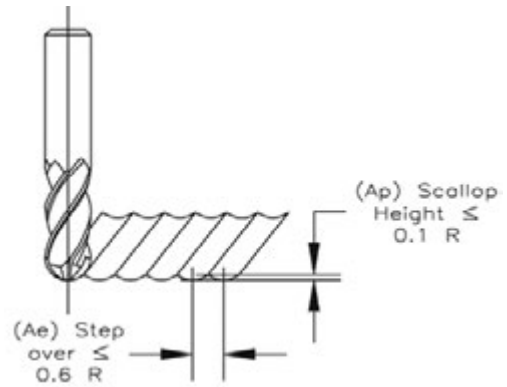
**Inch** See pages 324-327 for profile milling and slotting data.

Semi Roughing / Roughing (25 - 48 Rc)						
Diameter	Decimal	Radius	Sfm	in/tooth Range	Max	
					Ae	Ap
1/8	0.1250	0.063	820	.0008 - .0012	0.006	0.035
3/16	0.1875	0.094	1020	.0010 - .0017	0.009	0.053
1/4	0.2500	0.125	1235	.0010 - .0027	0.012	0.071
5/16	0.3125	0.156	1235	.0014 - .0032	0.016	0.094
3/8	0.3750	0.188	1235	.0018 - .0037	0.020	0.118
1/2	0.5000	0.250	1235	.0018 - .0040	0.024	0.142
5/8	0.6250	0.313	1235	.0020 - .0041	0.032	0.189
3/4	0.7500	0.375	1235	.0025 - .0045	0.038	0.225

Semi Finishing / Finishing (25 - 48 Rc)						
Diameter	Decimal	Radius	Sfm	in/tooth Range	Max	
					Ae	Ap
1/8	0.125	0.063	820	.0008 - .0012	0.035	0.006
3/16	0.187	0.094	1020	.0010 - .0017	0.053	0.009
1/4	0.25	0.125	1235	.0010 - .0027	0.07	0.012
5/16	0.3125	0.156	1235	.0014 - .0032	0.094	0.016
3/8	0.375	0.188	1235	.0018 - .0037	0.118	0.02
1/2	0.5	0.25	1235	.0018 - .0040	0.141	0.024
5/8	0.625	0.312	1235	.0020 - .0041	0.188	0.031
3/4	0.75	0.375	1235	.0025 - .0045	0.225	0.0375



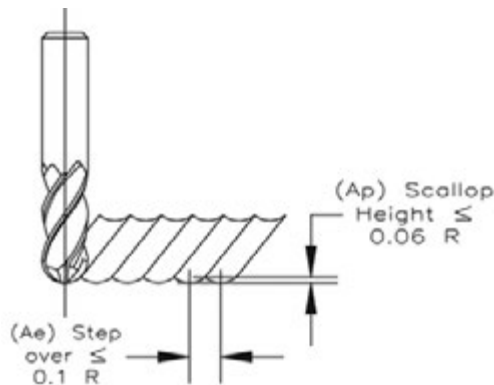
Coolant: High Pressure Air Blast



Coolant: High Pressure Air Blast

Titanium				
Diameter	Decimal	Radius	Sfm	In/tooth
1/8	0.125	0.063	500	0.0011
3/16	0.187	0.094	500	0.0015
1/4	0.25	0.125	500	0.0018
5/16	0.3125	0.156	500	0.0026
3/8	0.375	0.188	500	0.0031
1/2	0.5	0.25	500	0.0036
5/8	0.625	0.312	500	0.0039
3/4	0.75	0.375	500	0.0041

Titanium				
Diameter	Decimal	Radius	Sfm	In/tooth
1/8	0.125	0.063	150	0.0011
3/16	0.187	0.094	150	0.0015
1/4	0.25	0.125	150	0.0018
5/16	0.3125	0.156	150	0.0026
3/8	0.375	0.188	150	0.0031
1/2	0.5	0.25	150	0.0036
5/8	0.625	0.312	150	0.0039
3/4	0.75	0.375	150	0.0041



Coolant: High Pressure Air Blast

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

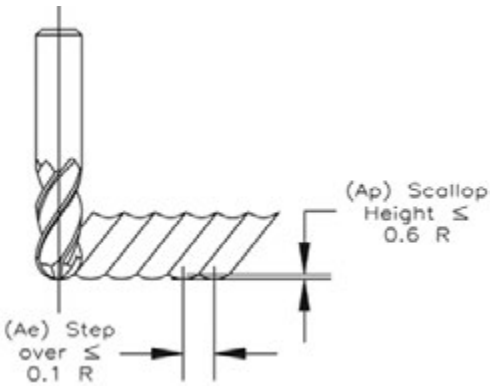
# TuffCut® XT

## 279 Recommended Cutting Data - Contouring

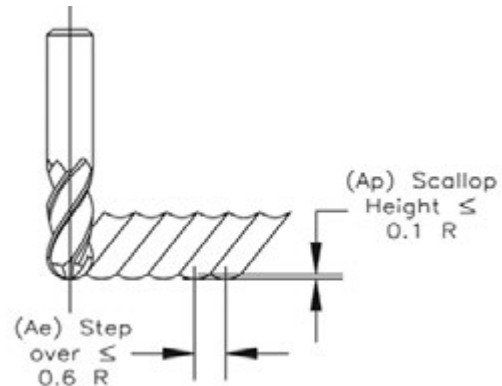
**Metric** See pages 324-327 for profile milling and slotting data.

Semi Roughing / Roughing (25 - 48 Rc)					
Diameter	Radius	meters/min	mm/tooth range	Max	Max
				Ae	Ap
3	1.5	250	.020 - .030	0.15	0.9
4	2	290	.025 - .040	0.2	1.2
5	2.5	315	.025 - .045	0.25	1.5
6	3	375	.025 - .065	0.3	1.8
8	4	375	.035 - .080	0.4	2.4
10	5	375	.045 - .090	0.5	3
12	6	375	.045 - .100	0.6	3.6
16	8	375	.050 - .105	0.8	4.8

Semi Finishing / Finishing (25 - 48 Rc)					
Diameter	Radius	meters/min	mm/tooth range	Max	Max
				Ae	Ap
3	1.5	250	.020 - .030	0.9	0.15
4	2	290	.025 - .040	1.2	0.2
5	2.5	315	.025 - .045	1.5	0.25
6	3	375	.025 - .065	1.8	0.3
8	4	375	.035 - .080	2.4	0.4
10	5	375	.045 - .090	3	0.5
12	6	375	.045 - .100	3.6	0.6
16	8	375	.050 - .105	4.8	0.8



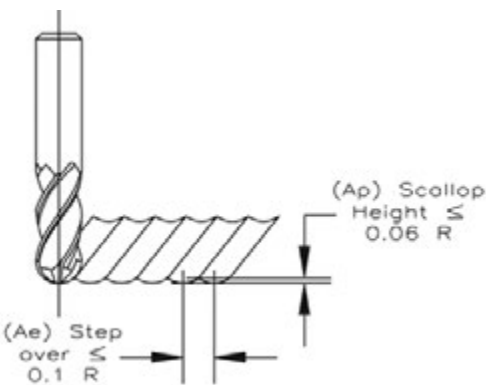
Coolant: High Pressure Air Blast



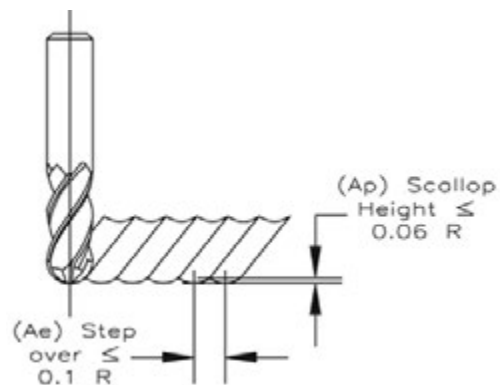
Coolant: High Pressure Air Blast

Titanium					
Diameter	Radius	meters/min	mm/tooth	Max	Max
				Ae	Ap
3	1.5	150	0.030	0.15	0.09
4	2	150	0.035	0.2	0.12
5	2.5	150	0.040	0.25	0.15
6	3	150	0.045	0.3	0.18
8	4	150	0.065	0.4	0.24
10	5	150	0.080	0.5	0.3
12	6	150	0.090	0.6	0.36
16	8	150	0.100	0.8	0.48

High Temp Alloys					
Diameter	Radius	meters/min	mm/tooth	Max	Max
				Ae	Ap
3	1.5	45	0.030	0.15	0.09
4	2	45	0.035	0.2	0.12
5	2.5	45	0.040	0.25	0.15
6	3	45	0.045	0.3	0.18
8	4	45	0.065	0.4	0.24
10	5	45	0.080	0.5	0.3
12	6	45	0.090	0.6	0.36
16	8	45	0.100	0.8	0.48



Coolant: Maximum Coolant Pressure



Coolant: Maximum Coolant Pressure

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

For product information, call your local distributor.