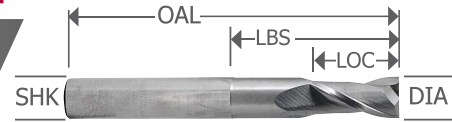


GENERAL PURPOSE CARBIDE END MILL

2 FLUTE • GENERAL PURPOSE END MILLS



Carbide	2	30°	Bright AlTiN	+0.0005 -.0005 <1/8	+0.0000 -.0020 ≥1/8	Square				HRc <48	<table border="1"> <tr> <td>P</td> <td>K</td> </tr> <tr> <td>M</td> <td>S</td> </tr> <tr> <td></td> <td>N</td> </tr> </table>	P	K	M	S		N
P	K																
M	S																
	N																

SERIES: AMG

DIA	SHK	LOC	LBS	OAL	LENGTH	TOOL	BRIGHT EDP	ALTiN EDP
1/64	1/8	3/64		1-1/2	std	AMG-400-1/2	13385	53385
1/32	1/8	1/16		1-1/2	stub	AMGS-401	16146	56146
1/32	1/8	3/32		1-1/2	std	AMG-401	14000	54000
3/64	1/8	3/32		1-1/2	stub	AMGS-401-1/2	16147	56147
3/64	1/8	1/8		1-1/2	std	AMG-401-1/2	14002	54002
1/16	1/8	1/8		1-1/2	stub	AMGS-402	16148	56148
1/16	1/8	3/16		1-1/2	std	AMG-402	14004	54004
1/16	1/8	1/4		1-1/2	med	AMG-402-M	19126	59126
1/16	1/8	3/8		1-1/2	long	AMG-402-L	11521	51521
5/64	1/8	1/8		1-1/2	stub	AMGS-402-1/2	11517	51517
5/64	1/8	3/16		1-1/2	std	AMG-402-1/2	14006	54006
5/64	1/8	1/4		1-1/2	med	AMG-402-1/2-M	19127	59127
3/32	1/8	3/16		1-1/2	stub	AMGS-403	16149	56149
3/32	1/8	3/8		1-1/2	std	AMG-403	14008	54008
3/32	1/8	3/8	3/4	2	ext neck	AMGN-403	19128	59128
3/32	1/8	1/2		1-1/2	med	AMG-403-M	19129	59129
3/32	1/8	9/16		3	long	AMG-403-L	16060	56060
7/64	1/8	7/32		1-1/2	stub	AMGS-403-1/2	14011	54011
7/64	1/8	3/8		1-1/2	std	AMG-403-1/2	14009	54009
1/8	1/8	1/4		1-1/2	stub	AMGS-404	16150	56150
1/8	1/8	1/2		1-1/2	std	AMG-404	14010	54010
1/8	1/8	5/8		2	med	AMG-404-M	11523	51523
1/8	1/8	5/8	1	2	ext neck	AMGN-404	16713	56713
1/8	1/8	3/4		2-1/4	med/long	AMG-404-ML	12751	52751
1/8	1/8	3/4		3	long	AMG-404-L	16061	56061
1/8	1/8	1		3	xl	AMG-404-E	16062	56062
9/64	3/16	9/16		2	std	AMG-604-1/2	15893	55893
5/32	3/16	5/16		1-1/2	stub	AMGS-605	16151	56151
5/32	3/16	9/16		2	std	AMG-605	14020	54020
5/32	3/16	3/4		3	long	AMG-605-L	16063	56063
5/32	3/16	1-1/8		3	xl	AMG-605-E	19130	59130
11/64	3/16	9/16		2	std	AMG-605-1/2	15894	55894
3/16	3/16	3/8		1-1/2	stub	AMGS-606	16152	56152
3/16	3/16	5/8		2	std	AMG-606	14022	54022
3/16	3/16	3/4		2-1/2	med/long	AMG-606-ML	12753	52753
3/16	3/16	3/4		3	long	AMG-606-L	16064	56064
3/16	3/16	1	1-5/8	3	ext neck	AMGN-606	16714	56714
3/16	3/16	1	2-5/8	4	ext neck	AMGN-606-2	16715	56715
3/16	3/16	1	no neck	4	no neck	AMG-606-NN	19131	59131
3/16	3/16	1-1/8		3	xl	AMG-606-E	16065	56065
13/64	1/4	5/8		2-1/2	std	AMG-806-1/2	15895	55895
7/32	1/4	1/2		2	stub	AMGS-807	16153	56153
7/32	1/4	5/8		2-1/2	std	AMG-807	14024	54024
15/64	1/4	3/4		2-1/2	std	AMG-807-1/2	15896	55896
1/4	1/4	1/2		2	stub	AMGS-808	16154	56154
1/4	1/4	3/4		2-1/2	std	AMG-808	14026	54026
1/4	1/4	1	2-1/4	4	ext neck	AMGN-808	16716	56716
1/4	1/4	1-1/8		3	long	AMG-808-L	14028	54028
1/4	1/4	1-1/2		4	xl	AMG-808-E	14030	54030

sizes continued on next page

GENERAL PURPOSE CARBIDE END MILL

2 FLUTE • GENERAL PURPOSE END MILLS

SERIES: AMG

DIA	SHK	LOC	LBS	OAL	LENGTH	TOOL	BRIGHT EDP	ALTIN EDP
1/4	1/4	1-1/2	4-1/4	6	ext neck	AMGN-808-2	16717	56717
1/4	1/4	1-1/2	no neck	6	no neck	AMG-808-NN	19132	59132
17/64	5/16	3/4		2-1/2	std	AMG-1008-1/2	15897	55897
9/32	5/16	3/4		2-1/2	std	AMG-1009	15898	55898
19/64	5/16	13/16		2-1/2	std	AMG-1009-1/2	15899	55899
5/16	5/16	1/2		2	stub	AMGS-1010	16155	56155
5/16	5/16	13/16		2-1/2	std	AMG-1010	14032	54032
5/16	5/16	1	2-5/16	4	ext neck	AMGN-1010	16718	56718
5/16	5/16	1-1/8		3	long	AMG-1010-L	16066	56066
5/16	5/16	1-1/2	4-5/16	6	ext neck	AMGN-1010-2	16719	56719
5/16	5/16	1-5/8		4	xl	AMG-1010-E	16027	56027
21/64	3/8	7/8		2-1/2	std	AMG-1210-1/2	16119	56119
11/32	3/8	7/8		2-1/2	std	AMG-1211	15900	55900
23/64	3/8	7/8		2-1/2	std	AMG-1211-1/2	16120	56120
3/8	3/8	5/8		2	stub	AMGS-1212	16156	56156
3/8	3/8	1		2-1/2	std	AMG-1212	14034	54034
3/8	3/8	1	2-3/8	4	ext neck	AMGN-1212	16720	56720
3/8	3/8	1-1/8		3	long	AMG-1212-L	14036	54036
3/8	3/8	1-1/2	4-3/8	6	ext neck	AMGN-1212-2	16721	56721
3/8	3/8	1-1/2	no neck	6	no neck	AMG-1212-NN	19133	59133
3/8	3/8	1-3/4		4	xl	AMG-1212-E	14038	54038
3/8	3/8	2		4	xl	AMG-1212-EL	19134	59134
3/8	3/8	3		6	xxl	AMG-1212-EE	13621	53621
25/64	7/16	1		2-3/4	std	AMG-1412-1/2	16121	56121
13/32	7/16	1		2-3/4	std	AMG-1413	15901	55901
27/64	7/16	1		2-3/4	std	AMG-1413-1/2	16122	56122
7/16	7/16	5/8		2-1/2	stub	AMGS-1414	16157	56157
7/16	7/16	1		2-3/4	std	AMG-1414	14040	54040
7/16	7/16	1	2-1/4	4	ext neck	AMGN-1414	16722	56722
7/16	7/16	1-1/2	4-1/4	6	ext neck	AMGN-1414-2	16723	56723
7/16	7/16	2		4	long	AMG-1414-L	16029	56029
7/16	7/16	3		6	xl	AMG-1414-E	16028	56028
29/64	1/2	1		3	std	AMG-1614-1/2	16123	56123
15/32	1/2	1		3	std	AMG-1615	15902	55902
31/64	1/2	1		3	std	AMG-1615-1/2	16124	56124
1/2	1/2	5/8		2-1/2	stub	AMGS-1616	16158	56158
1/2	1/2	1		3	std	AMG-1616	14042	54042
1/2	1/2	1	2	4	ext neck	AMGN-1616	16724	56724
1/2	1/2	1-1/4		3	med	AMG-1616-M	11529	51529
1/2	1/2	1-1/2		4	med/long	AMG-1616-ML	19135	59135
1/2	1/2	1-1/2	4	6	ext neck	AMGN-1616-2	16725	56725
1/2	1/2	1-1/2	no neck	6	no neck	AMG-1616-NN	11919	51919
1/2	1/2	2		4	long	AMG-1616-L	14044	54044
1/2	1/2	3		6	xl	AMG-1616-E	14046	54046
17/32	9/16	1-1/4		3-1/2	std	AMG-1817	11515	51515
9/16	9/16	1-1/4		3-1/2	std	AMG-1818	15903	55903
9/16	9/16	2	3-3/4	6	ext neck	AMGN-1818	16726	56726
9/16	9/16	3		6	xl	AMG-1818-E	16727	56727
5/8	5/8	3/4		3	stub	AMGS-2020	16159	56159
5/8	5/8	1-1/4		3-1/2	std	AMG-2020	14048	54048
5/8	5/8	2	3-3/4	6	ext neck	AMGN-2020	16728	56728
5/8	5/8	2	no neck	6	no neck	AMG-2020-NN	19136	59136
5/8	5/8	2-1/4		5	long	AMG-2020-L	16067	56067
5/8	5/8	3		6	xl	AMG-2020-E	16068	56068

sizes continued on next page

GENERAL PURPOSE CARBIDE END MILL

2 FLUTE • GENERAL PURPOSE END MILLS

SERIES: AMG



DIA	SHK	LOC	LBS	OAL	LENGTH	TOOL	BRIGHT EDP	ALTIN EDP
11/16	3/4	1-3/8		4	std	AMG-2422	11918	51918
3/4	3/4	1		3	stub	AMGS-2424	16160	56160
3/4	3/4	1-1/2		4	std	AMG-2424	14050	54050
3/4	3/4	2	3-1/2	6	ext neck	AMGN-2424	16729	56729
3/4	3/4	2-1/4		5	long	AMG-2424-L	16069	56069
3/4	3/4	3		6	xl	AMG-2424-E	14052	54052
7/8	7/8	1-1/2		4	std	AMG-2828	16125	56125
1	1	1-1/2		4	std	AMG-3232	14054	54054
1	1	2	3-1/2	6	ext neck	AMGN-3232	16730	56730
1	1	2-1/4		5	long	AMG-3232-L	12755	52755
1	1	3		6	xl	AMG-3232-E	14056	54056
1	1	4		7	xxl	AMG-3232-EE	14027	54027

2 FLUTE • GENERAL PURPOSE END MILLS



Carbide
2
30°
Bright AlTiN
+0.013
-0.013
<3mm
+0.000
-0.050
≥3mm
Square
3D Models
HRC <48
P M K S N

SERIES: AMG-M_M_

DIA	SHK	LOC	OAL	LENGTH	TOOL	BRIGHT EDP	ALTIN EDP
1mm	3mm	2mm	38mm	stub	AMGS-M3M1	13733	53733
1mm	3mm	3mm	38mm	std	AMG-M3M1	16935	56935
1.5mm	3mm	3mm	38mm	stub	AMGS-M3M1.5	14031	54031
1.5mm	3mm	6mm	38mm	std	AMG-M3M1.5	16936	56936
2mm	3mm	4mm	38mm	stub	AMGS-M3M2	13967	53967
2mm	3mm	9mm	38mm	std	AMG-M3M2	15987	55987
2.5mm	3mm	5mm	38mm	stub	AMGS-M3M2.5	14051	54051
2.5mm	3mm	12mm	38mm	std	AMG-M3M2.5	15988	55988
3mm	3mm	6mm	38mm	stub	AMGS-M3M3	13968	53968
3mm	3mm	12mm	38mm	std	AMG-M3M3	15989	55989
3mm	3mm	18mm	57mm	long	AMG-M3M3-L	13972	53972
3mm	6mm	12mm	63mm	std	AMG-M6M3	19750	59750
3.5mm	4mm	7mm	51mm	stub	AMGS-M4M3.5	14023	54023
3.5mm	4mm	12mm	51mm	std	AMG-M4M3.5	15990	55990
4mm	4mm	8mm	51mm	stub	AMGS-M4M4	13969	53969
4mm	4mm	14mm	51mm	std	AMG-M4M4	15991	55991
4mm	4mm	20mm	63mm	long	AMG-M4M4-L	13973	53973
4mm	6mm	14mm	63mm	std	AMG-M6M4	19751	59751
4.5mm	5mm	9mm	51mm	stub	AMGS-M5M4.5	10991	50991
4.5mm	5mm	14mm	51mm	std	AMG-M5M4.5	15992	55992
5mm	5mm	10mm	51mm	stub	AMGS-M5M5	13970	53970
5mm	5mm	20mm	51mm	std	AMG-M5M5	15993	55993
5mm	5mm	25mm	64mm	long	AMG-M5M5-L	13736	53736

sizes continued on next page

GENERAL PURPOSE CARBIDE END MILL

2 FLUTE • GENERAL PURPOSE END MILLS

SERIES: AMG-M_M_

DIA	SHK	LOC	OAL	LENGTH	TOOL	BRIGHT EDP	ALTIN EDP
5mm	6mm	20mm	63mm	std	AMG-M6M5	10588	50588
6mm	6mm	12mm	51mm	stub	AMGS-M6M6	13955	53955
6mm	6mm	20mm	63mm	std	AMG-M6M6	15994	55994
6mm	6mm	28mm	75mm	long	AMG-M6M6-L	13961	53961
7mm	8mm	12mm	51mm	stub	AMGS-M8M7	13734	53734
7mm	8mm	20mm	63mm	std	AMG-M8M7	15995	55995
8mm	8mm	12mm	51mm	stub	AMGS-M8M8	13735	53735
8mm	8mm	20mm	63mm	std	AMG-M8M8	15996	55996
8mm	8mm	32mm	75mm	long	AMG-M8M8-L	13974	53974
9mm	10mm	14mm	51mm	stub	AMGS-M10M9	10264	50264
9mm	10mm	22mm	70mm	std	AMG-M10M9	15997	55997
10mm	10mm	14mm	51mm	stub	AMGS-M10M10	13971	53971
10mm	10mm	25mm	70mm	std	AMG-M10M10	15998	55998
10mm	10mm	38mm	76mm	med	AMG-M10M10-M	13965	53965
10mm	10mm	40mm	100mm	long	AMG-M10M10-L	13953	53953
11mm	12mm	25mm	76mm	std	AMG-M12M11	10218	50218
12mm	12mm	25mm	76mm	std	AMG-M12M12	15999	55999
12mm	12mm	50mm	100mm	long	AMG-M12M12-L	13975	53975
14mm	14mm	32mm	89mm	std	AMG-M14M14	16926	56926
16mm	16mm	32mm	89mm	std	AMG-M16M16	16927	56927
16mm	16mm	57mm	127mm	long	AMG-M16M16-L	19752	59752
18mm	18mm	38mm	100mm	std	AMG-M18M18	16928	56928
18mm	18mm	57mm	127mm	long	AMG-M18M18-L	14059	54059
20mm	20mm	38mm	100mm	std	AMG-M20M20	16929	56929
20mm	20mm	57mm	127mm	long	AMG-M20M20-L	19753	59753
22mm	22mm	38mm	100mm	std	AMG-M22M22	16930	56930
25mm	25mm	38mm	100mm	std	AMG-M25M25	16931	56931

2 FLUTE • GENERAL PURPOSE METRIC/INCH END MILLS



Carbide	2	30°	Bright ATTIN	+0.000mm -0.050mm	Square				HRC <48	<table border="1"><tr><td>P</td><td>K</td></tr><tr><td>M</td><td>S</td></tr><tr><td></td><td>N</td></tr></table>	P	K	M	S		N
P	K															
M	S															
	N															

SERIES: AMG-_M_

DIA	SHK	LOC	OAL	LENGTH	TOOL	BRIGHT EDP	ALTIN EDP
3mm	1/8	3/8	1-1/2	std	AMG-4M3	15967	55967
4mm	3/16	1/2	2	std	AMG-6M4	15968	55968
5mm	1/4	5/8	2-1/2	std	AMG-8M5	15969	55969
6mm	1/4	5/8	2-1/2	std	AMG-8M6	15970	55970
7mm	5/16	3/4	2-1/2	std	AMG-10M7	15971	55971
8mm	3/8	7/8	2-1/2	std	AMG-12M8	15972	55972
9mm	3/8	7/8	2-1/2	std	AMG-12M9	15973	55973
10mm	7/16	1	2-3/4	std	AMG-14M10	15974	55974
11mm	7/16	1	2-3/4	std	AMG-14M11	15975	55975
12mm	1/2	1	3	std	AMG-16M12	15976	55976

General Purpose Carbide End Mills

SERIES: General Purpose Carbide End Mills

MATERIAL	CONDITIONS	CUTTING DIAMETER											
		1/8"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	CHIP PER TOOTH			
		Under 32 HRc	Over 32 HRc										
STAINLESS STEELS ISO-M													
Precipitation 13-8, 15-5, 17-4PH	Slotting .5 x Dia.	110-200	80-115	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
	Profiling ≤ .5 x Dia.	110-200	80-115	0.0006	0.0012	0.0015	0.0018	0.0025	0.0031	0.0038	0.0050		
Austenitic 302, 303, 304L, 316L	Slotting .5 x Dia.	150-275	80-180	0.0005	0.0011	0.0014	0.0016	0.0023	0.0029	0.0035	0.0046		
	Profiling ≤ .5 x Dia.	150-275	80-180	0.0007	0.0014	0.0018	0.0021	0.0030	0.0038	0.0045	0.0060		
Martensitic 403, 410, 416	Slotting .5 x Dia.	200-400	80-160	0.0005	0.0011	0.0014	0.0016	0.0023	0.0029	0.0035	0.0046		
	Profiling ≤ .5 x Dia.	200-400	80-160	0.0007	0.0014	0.0018	0.0021	0.0030	0.0038	0.0045	0.0060		
HIGH TEMP ALLOYS ISO-S													
Cobalt Base Stellite, Haynes 25, 188, X-40, L-605	Slotting .5 x Dia.	60-125	60-125	0.0004	0.0007	0.0009	0.0011	0.0015	0.0019	0.0023	0.0030		
	Profiling ≤ .5 x Dia.	60-125	60-125	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
Nickel Base Inconel 600, 625, 718, Nickel 200, 270, Invar, Monel 400, 405, K-Monel, PermaNickel 300, Incoly 600	Slotting .5 x Dia.	60-125	60-125	0.0004	0.0007	0.0009	0.0011	0.0015	0.0019	0.0023	0.0030		
	Profiling ≤ .5 x Dia.	60-125	60-125	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
Iron Base Incoloy 800-802, Multimet N-155, Timken 16-26-6	Slotting .5 x Dia.	60-125	60-125	0.0004	0.0007	0.0009	0.0011	0.0015	0.0019	0.0023	0.0030		
	Profiling ≤ .5 x Dia.	60-125	60-125	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
STEELS ISO-P													
High Strength Steels 4140, 4340, 52100	Slotting .5 x Dia.	150-300	80-180	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.004		
	Profiling ≤ .5 x Dia.	150-300	80-180	0.0006	0.0010	0.0012	0.0018	0.0025	0.0031	0.0038	0.005		
High Alloy Steels - Mold & Die A-2, P20, 01, 02, D2, H-13	Slotting .5 x Dia.	150-275	80-185	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.004		
	Profiling ≤ .5 x Dia.	150-275	80-185	0.0006	0.0010	0.0012	0.0018	0.0025	0.0031	0.0038	0.005		
Medium Alloy Steels 200, 250, 300	Slotting .5 x Dia.	175-350	100-225	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.004		
	Profiling ≤ .5 x Dia.	175-350	100-225	0.0006	0.0010	0.0012	0.0018	0.0025	0.0031	0.0038	0.005		
Low Alloy Steels-Maraging 10XX, 11XX, 13XX	Slotting .5 x Dia.	200-450	100-250	0.0006	0.0012	0.0015	0.0018	0.0025	0.0031	0.0038	0.005		
	Profiling ≤ .5 x Dia.	200-450	100-250	0.0007	0.0014	0.0018	0.0021	0.0030	0.0038	0.0045	0.006		
CAST IRONS ISO-K													
Ductile Iron Ductile Cast Iron	Slotting .5 x Dia.	120-325	80-140	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
	Profiling ≤ .5 x Dia.	120-325	80-140	0.0006	0.0012	0.0015	0.0018	0.0025	0.0031	0.0038	0.0050		
Cast Iron Grey Cast Iron	Slotting .5 x Dia.	250-425	125-285	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
	Profiling ≤ .5 x Dia.	250-425	125-285	0.0006	0.0012	0.0015	0.0018	0.0025	0.0031	0.0038	0.0050		
TITANIUMS ISO-S													
Titanium Alloys 6AL-4V, ASTM 1, 2, 3, 6AL-2S For 5553, decrease SFM and IPM by 25%	Slotting .5 x Dia.	140-200	90-145	0.0005	0.0010	0.0012	0.0014	0.0020	0.0025	0.0030	0.0040		
	Profiling ≤ .5 x Dia.	140-200	90-145	0.0006	0.0012	0.0015	0.0018	0.0025	0.0031	0.0038	0.0050		
ALUMINUM ISO-N													
Aluminum Alloys 6061-T6, 7075	Slotting .5 x Dia.	600-1000	NA	0.0006	0.0012	0.0015	0.0018	0.003	0.005	0.006	0.0080		
	Profiling ≤ .5 x Dia.	600-1000	NA	0.0007	0.0014	0.0018	0.0025	0.0035	0.006	0.0068	0.0100		

All technical data provided are suggested starting points. They may be increased or decreased depending on machine condition, depth of cut, finish required, coolant, etc. Call our TECHNICAL SERVICE TEAM with questions.

SPEED & FEED INFORMATION

Calculations

End mill speed & feed formulas are the various individual equations that determine the proper overall machining setup or more specifically the speed of the cutting tool and the rate which it is fed into the work piece. Each individual formula is distinct in what it determines but coordinates with the others to ensure successful cutting tool application. You can visit the TECHNICAL section on www.melintool.com for more information.

INCH

$$\text{RPM} = \frac{\text{Revolutions Per Minute}}{3.82 \times \text{SFM} / \text{Tool Dia}}$$

$$\text{SFM} = \frac{\text{Surface Foot Per Minute}}{.262 \times \text{RPM} \times \text{Tool Dia}}$$

$$\text{CPT or IPT} = \frac{\text{Chip-Load Per Tooth}}{\text{IPM} / \text{RPM} / \text{No. Of Flutes}}$$

$$\text{IPM} = \frac{\text{Inches Per Minute}}{\text{CPT} \times \text{RPM} \times \text{No. Of Flutes}}$$

$$\text{MRRCI} = \frac{\text{Metal Removal Rate Cubic Inches}}{\text{IPM} \times \text{Axial Doc} \times \text{Radial Woc}}$$

$$\text{IPR} = \frac{\text{Inches Per Revolution}}{\text{IPM} / \text{RPM}}$$

METRIC

$$\text{RPM} = \frac{\text{Revolutions Per Minute}}{1000 \times \text{M/MIN} / (3.14 \times \text{D})}$$

$$\text{M/MIN} = \frac{\text{Meters Per Minute}}{(3.14 \times \text{D} \times \text{RPM}) / 1000}$$

$$\text{Fz OR CPT} = \frac{\text{Chip-Load Per Tooth}}{\text{Feedrate (mm) per MIN} / (\text{Z} \times \text{RPM})}$$

$$\text{VF OR FPM} = \frac{\text{Feedrate (mm) Per Minute}}{\text{Feedrate (mm) per Tooth} \times \text{Z} \times \text{RPM}}$$

D = Cutter Dia.
Z = No. Of Teeth.

EQUIVALENTS & CONVERSIONS:

ABBREVIATIONS	
RPM	Revolutions Per Minute
SFM	Surface Feet Per Minute
CPT	Chip Load Per Tooth
IPM	Inches Per Minute
V_f	Millimeters Per Minute
ae	Radial Width of Cut
ap	Axial Depth of Cut
Vc	Surface Meters Per Minute
Fz	Metric Chip Load Per Tooth

$$N, n \text{ or } \text{Min}^{-1} = \text{RPM}$$

$$Vc \text{ or } \text{M/MIN} = \text{SFM}$$

$$Fz \text{ or } \text{mm/TOOTH} = \text{CPT}$$

$$V_f \text{ or } \text{mm/MIN} = \text{IPM}$$

$$\text{SFM} / 3.281 = \text{M/MIN}$$

$$\text{M/MIN} \times 3.281 = \text{SFM}$$

$$\text{mm/MIN} / 25.4 = \text{IPM}$$

$$\text{mm/TOOTH} / 25.4 = \text{CPT}$$



IMPERIAL METRIC

$$\text{Inch} \times 25.4 = \text{Millimeter}$$

$$\text{Millimeter} \times .03937 = \text{Inch}$$