



Solid Carbide Spiral Ball Nose for Plastics Speed and Feed Chart

Chip Load Per Tooth						
#46453 3mm	#46454 4mm	#46424/46425/46455 5mm - 3/16"	#46426/46428/46440/46456 6mm - 1/4"	#46442 5/16"	#46444/46457 10mm - 3/8"	#46446/46458 12mm - 1/2"
0.002" - .003"	0.002" - .003"	0.003" - 0.004"	0.003" - 0.005"	0.003" - 0.005"	0.004" - 0.006"	0.006" - 0.008"

Operating RPM: 12,500

Simple Machining Calculations:

To find **RPM:** SFM x 3.82 / diameter of tool

To find **SFM:** 0.262 x diameter of tool x RPM

To find **Feed Rate:** RPM x # of flutes x chip load

Depth of Cut: 1 x D Use recommended chip load
2 x D Reduce chip load by 25%
3 x D Reduce chip load by 50%