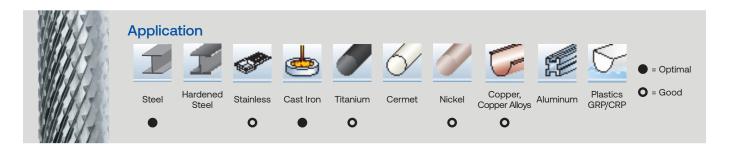
## **Heavy Duty Cut - Technical Resources**

Extremely aggressive cross cut geometry designed for maximum stock removal and for heavy deburring

- · Fast metal removal with optimized cutting geometry for demanding applications.
- Developed for tough grinding conditions like shipyards and foundries.
- For use on: ferrous metals including cast iron, steel < 60 HRC, copper, brass, and bronze.



## **Recommended Operating Speeds**

The operating speeds listed below serve as a guide for using tungsten carbide burs, based on bur head diameter.

	Materia	l groups	Application	Cutting speed	
3.343				SFPM	m/min
Steel, cast steel	Non-hardened, non-heat treated steels up to 1200 N/mm² (< 38 HRC)	Construction steels, carbon steels, tool steels, non-alloyed steels, case-hardened steels, cast steels	Coarse machining = high stock removal with impact load	820-2953	250-900
	Hardened, heat treated steels exceeding 1200 N/mm² (> 38 HRC)	Tool steels, tempered steels, alloyed steels, cast steels	Coarse machining = high stock removal with impact load	820-1148	250-350
Non-Ferrous metals	High-temperature resistant materials	Nickel based alloys cabalt based alloys (aircraft engine and turbine construction)	Coarse machining = high stock removal with impact load	820-1476	250-450
Cast iron	Gray cast iron, white cast iron	Cast-iron with flake graphite EN-GJL (GG), with nodular graphite cast iron EN-GJS (GGG), white anneales cast iron EN-GJMW (GTW), black cast iron EN-GJMB (GTS)	Coarse machining = high stock removal with impact load	820-1969	250-600

Cutting speed									
S	FM	820	1640	1969	2953				
m/	/min	250	500	600	900				
Ø (in)	Ø (mm)	Rotational speed (rpm)							
1/4	6	13,000	27,000	32,000	48,000				
5/16	8	10,000	20,000	24,000	36,000				
3/8	9.6	8,000	16,000	19,000	30,000				
1/2	12	7,000	13,000	16,000	24,000				
5/8	16	5,000	10,000	12,000	18,000				

Recommended speeds are based on standard shank length burs up to 1 3/4", with maximum overhang of 3/8". Max operating speed of 15,000 rpm for extended shanks ( >1  $\frac{3}{4}$ ").

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