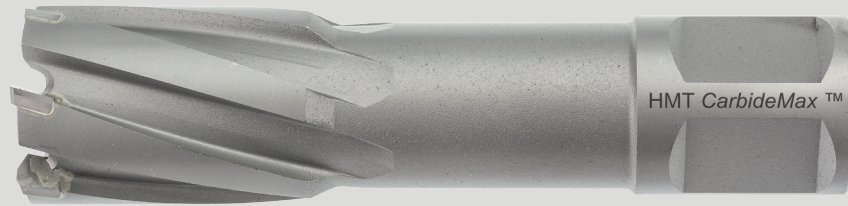



















CARBIDEMAX TCT BROACH CUTTER RPM & FEED DATA

RPM RECOMMENDATIONS FOR HMT CARBIDEMAX TCT BROACH CUTTERS



						
Cutter Diameter	Structural Steel <500Nm (S275, S355) Based on mm/R Feed of 0.10	Structural Steel <1000Nm Based on mm/R Feed of 0.10	Stainless Steel INOX Based on mm/R Feed of 0.13	Brass	Cast Iron-Grey	Aluminium
Diameter Ø	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range	RPM Range
12-19 mm	1265-850	850-580	530-350	1320-875	925-615	2200-1560
20-25 mm	840-650	550-410	345-255	870-630	610-440	1480-1140
26-32 mm	545-460	410-315	250-200	620-505	430-335	1125-890
33-39 mm	460-395	315-265	195-170	500-415	330-280	885-730
40-46 mm	405-340	265-250	165-140	405-340	280-235	720-620
47-53 mm	335-300	250-195	135-120	335-300	235-205	615-545
54-60 mm	295-265	195-180	120-105	295-260	200-180	540-475
61-70 mm	260-230	180-140	105-90	255-225	180-160	475-415
71-80 mm	230-200	140-130	90-70	225-205	160-145	410-365
81-90 mm	195-180	130-115	70-65	200-180	140-125	350-325
91-100 mm	180-160	115-100	60-55	175-160	125-110	320-280
101-112 mm	160-140	100-90	55-50	160-145	110-100	280-250
113-124 mm	140-120	90-85	50-48	145-130	100-90	250-235
125-136 mm	120-110	85-75	48-45	130-115	90-80	230-205
137-150 mm	110-100	70-65	45-40	115-105	80-75	205-190

BEST PRACTICE ADVICE

	Centre punch or pilot drill the surface for accurate hole start.		Regularly check that Magnet Drill slides, handles, arbors and movable parts have not vibrated loose over time.
	Follow guidelines to set correct RPM speed. Incorrect RPM can lead to poor life or tool breakage.		Ensure a debris free surface of sufficient steel thickness for strong magnet hold when Magnet Drilling.
	Apply firm, steady feed pressure throughout the cut, applying the feed very slowly and cautiously during the first 1mm of cut.		For drilling holes in steel thicker than 25mm it is recommended to ventilate the hole frequently to clear the swarf.
	Avoid lateral movement or tilting which can cause damage to the cutter.		When drilling multiple layers of steel CarbideMax Stack Laminate cutters are designed with a special tooth geometry to avoid stuck slugs.
	Ensure constant supply of quality cooling lubricant, especially when drilling thick or hardened materials.		Hiring the correct machine will often result in better life from the consumables and a quicker completion of the task.
	Hardened or heat-affected materials may require higher torque, reduced RPM and feed rates and extra coolant.		

* GUIDELINE PARAMETERS ONLY, ACTUAL PARAMETERS MAY VARY DEPENDING ON OPERATING CONDITIONS

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