



MILLING:
 3/16" CARBIDE = 1750 RPM
 3/8" CARBIDE = 1115 RPM
 3/4" HSS = 325 RPM
 1-1/8" HSS = 210 RPM
 4.2mm HSS = 1115 RPM

HSS PARTING:
 START AT 180 RPM
 FINISH AT 260 RPM

STOCK:
 1-1/8" ROD 4140 PREHARD

NOTES:
 1. Units are in millimeters unless otherwise specified.
 2. Designed for 1/4" tool bit.
 3. Maximum bore depth of about 80mm [3.1"].