

AMPCOLOY® 940 and AMPCOLOY® 944

Machining Recommendations (English imperial)



Turning:

	Carbide Insertable or Solid Carbide	Roughing	Finishing
AMPCOLOY® 940	Cuttingspeed (feet/min)	400 - 800	500 - 1000
	Feed (inches ⁻¹)	0,006 - 0,012	0,002 - 0,004
	Depth of cut (inches)	- 0,14	0,01 - 0,02
AMPCOLOY® 944	Cuttingspeed (feet/min)	400 - 1000	400 - 1300
	Feed (inches ⁻¹)	0,006 - 0,012	0,002 - 0,004
	Depth of cut (inches)	- 0,16	0,01 - 0,02

Face Milling:

	Carbide Insertable or Solid Carbide	Roughing	Finishing
AMPCOLOY® 940	Cuttingspeed (feet/min)	650 - 1300	2000 - 3600
	Feed (inches/tooth)	0,004 - 0,015	0,004 - 0,008
	Depth of cut (inches)	- 0,2	0,004 - 0,02
AMPCOLOY® 944	Cuttingspeed (feet/min)	600 - 650	1650 - 2600
	Feed (inches/tooth)	0,004 - 0,015	0,004 - 0,008
	Depth of cut (inches)	- 0,12	0,004 - 0,02

Plain Milling:

	Carbide Insertable or Solid Carbide	Roughing	Finishing
AMPCOLOY® 940	Cuttingspeed (feet/min)	300 - 650	650 - 800
	Feed (inches/tooth)	0,004 - 0,012	0,002 - 0,005
	Depth of cut (inches)	up to mill-Ø	0,004 - 0,012
AMPCOLOY® 944	Cuttingspeed (feet/min)	250 - 650	600 - 800
	Feed (inches/tooth)	0,008 - 0,015	0,002 - 0,006
	Depth of cut (inches)	up to mill-Ø	0,002 - 0,012

Drilling and Tapping:

		Drilling	Tapping
		Solid Carbide (w. internal cooling)	HSS
AMPCOLOY® 940	Cuttingspeed (feet/min)	250 - 400	25 - 40
	Feed (inches)	0,002 - 0,006	
AMPCOLOY® 944	Cuttingspeed (feet/min)	250 - 400	25 - 40
	Feed (inches)	0,003 - 0,008	