

# AMPCOLOY® 940 and AMPCOLOY® 944

## Machining Recommendations (English metric)



### Turning:

	Carbide Insertable or Solid Carbide	Roughing	Finishing
AMPCOLOY® 940	Cuttingspeed (m/min)	120 - 250	150 - 300
	Feed (mm <sup>-1</sup> )	0,15 - 0,30	0,05 - 0,1
	Depth of cut (mm)	- 3,5	0,25 - 0,5
AMPCOLOY® 944	Cuttingspeed (m/min)	150 - 300	150 - 400
	Feed (mm <sup>-1</sup> )	0,15 - 0,3	0,05 - 0,1
	Depth of cut (mm)	- 4	0,25 - 0,5

### Face Milling:

	Carbide Insertable or Solid Carbide	Roughing	Finishing
AMPCOLOY® 940	Cuttingspeed (m/min)	200 - 400	600 - 1100
	Feed (mm/tooth)	0,1 - 0,4	0,1 - 0,2
	Depth of cut (mm)	- 5	0,1 - 0,5
AMPCOLOY® 944	Cuttingspeed (m/min)	180 - 200	500 - 800
	Feed (mm/tooth)	0,1 - 0,4	0,1 - 0,2
	Depth of cut (mm)	- 3	0,1 - 0,5

### Plain Milling:

	Carbide Insertable or Solid Carbide	Roughing	Finishing
AMPCOLOY® 940	Cuttingspeed (m/min)	100 - 200	200 - 250
	Feed (mm/tooth)	0,1 - 0,3	0,05 - 0,12
	Depth of cut (mm)	up to mill-Ø	0,1 - 0,3
AMPCOLOY® 944	Cuttingspeed (m/min)	80 - 200	180 - 250
	Feed (mm/tooth)	0,2 - 0,4	0,05 - 0,15
	Depth of cut (mm)	up to mill-Ø	0,05 - 0,3

### Drilling and Tapping:

		Drilling	Tapping
		Solid Carbide (w. internal cooling)	HSS
AMPCOLOY® 940	Cuttingspeed (m/min)	80 - 120	8 - 12
	Feed (mm)	0,05 - 0,15	
AMPCOLOY® 944	Cuttingspeed (m/min)	80 - 120	8 - 12
	Feed (mm)	0,07 - 0,2	