

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 | |