

Variable Flute Endmill  
Speeds Feeds

WORKING MATERIAL	ALLOY STEELS/ TOOL STEELS		HARDENED STEEL						REFERENCE	
	25~35HRC		25~35HRC		35~45HRC		45~55HRC			
DIAMETER	R.P.M.	FEED	R.P.M.	FEED	R.P.M.	FEED	R.P.M.	FEED	DOC	Step Over
1/8	8915	19.6	5572	12.3	7761	9.2	5012	11	0.1875	0.0157
1/4	5943	17.4	3714	10.9	5174	8.2	3343	9.7	0.375	0.0236
3/8	3567	18.3	2230	11.4	3101	8.6	2006	9.4	0.5625	0.0394
1/2	2972	17.4	1859	10.9	2587	8.2	1670	9.7	0.75	0.0472

Diameter	Shank	LOC	OAL	Radius
1/8	1/8	3/8	1-1/2"	0.015
1/4	1/4	3/4	2-1/2"	0.010
3/8	3/8	1"	2-1/2"	0.020
1/2	1/2	1-1/4"	3"	0.030

**Bar-Tech Enterprises Ltd.**

355 Elmira Rd N. Unit #130  
1-800-265-0562 / 519-763-7030  
sales@bartechent.com