Suggested Speeds And Feeds

Tool Shank Diameter and Number of Flutes
SFPM and Feed, Inches per Tooth

Material	Class	1/4" 2	5/16" 2	3/8" 2	1/2" 2	3/4" 2
1. Steel	Plain and Low Carbon to 22 HRc	600 .004	600 .005	600 .005	600 .006	600 .006
2. Medium Carbon & Alloy Steels	Carbon and Alloys to 32 HRc	575 .003	575 .003	575 .003	575 .004	575 .004
3. Medium Carbon & Alloy Steels	Carbon and Alloys 32 HRc to 42 HRc	525 .004	525 .005	525 .005	525 .006	525 .006
4. Stainless Steels	Austentic	525 .0015	525 .0015	525 .002	525 .003	525 .004
5. Stainless Steels	Martensitic	550 .0015	550 .0015	550 .002	550 .003	550 .004
6. Stainless Steels	Precipitation Hardening	300 .001	300 .0015	300 .0015	300 .002	300 .002
7. Nickel	Nickel Base Aloys	120 .001	120 .001	120 .0015	120 .002	120 .002
8. Titanium	Titanium Alloys	100 .001	100 .001	100 .0015	100 .002	100 .002
9. Cast Iron	Gray, Malleable & Ductile	600 .0015	600 .002	600 .003	600 .004	600 .004
10. Non-Ferrous	Low Si Cast & Aluminum	1,700 .003	1,700 .003	1,700 .004	1,700 .005	1,700 .005

Suggested Speeds And Feeds

Tool Shank Diameter and number of flutes
Cutting Speed and Feed per Tooth

Material	Class	6mm 2	8mm 2	10mm 2	12mm 2	16mm 2
1. Steel	Plain and Low Carbon to 22 HRc	185 0,075	185 0,100	185 0,125	185 0,125	185 0,150
2. Medium Carbon & Alloy Steels	Carbon and Alloys to 32 HRc	175 0,050	175 0,075	175 0,075	175 0,075	175 0,125
3. Medium Carbon & Alloy Steels	Carbon and Alloys 32 HRc to 42 HRc	160 0,075	160 0,100	160 0,125	160 0,125	160 0,150
4. Stainless Steels	Austentic	160 0,025	160 0,038	160 0,038	160 0,050	160 0,075
5. Stainless Steels	Martensitic	165 0,025	165 0,038	165 0,038	165 0,050	165 0,075
6. Stainless Steels	Precipitation Hardening	90 0,025	90 0,025	90 0,038	90 0,038	90 0,050
7. Nickel	Nickel Base Aloys	36 0,012	36 0,025	36 0,025	36 0,038	36 0,050
8. Titanium	Titanium Alloys	30 0,012	30 0,025	30 0,025	30 0,038	30 0,050
9. Cast Iron	Gray, Malleable & Ductile	185 0,038	185 0,038	185 0,050	185 0,075	185 0,100
10. Non-Ferrous	Low Si Cast & Aluminum	500 0,050	500 0,075	500 0,075	500 0,100	500 0,150