Speed & Feed Information

Speed & Feeds for Series: Multiple Series
Description: Roughing End Mills

Notes

Note: All technical data provided are suggested starting points. They may be increase or decreased depending on machine condition, depth of cut, finish required, coolant, etc. Call our Technical Service Team with questions

Material Guide		SFM	Chip Load per Tooth			
			1/8"	1/4"	1/2"	1"
ISO-M	**Austenitic**	12-20		.0007	.0015	.0030
	Ferritic	50-75	.0004	.0007	.0020	.0050
ISO-S	**Cobalt Base**	8-15		.0007	.0015	.0030
	Nickel Base	20-25	.0004	.0007	.0015	.0030
ISO-P	**Stainless Steels**					
	Free Machining	75-90	.0005	.0007	.0012	.0020
	Other	50-75	.0005	.0007	.0012	.0020
	Steel					
	Annealed	100-125	.0010	.0020	.0040	.0060
	Rc 18-24	75-100	.0070	.0012	.0030	.0050
	Rc 25-37	40-75	.0005	.0010	.0020	.0040
ISO-K	**Cast Steel**	75-100	.0008	.0015	.0025	.0050
	Cast Iron	100-125	.0008	.0015	.0025	.0050
	Malleable Iron	80-120	.0008	.0015	.0025	.0050
ISO-S	**Titanium Alloys**					
	Up to Rc 30	40-75	.0050	.0012	.0025	.0050
	Rc 30+	20-25	.0005	.0010	.0020	.0035
ISO-N	**Copper Alloys**	75-100	.0008	.0015	.0030	.0060
	Brass	85-110	.0008	.0015	.0030	.0060
	Bronze	75-100	.0008	.0015	.0030	.0060
	Magnesium	125-250	.0010	.0020	.0025	.0030
	Aluminum Alloys	125-250	.0010	.0020	.0025	.0030