



Double Ended | Two RH Spiral Flutes | 118° Cam Relieved | 60°/82°/90°

		Imperial (in)						Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
High Si Aluminum >10%	RPM	7,640	3,820	2,547	1,910	1,273	955	8,085	4,042	2,425	2,021	1,277	970
	IPM	9	7	5	5	4	3	233	175	129	121	97	85
	SFM	250	250	250	250	250	250	76	76	76	76	76	76
	IPR	.001	.002	.002	.003	.003	.004	0.03	0.04	0.05	0.06	0.08	0.09
Low Si Aluminum <10%	RPM	9,168	4,584	3,056	2,292	1,528	1,146	9,702	4,851	2,911	2,425	1,532	1,164
	IPM	11	8	6	7	5	6	279	210	155	175	136	146
	SFM	300	300	300	300	300	300	91	91	91	91	91	91
	IPR	.001	.002	.002	.003	.004	.005	0.03	0.04	0.05	0.07	0.09	0.13
Composites	RPM	13,752	6,876	4,584	3,438	2,292	1,719	14,553	7,276	4,366	3,638	2,298	1,746
	IPM	21	10	9	12	9	9	524	262	233	306	233	218
	SFM	450	450	450	450	450	450	137	137	137	137	137	137
	IPR	.002	.002	.002	.004	.004	.005	0.04	0.04	0.05	0.08	0.10	0.13
Brass & Copper	RPM	7,640	3,820	2,547	1,910	1,273	955	8,085	4,042	2,425	2,021	1,277	970
	IPM	8	6	5	5	5	5	194	146	129	121	129	121
	SFM	250	250	250	250	250	250	76	76	76	76	76	76
	IPR	.001	.002	.002	.003	.004	.005	0.02	0.04	0.05	0.06	0.10	0.13
Graphite	RPM	15,280	7,640	5,093	3,820	2,547	1,910	16,170	8,085	4,851	4,042	2,553	1,940
	IPM	31	19	18	17	13	11	776	485	453	437	323	291
	SFM	500	500	500	500	500	500	152	152	152	152	152	152
	IPR	.002	.003	.004	.005	.005	.006	0.05	0.06	0.09	0.11	0.13	0.15
Cast Iron	RPM	9,168	4,584	3,056	2,292	1,528	1,146	9,702	4,851	2,911	2,425	1,532	1,164
	IPM	11	8	6	6	5	6	279	210	155	146	136	146
	SFM	300	300	300	300	300	300	91	91	91	91	91	91
	IPR	.001	.002	.002	.003	.004	.005	0.03	0.04	0.05	0.06	0.09	0.13
Hardened Steels >48RC	RPM	2,445	1,222	815	611	407	306	2,587	1,294	776	647	408	310
	IPM	2	2	1	2	1	1	50	43	37	39	31	27
	SFM	80	80	80	80	80	80	24	24	24	24	24	24
	IPR	.001	.001	.002	.003	.003	.004	0.02	0.03	0.05	0.06	0.08	0.09
Steels	RPM	7,640	3,820	2,547	1,910	1,273	955	8,085	4,042	2,425	2,021	1,277	970
	IPM	6	5	5	5	4	4	155	126	129	121	113	97
	SFM	250	250	250	250	250	250	76	76	76	76	76	76
	IPR	.001	.001	.002	.003	.004	.004	0.02	0.03	0.05	0.06	0.09	0.10
Stainless Steels	RPM	4,584	2,292	1,528	1,146	764	573	4,851	2,425	1,455	1,213	766	582
	IPM	4	3	3	3	3	2	93	76	78	73	68	58
	SFM	150	150	150	150	150	150	46	46	46	46	46	46
	IPR	.001	.001	.002	.003	.004	.004	0.02	0.03	0.05	0.06	0.09	0.10
Titanium	RPM	2,750	1,375	917	688	458	344	2,911	1,455	873	728	460	349
	IPM	2	2	1	1	1	1	56	42	35	35	35	31
	SFM	90	90	90	90	90	90	27	27	27	27	27	27
	IPR	.001	.001	.002	.002	.003	.004	0.02	0.03	0.04	0.05	0.08	0.09

Not Recommended for Plastics or Super Alloys (Nickel based, Inconel).

The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.

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