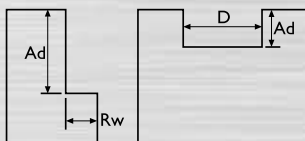


Speed and Feed Recommendations

Slotting		Steels 30-45 HRC		Steels >45-55 HRC		Steels >55-60 HRC	
		Rw 1xD Ad ≤ .5xD		Rw 1xD Ad ≤ .5xD		Rw 1xD Ad ≤ .3xD	
		215 sfm in / tooth	65 m / min mm / tooth	120 sfm in / tooth	36 m / min mm / tooth	65 sfm in / tooth	20 m / min mm / tooth
Diameter (D)							
1/8	3mm	0.0006	0.02	0.0005	0.01	0.0004	0.01
3/16	5mm	0.0009	0.02	0.0008	0.02	0.0006	0.02
1/4	6mm	0.0013	0.03	0.0010	0.03	0.0008	0.02
5/16	8mm	0.0016	0.04	0.0013	0.03	0.0009	0.02
3/8	10mm	0.0019	0.05	0.0015	0.04	0.0011	0.03
7/16		0.0022	0.06	0.0018	0.05	0.0013	0.03
1/2	12mm	0.0025	0.06	0.0020	0.05	0.0015	0.04
5/8	16mm	0.0031	0.08	0.0025	0.06	0.0019	0.05
3/4	20mm	0.0038	0.10	0.0030	0.08	0.0023	0.06

Profiling		Steels 30-45 HRC		Steels >45-55 HRC		Steels >55-60 HRC	
		Rw ≤ .5xD Ad ≤ 1xD		Rw ≤ .5xD Ad ≤ 1xD		Rw ≤ .3xD Ad ≤ 1xD	
		265 sfm in / tooth	80 m / min mm / tooth	150 sfm in / tooth	45 m / min mm / tooth	80 sfm in / tooth	24 m / min mm / tooth
Diameter (D)							
1/8	3mm	0.0009	0.02	0.0007	0.02	0.0005	0.01
3/16	5mm	0.0013	0.03	0.0011	0.03	0.0008	0.02
1/4	6mm	0.0018	0.05	0.0014	0.04	0.0011	0.03
5/16	8mm	0.0022	0.06	0.0018	0.05	0.0013	0.03
3/8	10mm	0.0026	0.07	0.0021	0.05	0.0016	0.04
7/16		0.0031	0.08	0.0026	0.07	0.0018	0.05
1/2	12mm	0.0035	0.09	0.0028	0.07	0.0021	0.05
5/8	16mm	0.0044	0.11	0.0035	0.09	0.0026	0.07
3/4	20mm	0.0053	0.13	0.0042	0.11	0.0032	0.08

High Speed Profiling		Steels 30-45 HRC		Steels >45-55 HRC		Steels >55-60 HRC	
		Rw ≤ .1xD Ad ≤ .1xD		Rw ≤ .1xD Ad ≤ .1xD		Rw ≤ .1xD Ad ≤ .1xD	
		560 sfm in / tooth	170 m / min mm / tooth	490 sfm in / tooth	150 m / min mm / tooth	250 sfm in / tooth	75 m / min mm / tooth
Diameter (D)							
1/8	3mm	0.0011	0.03	0.0009	0.02	0.0006	0.02
3/16	5mm	0.0017	0.04	0.0013	0.03	0.0009	0.02
1/4	6mm	0.0022	0.06	0.0018	0.05	0.0013	0.03
5/16	8mm	0.0028	0.07	0.0022	0.06	0.0016	0.04
3/8	10mm	0.0033	0.08	0.0026	0.07	0.0019	0.05
7/16		0.0039	0.10	0.0031	0.08	0.0022	0.06
1/2	12mm	0.0044	0.11	0.0035	0.09	0.0025	0.06
5/8	16mm	0.0055	0.14	0.0044	0.11	0.0031	0.08
3/4	20mm	0.0066	0.17	0.0053	0.13	0.0038	0.10



Radial Width of Cut (Rw) Axial Depth of Cut (Ad) Tool Diameter (D)