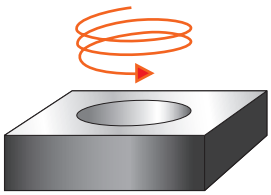
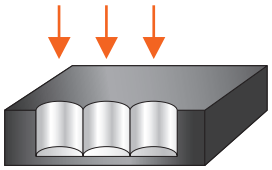
HIGH FEED MILLING / FEED VALUES

ISO	Workpiece Material	Rockwell Hardness HRC	Recommended feed per insert f_z (inches) starting (range)	
			GM (medium)	GH (heavy)
P Steel	Low-Carbon Steel	<25	.045 (.030 - .060)	.060 (.040 - .080)
P Steel	Alloy Steel and Tool Steel	<35	.045 (.030 - .060)	.060 (.040 - .080)
P Steel	Alloy Steel and Tool Steel	35 - 45	.035 (.025 - .050)	.045 (.030 - .060)
M Stainless Steel	Stainless Steel	<35	.030 (.025 - .040)	.040 (.030 - .050)
K Cast Iron	Cast Iron	<35	.045 (.030 - .060)	.060 (.040 - .080)
S High-Temp Alloys	Heat-Resistant and Titanium Alloys	<35	.015 (.006 - .024)	.020 (.008 - .036)
H Hardened Steel	Alloy Steel and Tool Steel	45 - 55	.010 (.004 - .020)	.015 (.006 - .030)

RECOMMENDED STARTING FEED VALUES RELATIVE TO DEPTH OF CUT	depth of cut a_p (inches)			
	.020	.040	.060	.078
Recommended feed per insert f_z (inches) starting (range)	.070 (.060 - .080)	.060 (.040 - .070)	.040 (.025 - .060)	.030 (.015 - .040)

OTHER APPLICATIONS





See Tech Info pages for feed recommendations for ramping, helical milling and plunging applications.