

Speeds & Feeds - Chamfering milling cutters

Material	Hardness	Cutting speed SFM	Feed Rate Inch per Tooth - IPT d1 End Mill Diameter						
			3	6	8	10	12	16	20
Struct./free-cutting steels, unall. heat-treat./case hard. steels	Up To 28 HRc	525	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017	0.0019
Free-cutting steels, unalloyed case hard. steels, nitr. steels	28-44 HRc	460	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Alloyed heat-treatable, tool and high speed steels	38-44 HRc	360	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Hardened Steels	up to 54 HRc	300	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
	54-60 HRc	200	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Stainless steel - easy to machine / sulphured	up to 20 HRc	260	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Stainless steel - moderately difficult to machine	20-30 HRc	160	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Titanium, Titanium alloys	Up to 42 HRc	250	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
High-temp alloys	Up to 42 HRc	148	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Cast iron, grey cast iron, spher. graphite/malleable cast iron	over 240 HB30	500	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017	0.0019
		425	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Aluminum, Al-wrought alloys, Al-alloys	less than 7% Si	574	0.0005	0.0007	0.0010	0.0013	0.0017	0.0019	0.0025