

# APPLICATION CHART

CARBIDE

## Square End Mill, Corner Radius End Mill

DS2SS (⊕I036), DS2MS (⊕I037), DS2LS (⊕I038), DS3SC (⊕I039), DS3MC (⊕I040), DS4SC (⊕I041), DS4MC (⊕I042), DS4LC (⊕I043), DS4MC...CB (⊕I051), DS4LC...CB (⊕I052), DS2SRB (⊕I053), DS2MRB (⊕I054), DS4SRB (⊕I055), DS4MRB (⊕I056)

			.016"-.125"	.141"-.250"	.281"-.500"	.563"-.750"	.750"-1.250"	Slotting-max D.O.C.	
	MATERIAL	HRC / BHN	SFM *	IPT	IPT	IPT	IPT		
STEELS	Carbon Steel	150-250 BHN	160-500	.0002-.0005	.0008-.0015	.0015-.003	.002-.003	.003-.005	.3-.5DC
	Steel Alloys	-45 HRC	130-350	.0002-.0005	.0008-.0015	.0015-.003	.002-.003	.003	.3-.5DC
	Steel Alloys	45-55 HRC	100-160	.0001-.0004	.0005-.001	.001-.002	.002	.003	.05-.2DC
STAINLESS STEELS	300	140-185 BHN	100-300	.0001-.0005	.0008-.0015	.0015-.003	.002-.003	.003-.004	.3-.5DC
	400	180-200 BHN	125-350	.0001-.0005	.0008-.0015	.0015-.003	.002-.003	.003-.004	.3-.5DC
	Heat Resistant	32-43 HRC	100-300	.0001-.0004	.0005-.001	.001-.002	.002	.002	.05-.2DC
CAST IRON	Gray Cast Iron	180-260 BHN	150-550	.0002-.0005	.0008-.0015	.0015-.003	.002-.003	.003-.005	.3-.5DC
	Ductile Cast Iron	220-260 BHN	150-550	.0002-.0005	.0008-.0015	.0015-.003	.002-.003	.003-.005	.3-.5DC
NON-FERROUS	Aluminum Alloys	180-220 BHN	300-1000	.0002-.0005	.001-.002	.002-.003	.003-.004	.004-.005	.5-1DC
	Copper Alloys	60-120 BHN	200-500	.0002-.0005	.0008-.0015	.0015-.003	.002-.003	.003-.005	.3-.5DC
	Plastics	-	300-1500	.0002-.0005	.001-.002	.002-.003	.003-.004	.004-.005	.5-1DC
TI	Titanium	300-350 BHN	70-300	.0003-.0006	.0006-.001	.001-.003	.003-.004	.004-.007	.3-.5DC

## STAINLESS STEEL Square End Mill, Corner Radius End Mill

DS3MHH60 (⊕I049), DS6MHH60 (⊕I050), DS3SH...SS (⊕I060), DS3MH...SS (⊕I061), DS5MH...SS (⊕I062), DS5LH...SS (⊕I063), DS3SHRB...SS (⊕I066), DS3MHRB...SS (⊕I067), DS5SHRB...SS (⊕I068), DS5MHRB...SS (⊕I069), DS3MHHRB (⊕I070), DS6MHHRB (⊕I071)

			.125"	.141"-.250"	.281"-.500"	.563"-.750"	.750"	Slotting-max D.O.C.	
	MATERIAL	HRC / BHN	SFM *	IPT	IPT	IPT	IPT		
STAINLESS STEELS	304 316	130-190 BHN	150-300	.0005	.0008-.0015	.0015-.003	.002-.003	.003	.3-.5DC
	405 410 430	180-200 BHN	200-500	.0005	.0008-.0015	.0015-.003	.002-.003	.003	.3-.5DC
	405 410 430	30-37 HRC	130-500	.0005	.0008-.0015	.0015-.003	.002-.003	.003	.3-.5DC
	PH	35-42 HRC	150-200	.0004	.0005-.001	.001-.002	.002	.002	.05-.2DC

## ALUMINUM Square End Mill, Corner Radius End Mill

DS2SRB...A (⊕I057), DS2SRB...NA (⊕I058), DS3MHR...A (⊕I059)

			.141"-.250"	.281"-.500"	.563"-.750"	.750"-1"	Slotting-max D.O.C.	
	MATERIAL	HRC / BHN	SFM *	IPT	IPT	IPT		
ALUMINUM	Aluminum Cast	40-100 BHN	700-1500	.001-.002	.002-.003	.003-.004	.004-.006	.5-1DC
	Aluminum Alloys <5% silicon	40-100 BHN	700-1500	.001-.002	.002-.003	.003-.004	.004-.006	.5-1DC
	Aluminum Alloys >5% silicon	60-120 BHN	450-1000	.001-.002	.002-.003	.003-.004	.004-.006	.5-1DC

- \* Please decrease speed by 25% when using extra length end mills.
- \* Speed may be increased by 25% when using stub length end mills.
- \* When slotting, please decrease speed by 20%.

SOLID END MILLS