

APPLICATION CHART

CARBIDE

Ball Nose End Mill

DS2SB (↻I044), DS2LB (↻I045), DS3SB (↻I046), DS4SB (↻I047), DS4LB (↻I048)

	MATERIAL	HRC / BHN	SFM *	.016"—.125"	.141"—.250"	.281"—.500"	.563"—.750"	.750"—1"	Slotting- max D.O.C.
				IPT	IPT	IPT	IPT	IPT	
STEELS	Carbon Steel	150—250 BHN	160—900	.0001—.0005	.001—.0015	.0015—.003	.003—.005	.005—.006	.1—.25DC
	Steel Alloys	—45 HRC	160—750	.0001—.0004	.001—.0012	.0012—.003	.003—.005	.005—.006	.1—.25DC
	Steel Alloys	45—55 HRC	160—600	.0001—.0004	.0008—.0012	.0012—.003	.003—.004	.004—.005	.1—.25DC
STAINLESS STEELS	400	180—200 BHN	160—750	.0001—.0004	.001—.0012	.0012—.003	.003—.005	.005—.006	.1—.25DC
	Heat Resistant	32—43 HRC	150—400	.0001—.0004	.0008—.0012	.0012—.003	.003—.004	.004—.005	.1—.25DC
CAST IRON	Gray Cast Iron	180—260 BHN	160—900	.0001—.0005	.001—.0015	.0015—.003	.003—.005	.005—.006	.1—.25DC
	Ductile Cast Iron	220—260 BHN	160—900	.0001—.0005	.001—.0015	.0015—.003	.003—.005	.005—.006	.1—.25DC
NON- FERROUS	Aluminum Alloys	180—220 BHN	300—1500	.0001—.0008	.001—.002	.0015—.004	.004—.006	.006—.008	.2—.5DC
	Copper Alloys	60—120 BHN	160—900	.0001—.0005	.001—.0015	.0015—.003	.003—.005	.005—.006	.1—.25DC
	Plastics	—	300—1500	.0001—.0008	.001—.002	.0015—.004	.004—.006	.006—.008	.2—.5DC
Ti	Titanium	300—350 BHN	100—300	.0001—.0004	.0008—.0012	.0012—.003	.003—.004	.004—.005	.1—.25DC

STAINLESS STEEL Ball Nose End Mill

DS3SHB...SS (↻I064), DS3MHB...SS (↻I065)

	MATERIAL	HRC / BHN	SFM *	.125"	.141"—.250"	.281"—.500"	.563"—.750"	.750"	Slotting- max D.O.C.
				IPT	IPT	IPT	IPT	IPT	
STAINLESS STEELS	304 316	130—190 BHN	250—500	.0003—.0004	.001—.0012	.0012—.003	.003—.005	.004—.005	.1—.25DC
	405 410 430	180—200 BHN	200—600	.0003—.0004	.001—.0012	.0012—.003	.003—.005	.005—.006	.1—.25DC
	405 410 430	30—37 HRC	130—500	.0003—.0004	.001—.0012	.0012—.003	.003—.005	.005—.006	.1—.25DC
	PH	35—42 HRC	150—350	.0003—.0004	.0008—.0012	.0012—.003	.003—.004	.004—.005	.1—.25DC

- * 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