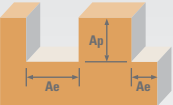


Speed & Feed Recommendations

Series MK2 Metric	Hardness BRINELL			Vc (m/min)		Diameter (D ₁) (mm)				
		Ae x D ₁	Ap x D ₁			0.2	0.41	0.79	1.02	1.52
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	 Profile ≤ 0.5 ≤ 1.5		98	RPM	155107	75662	39267	30413	20409
				(78-117)	Fz	0.00046	0.0010	0.0018	0.0028	0.0036
					Feed (mm/min)	143	151	141	170	147
		 Slot 1 ≤ 1		78	RPM	123601	60293	31291	24235	16263
				(62-93)	Fz	0.00041	0.0008	0.0015	0.0023	0.0033
					Feed (IPM)	101	96	94	111	107
P	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	 Profile ≤ 0.5 ≤ 1.5		72	RPM	113906	55564	28837	22335	14988
				(57-86)	Fz	0.00036	0.0008	0.0013	0.0002	0.0028
					Feed (IPM)	82	89	75	9	84
		 Slot 1 ≤ 1		58	RPM	92095	44924	23315	18058	12118
				(46-69)	Fz	0.00030	0.0005	0.0013	0.0018	0.0023
					Feed (IPM)	55	45	61	65	56
P	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	 Profile ≤ 0.5 ≤ 1.5		67	RPM	106636	52017	26996	20909	14031
				(54-80)	Fz	0.00036	0.0008	0.0013	0.0002	0.0028
					Feed (IPM)	77	83	70	8	79
		 Slot 1 ≤ 1		53	RPM	84824	41378	21474	16632	11161
				(43-64)	Fz	0.00030	0.0005	0.0013	0.0018	0.0023
					Feed (IPM)	51	41	56	60	51
K	CAST IRONS Gray, Malleable, Ductile	 Profile ≤ 0.5 ≤ 1.5		72	RPM	113906	55564	28837	22335	14988
				(57-86)	Fz	0.00046	0.0010	0.0018	0.0028	0.0036
					Feed (IPM)	105	111	104	125	108
		 Slot 1 ≤ 1		58	RPM	92095	44924	23315	18058	12118
				(46-69)	Fz	0.00041	0.0008	0.0015	0.0023	0.0033
					Feed (IPM)	76	72	70	83	80
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F 440F	 Profile ≤ 0.5 ≤ 1.5		79	RPM	126024	61475	31905	24711	16582
				(63-95)	Fz	0.00036	0.0008	0.0013	0.0002	0.0028
					Feed (IPM)	91	98	83	10	93
		 Slot 1 ≤ 1		64	RPM	101789	49653	25769	19959	13393
				(51-77)	Fz	0.00030	0.0005	0.0013	0.0018	0.0023
					Feed (IPM)	61	50	67	72	62
M	STAINLESS STEELS (DIFFICULT) 304, 304L, 316, 316L	 Profile ≤ 0.5 ≤ 1.5		55	RPM	87247	42560	22088	17107	11480
				(44-66)	Fz	0.00028	0.0005	0.0010	0.0015	0.0023
					Feed (IPM)	49	43	44	51	53
		 Slot 1 ≤ 1		44	RPM	70283	34284	17793	13781	9248
				(35-53)	Fz	0.00025	0.0005	0.0010	0.0015	0.0020
					Feed (IPM)	35	34	36	41	37

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