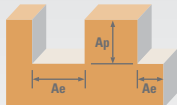


Speed & Feed Recommendations



Series 57 Fractional	Hardness BRINELL			Vc (SFM)	Diameter (D ₁) (inch)					
		Ae x D ₁	Ap x D ₁		1/4	5/16	3/8	1/2		
P	TOOL STEELS MOLD AND DIE STEEL 300M, 4340, 52100, HP-9-4-20, M50, A2, D2, H13, L2, M2, P20, S7, T15, W2		1	≤ 0.3	215	RPM	3285	2628	2190	1643
					(172-258)	Fz	0.0013	0.0019	0.0025	0.0031
						Feed (IPM)	26	30	33	31
			≤ 0.1	≤ 1.5	265	RPM	4049	3239	2699	2025
					(212-318)	Fz	0.0018	0.0026	0.0035	0.0440
						Feed (IPM)	44	51	57	53
			≤ 0.04	≤ 1.5	560	RPM	8557	6845	5705	4278
					(448-672)	Fz	0.0022	0.0033	0.0044	0.0055
						Feed (IPM)	113	136	151	141
P	TOOL STEELS MOLD AND DIE STEEL 300M, 4340, 52100, HP-9-4-20, M50, A2, D2, H13, L2, M2, P20, S7, T15, W2		1	≤ 0.3	120	RPM	1834	1467	1222	917
					(96-144)	Fz	0.0010	0.0015	0.0020	0.0025
						Feed (IPM)	11	13	15	14
			≤ 0.1	≤ 1.5	150	RPM	2292	1834	1528	1146
					(120-180)	Fz	0.0014	0.0021	0.0028	0.0035
						Feed (IPM)	19	23	26	24
			≤ 0.04	≤ 1.5	490	RPM	7487	5990	4991	3744
					(392-588)	Fz	0.0018	0.0026	0.0035	0.0044
						Feed (IPM)	81	93	105	99
H	TOOL STEELS MOLD AND DIE STEEL 300M, 4340, 52100, HP-9-4-20, M50, A2, D2, H13, L2, M2, P20, S7, T15, W2		1	≤ 0.3	65	RPM	993	795	662	497
					(52-78)	Fz	0.0008	0.0011	0.0015	0.0019
						Feed (IPM)	5	5	6	6
			≤ 0.1	≤ 1.5	80	RPM	1222	978	815	611
					(64-96)	Fz	0.0011	0.0016	0.0021	0.0026
						Feed (IPM)	8	9	10	10
			≤ 0.04	≤ 1.5	250	RPM	3820	3056	2547	1910
					(200-300)	Fz	0.0013	0.0019	0.0025	0.0031
						Feed (IPM)	30	35	38	36

rpm = sfm x 3.82 / D₁

ipm = (inch / flute) x 6 x rpm

HSM (high speed machining)

reduce speed and feed for materials harder than listed

reduce feed and Ae when finish milling (.02 x D₁ maximum)

refer to the SGS Tool Wizard for complete technical information ()