HIGH FEED MILL RECOMMENDATIONS

DEPTH OF CUT (DOC) IN "Z" FOR PART NUMBERS ENDING IN "A"						
"D" MAJOR DIAMETER	.120	.177	.240	.300	.360	.485
DOC IN "Z"	.006	.010	.015	.020	.020	.025

D = MAJOR DIAMETER OF TOOL	**DOC = DEPTH OF CUT**	**RAMPING ANGLE: 1 - 1.5 DEGREES**
REDUCE DOC 20% & FEED PER TOOTH 15% FOR PART # ENDING IN "B"		
REDUCE DOC 40% & FEED PER TOOTH 30% FOR PART # ENDING IN "C"		

FEEDRATE CALCULATOR (IPT = INCHES PER TOOTH)

MATERIALS	MILD STEELS	TOOL STEELS	SOFT CAST IRON	HARD CAST IRON	STAINLESS STEELS	SUPER ALLOY	TITANIUM ALLOYS
SFM	800/1100	450/650	250/450	450/650	300/450	50/175	300/400
SLOTTING IPT	.030 x D	.027 x D	.024 x D	.024 x D	.018 x D	.018 x D	.021 x D

MATERIALS	MILD STEELS	TOOL STEELS	SOFT CAST IRON	HARD CAST IRON	STAINLESS STEELS	SUPER ALLOY	TITANIUM ALLOYS
SFM	800/1100	450/650	250/450	450/650	300/450	50/175	300/400
SIDE MILL IPT	.055 x D	.045 x D	.040 x D	.040 x D	.024 x D	.024 x D	.035 x D
SIDE MILL DOC IN "Z"	1 x DOC	1 x DOC	1 x DOC	1 x DOC	1 x DOC	.5 x DOC	.5 x DOC
SIDE MILL STEP OVER	.5 x D	.5 x D	.5 x D	.5 x D	.5 x D	.5 x D	.5 x D

MATERIALS	MILD STEELS	TOOL STEELS	SOFT CAST IRON	HARD CAST IRON	STAINLESS STEELS	SUPER ALLOY	TITANIUM ALLOYS
SFM	400/800	350/400	150/325	350/450	200/350	50/125	200/300
PLUNGE MILL IPT	.010 x D	.010 x D	.007 x D	.007 x D	.006 x D	.006 x D	.007 x D
PLUNGE MILL STEP OVER	.3 x D	.3 x D	.3 x D	.3 x D	.3 x D	.3 x D	.3 x D