



General Purpose Speeds and Feeds in SFPM



(Surface Feet per Minute)

<u>Aluminum (6061, 2024, 7075)</u>				
SFM	Chipload Per Tooth			
<u>2, 3, & 4 Flute</u>	<u>up to .125 dia.</u>	<u>.125-.250 dia.</u>	<u>.250-.500 dia.</u>	<u>.500-1.0 dia.</u>
300-500	.0008-.0020	0015-.0040	0020-.0060	0030-.0090

<u>Tool Steels <30 RC (4140, 4340, A2, D2, O1, S7, P2,H13)</u>				
SFM	Chipload Per Tooth			
<u>2, 3, & 4 Flute</u>	<u>up to .125 dia.</u>	<u>.125-.250 dia.</u>	<u>.250-.500 dia.</u>	<u>.500-1.0 dia.</u>
150-225	.0005-.0010	0008-.0020	0010-.0030	0020-.0040

<u>Carbon Steels <35 RC (A36, 1000's, 1100's, 1300's)</u>				
SFM	Chipload Per Tooth			
<u>2, 3, & 4 Flute</u>	<u>up to .125 dia.</u>	<u>.125-.250 dia.</u>	<u>.250-.500 dia.</u>	<u>.500-1.0 dia.</u>
175-250	.0006-.0015	0010-.0025	0015-.0040	0020-.0050

The above are recommended starting points for regular flute lengths – adjust for extended flute lengths. your machining set up should always be as rigid as possible.