IPT11/IPC11 Application Guide – Speed & Feed (metric)

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (M/min)	12.0	16.0	20.0
K	Gray ASTM-A48 Class 20, 25, 30, 35 & 40	Peripheral - HEM	≤ 2 x D	.08 x D	11	111	.1272	.1692	.2111
		Peripheral - HEM	> 2 - 3 x D	.07 x D	11	111	.1104	.1468	.1832
		Peripheral - HEM	> 3 - 3.5 x D	.07 x D	11	107	.0960	.1277	.1593
		Peripheral - HEM	> 3.5 - 4 x D	.065 x D	11	107	.0816	.1085	.1354
		Finish	3 x D	.01 x D	11	113	.0528	.0702	.0876
	Cast Iron Malleable	Peripheral - HEM	≤ 2 x D	.07 x D	11	114	.1512	.2011	.2510
		Peripheral - HEM	> 2 - 3 x D	.07 x D	11	114	.1344	.1787	.2231
		Peripheral - HEM	> 3 - 3.5 x D	.07 x D	11	110	.1152	.1532	.1912
		Peripheral - HEM	> 3.5 - 4 x D	.07 x D	11	110	.0960	.1277	.1593
		Finish	3 x D	.01 x D	11	102	.0552	.0734	.0916
P	Low Carbon Steels ≤ 38 Rc 1018, 1020, 12L14, 5120, 8620	Peripheral - HEM	≤ 2 x D	.07 x D	11	168	.1320	.1755	.2191
		Peripheral - HEM	> 2 - 3 x D	.07 x D	11	162	.1152	.1532	.1912
		Peripheral - HEM	> 3 - 3.5 x D	.07 x D	11	157	.1008	.1341	.1673
		Peripheral - HEM	> 3.5 - 4 x D	.07 x D	11	154	.0864	.1149	.1434
		Finish	3 x D	.01 x D	11	145	.0480	.0638	.0797
	Medium Carbon Steels ≤ 48 HRC 1045, 4140, 4340, 5140	Peripheral - HEM	≤ 2 x D	.07 x D	11	162	.1296	.1724	.2151
		Peripheral - HEM	> 2 - 3 x D	.07 x D	11	157	.1128	.1500	.1872
		Peripheral - HEM	> 3 - 3.5 x D	.07 x D	11	152	.0984	.1309	.1633
		Peripheral - HEM	> 3.5 - 4 x D	.07 x D	11	149	.0840	.1117	.1394
		Finish	3 x D	.01 x D	11	139	.0456	.0606	.0757
	Tool and Die Steels ≤ 48 Rc A2, D2, O1, S7, P20, H13	Peripheral - HEM	≤ 2 x D	.06 x D	11	136	.1512	.2011	.2510
		Peripheral - HEM	> 2 - 3 x D	.06 x D	11	131	.1320	.1755	.2191
		Peripheral - HEM	> 3 - 3.5 x D	.06 x D	11	126	.1152	.1532	.1912
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	11	125	.0984	.1309	.1633
		Finish	3 x D	.01 x D	11	117	.0480	.0638	.0797
M	Martensitic & Ferritic Stainless Steels 410, 416, 440	Peripheral - HEM	≤ 2 x D	.06 x D	11	137	.1608	.2138	.2669
		Peripheral - HEM	> 2 - 3 x D	.06 x D	11	137	.1416	.1883	.2350
		Peripheral - HEM	> 3 - 3.5 x D	.06 x D	11	130	.1248	.1660	.2072
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	11	130	.1032	.1372	.1713
		Finish	3 x D	.01 x D	11	119	.0600	.0798	.0996
	Austenitic Stainless Steels, FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral - HEM	≤ 2 x D	.06 x D	11	136	.1632	.2170	.2709
		Peripheral - HEM	> 2 - 3 x D	.06 x D	11	131	.1440	.1915	.2390
		Peripheral - HEM	> 3 - 3.5 x D	.06 x D	11	126	.1296	.1724	.2151
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	11	125	.1056	.1404	.1753
		Finish	3 x D	.01 x D	11	117	.0552	.0734	.0916
	Precipitation Hardening Stainless Steels 17-4, 15-5	Peripheral - HEM	≤ 2 x D	.06 x D	11	133	.1632	.2170	.2709
		Peripheral - HEM	> 2 - 3 x D	.06 x D	11	128	.1440	.1915	.2390
		Peripheral - HEM	> 3 - 3.5 x D	.06 x D	11	123	.1248	.1660	.2072
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	11	122	.1032	.1372	.1713
		Finish	3 x D	.01 x D	11	114	.0528	.0702	.0876
S	Titanium Alloys 6Al-4V, 6-2-4	Peripheral - HEM	≤ 2 x D	.06 x D	11	130	.1440	.1915	.2390
		Peripheral - HEM	> 2 - 3 x D	.06 x D	11	126	.1032	.1372	.1713
		Peripheral - HEM	> 3 - 3.5 x D	.06 x D	11	120	.1008	.1341	.1673
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	11	120	.0936	.1245	.1554
		Finish	3 x D	.015 x D	11	113	.0552	.0734	.0916
	Difficult-to-Machine Titanium Alloys 10-2-3 Precipitation Hardening Stainless Steel M 13-8	Peripheral - HEM	≤ 2 x D	0.06 x D	11	107	.1416	.1883	.2350
		Peripheral - HEM	> 2 - 3 x D	0.06 x D	11	101	.1008	.1341	.1673
		Peripheral - HEM	> 3 - 3.5 x D	0.055 x D	11	96	.0984	.1309	.1633
		Peripheral - HEM	> 3.5 - 4 x D	0.05 x D	11	94	.0912	.1213	.1514
		Finish	3 x D	.01 x D	11	91	.0480	.0638	.0797
	Hastalloy, Waspalloy	Peripheral - HEM	≤ 2 x D	.07 X D	11	32	.2160	.2873	.3585
		Peripheral - HEM	> 2 - 3 x D	.065 x D	11	30	.1944	.2585	.3227
		Peripheral - HEM	> 3 - 3.5 x D	.055 x D	11	27	.1728	.2298	.2868
		Peripheral - HEM	> 3.5 - 4 x D	.055 x D	11	27	.1555	.2068	.2581
		Finish	3 x D	.01 x D	11	27	.1128	.1500	.1872
	Inconel 718, Rene 88	Peripheral - HEM	≤ 2 x D	.065 x D	11	30	.1488	.1979	.2470
		Peripheral - HEM	> 2 - 3 x D	.06 x D	11	29	.1440	.1915	.2390
		Peripheral - HEM	> 3 - 3.5 x D	.05 x D	11	29	.1440	.1915	.2390
		Peripheral - HEM	> 3.5 - 4 x D	.05 x D	11	29	.1248	.1660	.2072
		Finish	3 x D	.01 x D	11	27	.0768	.1021	.1275

D = Tool Diameter HEM = High-efficiency machining (chip thinning calculations have already been applied to HEM parameters)

Information on tips and adjustments can be found in our Technical Resources section beginning on page 129.