ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (SFM)	Feed (Inches per Tooth)									
							1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
K	Cast Iron Gray ASTM-A48 Class 20, 25, 30, 35 & 40	Slotting	.5 x D	1 x D	5	300	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0048
		Peripheral - Rough	1.25 x D	.3 x D	5	375	.0008	.0012	.0016	.0020	.0025	.0029	.0033	.0041	.0049	.0065
		Finish	2 x D	.015 x D	5	375	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0067
	Cast Iron Malleable	Slotting	.5 x D	1 x D	5	275	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0040
		Peripheral - Rough	1.25 x D	.3 x D	5	350	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0055
		Peripheral - HEM*	3 x D	.05 x D	5	390	.0020	.0030	.0040	.0050	.0060	.0070	.0081	.0101	.0121	.0161
		Finish	2 x D	.015 x D	5	350	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0056
P	Low Carbon Steels ≤ 38 Rc 1018, 1020, 12L14, 5120, 8620	Slotting	.5 x D	1 x D	5	325	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0056
		Peripheral - Rough	1.25 x D	.3 x D	5	400	.0010	.0014	.0019	.0024	.0029	.0033	.0038	.0048	.0057	.0076
		Peripheral - HEM*	3 x D	.07 x D	5	450	.0028	.0042	.0056	.0070	.0084	.0098	.0112	.0140	.0168	.0224
		Finish	2 x D	.015 x D	5	400	.0010	.0015	.0019	.0024	.0029	.0034	.0039	.0049	.0058	.0078
	Medium Carbon Steels ≤ 48 HRC 1045, 4140, 4340, 5140	Slotting	.5 x D	1 x D	5	300	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0051
		Peripheral - Rough	1.25 x D	.3 x D	5	375	.0009	.0013	.0017	.0022	.0026	.0031	.0035	.0044	.0052	.0070
		Peripheral - HEM*	3 x D	.05 x D	5	415	.0026	.0039	.0052	.0065	.0077	.0090	.0103	.0129	.0155	.0207
		Finish	2 x D	.015 x D	5	375	.0009	.0013	.0018	.0022	.0027	.0031	.0036	.0044	.0053	.0071
	Tool and Die Steels ≤ 48 Rc A2, D2, O1, S7, P20, H13	Slotting	.5 x D	1 x D	5	275	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0032	.0043
		Peripheral - Rough	1.25 x D	.3 x D	5	350	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0059
		Peripheral - HEM*	3 x D	.05 x D	5	390	.0022	.0032	.0043	.0054	.0065	.0076	.0087	.0108	.0130	.0173
		Finish	2 x D	.015 x D	5	350	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0060
M	Martensitic & Ferritic Stainless Steels 410, 416, 440	Slotting	.5 x D	1 x D	5	300	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0051
		Peripheral - Rough	1.25 x D	.3 x D	5	375	.0009	.0013	.0017	.0022	.0026	.0031	.0035	.0044	.0052	.0070
		Peripheral - HEM*	3 x D	.05 x D	5	415	.0026	.0039	.0052	.0065	.0077	.0090	.0103	.0129	.0155	.0207
		Finish	2 x D	.015 x D	5	375	.0009	.0013	.0018	.0022	.0027	.0031	.0036	.0044	.0053	.0071
	Austenitic Stainless Steels, FeNi Alloys 303, 304, 316, Invar, Kovar	Slotting	.5 x D	1 x D	5	275	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0048
		Peripheral - Rough	1.25 x D	.3 x D	5	350	.0008	.0012	.0016	.0020	.0025	.0029	.0033	.0041	.0049	.0065
		Peripheral - HEM*	3 x D	.05 x D	5	390	.0025	.0037	.0049	.0062	.0074	.0086	.0099	.0123	.0148	.0198
		Finish	2 x D	.015 x D	5	350	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0067
	Precipitation Hardening Stainless Steels 17-4, 15-5	Slotting	.5 x D	1 x D	5	250	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0040
		Peripheral - Rough	1.25 x D	.3 x D	5	325	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0055
		Peripheral - HEM*	3 x D	.05 x D	5	360	.0020	.0030	.0040	.0049	.0059	.0069	.0079	.0099	.0119	.0158
		Finish	1.5 x D	.015 x D	5	325	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0056
S	Titanium Alloys 6Al-4V, 6-2-4	Slotting	.5 x D	1 x D	5	250	.0005	.0007	.0009	.0012	.0014	.0016	.0018	.0023	.0028	.0037
		Peripheral - Rough	1 x D	.3 x D	5	300	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0050
		Peripheral - HEM*	3 x D	.05 x D	5	330	.0018	.0027	.0036	.0046	.0055	.0064	.0073	.0091	.0109	.0146
		Finish	1.5 x D	.015 x D	5	300	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0051
	Difficult-to-Machine Titanium Alloys 10-2-3 Precipitation Hardening Stainless Steels **M** 13-8	Slotting	.25 x D	1 x D	5	200	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0020	.0027
		Peripheral - Rough	1 x D	.25 x D	5	250	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0029	.0039
		Peripheral - HEM*	3 x D	.05 x D	5	275	.0015	.0022	.0030	.0037	.0045	.0052	.0059	.0074	.0089	.0119
		Finish	1.5 x D	.01 x D	5	250	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0046

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

≈ Approximately Equals   < Less Than
≤ Less Than or Equal To   > Greater Than
≥ Greater Than or Equal To   = Equals
× Multiply

Common Machining Formulas

$$RPM = \frac{SFM \times 3.82}{D}$$

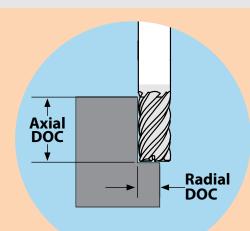$$SFM = RPM \times D \times .262$$

$$IPM = RPM \times IPT \times Z$$

$$MRR = RDOC \times ADOC \times IPM$$

$$RPM = \frac{M/min \times 318.3}{D}$$

$$M/min = RPM \times D \times .00314$$

$$MMPM = RPM \times MMPT \times Z$$

$$MRR = RDOC \times ADOC \times MMPM$$

Axial DOC

Radial DOC