M527 Application Guide – Speed & Feed (metric)

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (M/min)	Feed (MM per Tooth) 10.0	12.0	16.0	20.0	25.0
K	Cast Iron Gray	Slotting	.5 x D	1 x D	7	91	.0353	.0425	.0566	.0706	.0886
		Peripheral - Rough	1.25 x D	.3 x D	7	114	.0467	.0563	.0749	.0935	.1173
		Finish	2 x D	.015 x D	7	137	.0476	.0573	.0762	.0951	.1194
	Cast Iron	Slotting	.5 x D	1 x D	7	84	.0285	.0343	.0456	.0569	.0714
		Peripheral - Rough	1.25 x D	.3 x D	7	107	.0388	.0468	.0622	.0776	.0974
		Peripheral - HEM*	3 x D	.05 x D	7	119	.1133	.1365	.1816	.2266	.2844
		Finish	2 x D	.015 x D	7	107	.0395	.0476	.0633	.0790	.0992
P	Low Carbon Steels ≤ 38 Rc 1018, 1020, 12L14, 5120, 8620	Slotting	.5 x D	1 x D	7	99	.0398	.0480	.0638	.0797	.1000
		Peripheral - Rough	1.25 x D	.3 x D	7	122	.0543	.0655	.0871	.1087	.1364
		Peripheral - HEM*	3 x D	.05 x D	7	137	.1743	.2100	.2793	.3486	.4375
		Finish	2 x D	.015 x D	7	122	.0553	.0666	.0886	.1106	.1388
	Medium Carbon Steels ≤ 48 HRC 1045, 4140, 4340, 5140	Slotting	.5 x D	1 x D	7	91	.0364	.0439	.0584	.0729	.0914
		Peripheral - Rough	1.25 x D	.3 x D	7	114	.0497	.0599	.0796	.0994	.1247
		Peripheral - HEM*	3 x D	.05 x D	7	126	.1708	.2058	.2737	.3417	.4288
		Finish	2 x D	.015 x D	7	114	.0506	.0609	.0810	.1011	.1269
	Tool and Die Steels ≤ 48 Rc A2, D2, O1, S7, P20, H13	Slotting	.5 x D	1 x D	7	84	.0307	.0370	.0493	.0615	.0772
		Peripheral - Rough	1.25 x D	.3 x D	7	107	.0419	.0505	.0672	.0838	.1052
		Peripheral - HEM*	3 x D	.05 x D	7	119	.1464	.1764	.2346	.2929	.3675
		Finish	2 x D	.015 x D	7	107	.0427	.0514	.0684	.0853	.1071
M	Martensitic & Ferritic Stainless Steels 410, 416, 440	Slotting	.5 x D	1 x D	7	91	.0364	.0439	.0584	.0729	.0914
		Peripheral - Rough	1.25 x D	.3 x D	7	114	.0497	.0599	.0796	.0994	.1247
		Peripheral - HEM*	3 x D	.05 x D	7	126	.1708	.2058	.2737	.3417	.4288
		Finish	2 x D	.015 x D	7	114	.0506	.0609	.0810	.1011	.1269
	Austenitic Stainless Steels, FeNi Alloys 303, 304, 316, Invar, Kovar	Slotting	.5 x D	1 x D	7	84	.0341	.0411	.0547	.0683	.0857
		Peripheral - Rough	1.25 x D	.3 x D	7	107	.0466	.0561	.0746	.0931	.1169
		Peripheral - HEM*	3 x D	.05 x D	7	119	.1660	.2000	.2660	.3320	.4166
		Finish	2 x D	.015 x D	7	107	.0474	.0571	.0760	.0948	.1190
	Precipitation Hardening Stainless Steels 17-4, 15-5	Slotting	.5 x D	1 x D	7	76	.0285	.0343	.0456	.0569	.0714
		Peripheral - Rough	1.25 x D	.3 x D	7	99	.0388	.0468	.0622	.0776	.0974
		Peripheral - HEM*	3 x D	.05 x D	7	110	.1328	.1600	.2128	.2656	.3333
		Finish	1.5 x D	.015 x D	7	99	.0395	.0476	.0633	.0790	.0992
S	Titanium Alloys 6Al-4V, 6-2-4	Slotting	.5 x D	1 x D	7	76	.0262	.0315	.0420	.0524	.0657
		Peripheral - Rough	1 x D	.3 x D	7	91	.0357	.0430	.0572	.0714	.0896
		Peripheral - HEM*	3 x D	.05 x D	7	101	.1257	.1515	.2015	.2515	.3156
		Finish	1.5 x D	.015 x D	7	91	.0363	.0438	.0582	.0727	.0912
	Difficult-to-Machine Titanium Alloys 10-2-3 Precipitation Hardening Stainless Steels M 13-8	Slotting	.25 x D	1 x D	7	61	.0193	.0233	.0310	.0387	.0486
		Peripheral - Rough	1 x D	.25 x D	7	76	.0279	.0336	.0447	.0558	.0701
		Peripheral - HEM*	3 x D	.05 x D	7	84	.0975	.1175	.1563	.1950	.2448
		Finish	1.5 x D	.01 x D	7	76	.0328	.0395	.0526	.0656	.0824

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

D Tool Diameter
Z Number of Flutes
RPM Revolutions per Minute
SFM Surface Feet per Minute
M/min Surface Meters per Minute
IPM Inches per Minute
MMPM Millimeters per Minute
IPT Inch per Tooth
MMPT Millimeters per Tooth
MRR Metal Removal Rate
RDOC Radial Depth of Cut
ADOC Axial Depth of Cut

Technical Resources

Information on tips and adjustments for the following milling operations can be found in our Technical Resources section beginning on page 129.

- HEM slotting
- Face milling
- Helical entry ramping
- Straight line ramping
- Long tool projection adjustments
- Ball nose milling adjustments
- Other helpful tips and calculations