

AFC5/IFC5 Application Guide – Speed & Feed (inch)

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ISO Code	Work Material	Type of Cut	Tool LC/Dia.	Axial DOC	Radial DOC	No. of Flutes	Speed (SFM)	Feed (Inch per Tooth)			
								1/2	5/8	3/4	1
N	Aluminum Alloys 6061, 7075, 2024	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	425	.0021	.0026	.0032	.0042
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	350	.0017	.0022	.0026	.0035

D = Tool Diameter

IFC5 Application Guide – Speed & Feed (inch)

ISO Code	Work Material	Type of Cut	Tool LC/Dia.	Axial DOC	Radial DOC	No. of Flutes	Speed (SFM)	Feed (Inch per Tooth)				
								1/2	5/8	3/4	1	
K	Cast Iron - Gray ASTM - A48, Class 20, 25, 30, 35 & 40	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	290	.0017	.0021	.0026	.0034	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	235	.0014	.0017	.0021	.0028	
	Cast Iron - Malleable	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	275	.0017	.0021	.0026	.0034	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	220	.0014	.0017	.0020	.0027	
P	Low Carbon Steel ≤ 38 HRC 1018, 1020, 12L14, 5120, 8620	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	300	.0018	.0023	.0027	.0036	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	240	.0014	.0018	.0022	.0029	
	Medium Carbon Steel ≤ 48 HRC 1045, 4140, 4340, 5140	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	290	.0017	.0021	.0026	.0034	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	235	.0014	.0017	.0021	.0028	
	Tool & Die Steels ≤ 40 HRC A2, D2, O1, S7, P20, H13	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	275	.0016	.0020	.0024	.0032	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	220	.0013	.0016	.0019	.0026	
	M	Martensitic & Ferritic Stainless Steels 410, 416, 440	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	280	.0017	.0021	.0026	.0034
			Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	227	.0014	.0017	.0021	.0028
Austenitic Stainless Steels 303, 304, 316, Invar, Kovar		Peripheral - Finish	3 - 4	4 x D	.01 x D	5	275	.0016	.0020	.0024	.0032	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	220	.0013	.0016	.0019	.0026	
Precipitation Hardening Stainless Steel 17-4, 15-5, 13-8		Peripheral - Finish	3 - 4	4 x D	.01 x D	5	255	.0015	.0019	.0023	.0030	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	204	.0012	.0015	.0018	.0024	
S	Titanium Alloys 6AL-4V, 6-2-4	Peripheral - Finish	3 - 4	4 x D	.01 x D	5	320	.0018	.0023	.0027	.0036	
		Peripheral - Finish	< 4 - 6	6 x D	.01 x D	5	256	.0014	.0018	.0022	.0029	

D = Tool Diameter

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

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

TOOL TIP

AFC5/IFC5



- **BIG CORE.**
- **LITTLE DEFLECTION.**
- **MINIMAL WALL TAPER IN DEEP REACH APPLICATIONS.**

