

M936 POW-R-FEED

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (IPT)												
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
K	1a) Cast Iron- Gray ASTM-A48 Class 20, 25,30,35 & 40	Peripheral -Rough	1.5 x D	.3 x D	352	.00071	.00107	.0014	.0018	.0021	.0025	.0029	.0036	.0043	.0050	.0057	.0064	.0071
		Peripheral -Finish	3 x D	.015 x D	356	.00069	.00103	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Peripheral -HEM	3 x D	.08 x D	361	.00166	.00249	.0033	.0042	.0050	.0058	.0067	.0083	.0100	.0116	.0133	.0150	.0166
		Slotting -Traditional	.625 x D	1 x D	285	.00050	.00075	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Rough Facing	.375 x D	.7 x D	387	.00064	.00096	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
		Finish Facing	.020 x D	.7 x D	374	.00063	.00095	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0051	.0057	.0063
		Helical Entry	3 x D	18 deg	309	.00040	.00060	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0040
		Straight Line Ramp	.630 x D	11 deg	285	.00046	.00069	.0009	.0011	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Zig Zag Pocket	.625 x D	.625 x D	285	.00050	.00075	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
	1b) Cast Iron- Gray ASTM-A48 26-48 HRc Class 20, 25,30,35 & 40	Peripheral -Rough	1.5 x D	.25 x D	333	.00068	.00101	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0047	.0054	.0061	.0068
		Peripheral -Finish	3 x D	.01 x D	338	.00065	.00098	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0052	.0059	.0065
		Peripheral -HEM	3 x D	.07 x D	342	.00158	.00236	.0032	.0039	.0047	.0055	.0063	.0079	.0095	.0110	.0126	.0142	.0158
		Slotting -Traditional	.5 x D	1 x D	270	.00047	.00071	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
		Rough Facing	.35 x D	.65 x D	354	.00061	.00091	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Finish Facing	.020 x D	.65 x D	354	.00057	.00086	.0011	.0014	.0017	.0020	.0023	.0029	.0034	.0040	.0046	.0051	.0057
		Helical Entry	2 x D	12 deg	292	.00037	.00055	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0029	.0033	.0037
		Straight Line Ramp	.5 x D	10 deg	270	.00046	.00069	.0009	.0011	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Zig Zag Pocket	.5 x D	.55 x D	270	.00047	.00071	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
	2a) Cast Iron- Ductile 15-25 HRc	Peripheral -Rough	1.5 x D	.32 x D	333	.00067	.00100	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Peripheral -Finish	3 x D	.015 x D	333	.00062	.00093	.0012	.0015	.0019	.0022	.0025	.0031	.0037	.0043	.0049	.0056	.0062
		Peripheral -HEM	3 x D	.08 x D	371	.00178	.00267	.0036	.0045	.0053	.0062	.0071	.0089	.0107	.0125	.0143	.0160	.0178
		Slotting -Traditional	.625 x D	1 x D	247	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Rough Facing	.375 x D	.7 x D	366	.00060	.00090	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Finish Facing	.020 x D	.7 x D	349	.00057	.00085	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0045	.0051	.0057
		Helical Entry	3 x D	20 deg	275	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Straight Line Ramp	.63 x D	14 deg	247	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Zig Zag Pocket	.625 x D	.625 x D	247	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
	2b) Cast Iron- Ductile 26-48 HRc	Peripheral -Rough	1.5 x D	.3 x D	315	.00063	.00095	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0050	.0057	.0063
Peripheral -Finish		3 x D	.01 x D	315	.00061	.00091	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061	
Peripheral -HEM		3 x D	.07 x D	351	.00169	.00253	.0034	.0042	.0051	.0059	.0068	.0084	.0101	.0118	.0135	.0152	.0169	
Slotting -Traditional		.5 x D	1 x D	234	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
Rough Facing		.35 x D	.65 x D	347	.00057	.00085	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0045	.0051	.0057	
Finish Facing		.02 x D	.65 x D	331	.00051	.00077	.0010	.0013	.0015	.0018	.0020	.0026	.0031	.0036	.0041	.0046	.0051	
Helical Entry		3 x D	18 deg	260	.00042	.00062	.0008	.0010	.0012	.0015	.0017	.0021	.0025	.0029	.0033	.0037	.0042	
Straight Line Ramp		.5 x D	13 deg	234	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
Zig Zag Pocket		.5 x D	.55 x D	234	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
3a) Cast Iron- Malleable 15-25 HRc	Peripheral -Rough	1.5 x D	.32 x D	333	.00064	.00096	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064	
	Peripheral -Finish	3 x D	.015 x D	333	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059	
	Peripheral -HEM	3 x D	.08 x D	371	.00176	.00264	.0035	.0044	.0053	.0062	.0070	.0088	.0105	.0123	.0141	.0158	.0176	
	Slotting -Traditional	.625 x D	1 x D	252	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
	Rough Facing	.375 x D	.7 x D	366	.00058	.00087	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058	
	Finish Facing	.02 x D	.7 x D	349	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055	
	Helical Entry	3 x D	20 deg	270	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
	Straight Line Ramp	.63 x D	14 deg	252	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	
	Zig Zag Pocket	.625 x D	.625 x D	252	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	

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						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
K	3b) Cast Iron- Malleable 26-48 HRC	Peripheral -Rough	1.5 x D	.3 x D	315	.00061	.00091	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Peripheral -Finish	3 x D	.01 x D	315	.00059	.00088	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059
		Peripheral -HEM	3 x D	.07 x D	351	.00167	.00250	.0033	.0042	.0050	.0058	.0067	.0083	.0100	.0117	.0133	.0150	.0167
		Slotting -Traditional	.5 x D	1 x D	239	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	347	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Finish Facing	.02 x D	.65 x D	331	.00049	.00074	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0034	.0039	.0044	.0049
		Helical Entry	3 x D	18 deg	256	.00039	.00059	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0035	.0039
		Straight Line Ramp	.5 x D	13 deg	239	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Zig Zag Pocket	.5 x D	.55 x D	239	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
P	1a) Low Carbon Steel ≤38 HRC 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	2 x D	.55 x D	361	.00081	.00121	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -Finish	3 x D	.015 x D	380	.00088	.00132	.0018	.0022	.0026	.0031	.0035	.0044	.0053	.0062	.0070	.0079	.0088
		Peripheral -HEM	3 x D	.09 x D	418	.00154	.00232	.0031	.0039	.0046	.0054	.0062	.0077	.0093	.0108	.0124	.0139	.0154
		Slotting -Traditional	1 x D	1 x D	309	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Rough Facing	.375 x D	.7 x D	397	.00073	.00109	.0015	.0018	.0022	.0025	.0029	.0036	.0044	.0051	.0058	.0065	.0073
		Finish Facing	.02 x D	.7 x D	399	.00085	.00128	.0017	.0021	.0026	.0030	.0034	.0043	.0051	.0060	.0068	.0077	.0085
		Helical Entry	3 x D	25 deg	371	.00046	.00069	.0009	.0012	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Straight Line Ramp	1 x D	20 deg	380	.00038	.00056	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038
		Zig Zag Pocket	1 x D	.625 x D	309	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
	1b) Low Carbon Steel 39-53 HRC 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	1.5 x D	.52 x D	342	.00077	.00115	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Peripheral -Finish	3 x D	.012 x D	360	.00083	.00125	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Peripheral -HEM	3 x D	.07 x D	396	.00146	.00219	.0029	.0037	.0044	.0051	.0059	.0073	.0088	.0102	.0117	.0132	.0146
		Slotting -Traditional	.75 x D	1 x D	293	.00056	.00084	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Rough Facing	.35 x D	.65 x D	376	.00069	.00103	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Finish Facing	.02 x D	.65 x D	378	.00077	.00115	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0062	.0069	.0077
		Helical Entry	3 x D	20 deg	350	.00042	.00064	.0008	.0011	.0013	.0015	.0017	.0021	.0025	.0030	.0034	.0038	.0042
		Straight Line Ramp	.75 x D	18 deg	360	.00038	.00056	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038
		Zig Zag Pocket	.75 x D	.55 x D	293	.00056	.00084	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
	2a) Medium Carbon Steel ≤40 HRC 1045, 4140, 4340, 5140	Peripheral -Rough	2 x D	.55 x D	356	.00076	.00114	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Peripheral -Finish	3 x D	.015 x D	356	.00081	.00121	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -HEM	3 x D	.09 x D	380	.00138	.00207	.0028	.0034	.0041	.0048	.0055	.0069	.0083	.0096	.0110	.0124	.0138
		Slotting -Traditional	1 x D	1 x D	285	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Rough Facing	.375 x D	.7 x D	392	.00068	.00103	.0014	.0017	.0021	.0024	.0027	.0034	.0041	.0048	.0055	.0062	.0068
		Finish Facing	.02 x D	.7 x D	374	.00078	.00117	.0016	.0020	.0023	.0027	.0031	.0039	.0047	.0055	.0063	.0070	.0078
Helical Entry		3 x D	25 deg	356	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0025	.0029	.0033	.0037	.0041	
Straight Line Ramp		1 x D	20 deg	380	.00035	.00052	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035	
Zig Zag Pocket		1 x D	.625 x D	285	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055	
2b) Medium Carbon Steel 41-48 HRC 1045, 4140, 4340, 5140	Peripheral -Rough	1.5 x D	.52 x D	338	.00072	.00108	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072	
	Peripheral -Finish	3 x D	.012 x D	338	.00077	.00115	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077	
	Peripheral -HEM	3 x D	.07 x D	315	.00131	.00196	.0026	.0033	.0039	.0046	.0052	.0065	.0078	.0091	.0104	.0117	.0131	
	Slotting -Traditional	.75 x D	1 x D	270	.00052	.00078	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052	
	Rough Facing	.35 x D	.65 x D	371	.00065	.00097	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0065	
	Finish Facing	.02 x D	.65 x D	354	.00071	.00106	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0057	.0064	.0071	
	Helical Entry	3 x D	20 deg	338	.00038	.00057	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038	
	Straight Line Ramp	.75 x D	18 deg	351	.00035	.00052	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035	
	Zig Zag Pocket	.75 x D	.55 x D	270	.00052	.00078	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052	

M936 POW-R-FEED

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						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
P	3a) Tool & Die Steels ≤34 HRc A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.5 x D	.52 x D	333	.00064	.00096	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
		Peripheral -Finish	3 x D	.015 x D	333	.00069	.00103	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Peripheral -HEM	3 x D	.08 x D	371	.00114	.00171	.0023	.0029	.0034	.0040	.0046	.0057	.0068	.0080	.0091	.0103	.0114
		Slotting -Traditional	.75 x D	1 x D	261	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Rough Facing	.375 x D	.7 x D	366	.00058	.00087	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058
		Finish Facing	.02 x D	.7 x D	349	.00067	.00100	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Helical Entry	3 x D	18 deg	285	.00036	.00054	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
		Straight Line Ramp	.75 x D	18 deg	333	.00030	.00045	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0027	.0030
	Zig Zag Pocket	.75 x D	.625 x D	261	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045	
	3b) Tool & Die Steels 35-42 HRc A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.25 x D	.4 x D	315	.00060	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Peripheral -Finish	3 x D	.012 x D	315	.00065	.00098	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0052	.0059	.0065
		Peripheral -HEM	3 x D	.07 x D	347	.00108	.00162	.0022	.0027	.0032	.0038	.0043	.0054	.0065	.0076	.0086	.0097	.0108
		Slotting -Traditional	.625 x D	1 x D	248	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.35 x D	.65 x D	347	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
Finish Facing		.02 x D	.65 x D	331	.00060	.00090	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060	
Helical Entry		2 x D	12 deg	270	.00033	.00050	.0007	.0008	.0010	.0012	.0013	.0017	.0020	.0023	.0027	.0030	.0033	
Straight Line Ramp		.63 x D	16 deg	285	.00030	.00045	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0027	.0030	
Zig Zag Pocket	.625 x D	.55 x D	248	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043		
H	1a) Tool & Die Steels 40-48- HRc	Peripheral -Rough	1 x D	.25 x D	290	.00048	.00071	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0033	.0038	.0043	.0048
		Peripheral -Finish	3 x D	.01 x D	285	.00050	.00075	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Peripheral -HEM	3 x D	.05 x D	337	.00132	.00197	.0026	.0033	.0039	.0046	.0053	.0066	.0079	.0092	.0105	.0118	.0132
		Slotting -Traditional	.45 x D	1 x D	238	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Rough Facing	.35 x D	.65 x D	319	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Finish Facing	.02 x D	.65 x D	298	.00045	.00067	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Helical Entry	.88 x D	12 deg	238	.00035	.00052	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035
		Straight Line Ramp	.5 x D	8 deg	257	.00024	.00037	.0005	.0006	.0007	.0009	.0010	.0012	.0015	.0017	.0020	.0022	.0024
Zig Zag Pocket	.45 x D	.4 x D	238	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045		
M	1a) Martensitic & Ferritic Stainless Steels 15-29 HRc 410, 416, 440	Peripheral -Rough	2.5 x D	.3 x D	347	.00072	.00108	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072
		Peripheral -Finish	3 x D	.015 x D	356	.00081	.00121	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -HEM	3 x D	.2 x D	380	.00102	.00153	.0020	.0026	.0031	.0036	.0041	.0051	.0061	.0071	.0082	.0092	.0102
		Slotting -Traditional	1 x D	1 x D	261	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	381	.00068	.00103	.0014	.0017	.0021	.0024	.0027	.0034	.0041	.0048	.0055	.0062	.0068
		Finish Facing	.02 x D	.7 x D	374	.00069	.00103	.0014	.0017	.0021	.0024	.0027	.0034	.0041	.0048	.0055	.0062	.0069
		Helical Entry	3 x D	7 deg	314	.00027	.00041	.0005	.0007	.0008	.0010	.0011	.0014	.0016	.0019	.0022	.0025	.0027
		Straight Line Ramp	.75 x D	5 deg	261	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
	Zig Zag Pocket	1 x D	.625 x D	261	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
	1b) Martensitic & Ferritic Stainless Steels 30-48 HRc 410, 416, 440	Peripheral -Rough	2.25 x D	.25 x D	329	.00072	.00108	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072
		Peripheral -Finish	3 x D	.012 x D	338	.00077	.00115	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Peripheral -HEM	3 x D	.2 x D	360	.00097	.00145	.0019	.0024	.0029	.0034	.0039	.0048	.0058	.0068	.0077	.0087	.0097
		Slotting -Traditional	.75 x D	1 x D	248	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	361	.00065	.00097	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0065
Finish Facing		.02 x D	.65 x D	345	.00063	.00095	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0051	.0057	.0063	
Helical Entry		3 x D	7 deg	297	.00024	.00035	.0005	.0006	.0007	.0008	.0009	.0012	.0014	.0017	.0019	.0021	.0024	
Straight Line Ramp		.63 x D	4 deg	248	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038	
Zig Zag Pocket	.75 x D	.55 x D	248	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041		

M936 POW-R-FEED

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (IPT)												
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
M	2a) Austenitic Stainless Steels 15-29 HRC FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	2 x D	.3 x D	365	.00083	.00125	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Peripheral -Finish	3 x D	.015 x D	333	.00074	.00110	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074
		Peripheral -HEM	3 x D	.2 x D	375	.00100	.00150	.0020	.0025	.0030	.0035	.0040	.0050	.0060	.0070	.0080	.0090	.0100
		Slotting -Traditional	1.25 x D	1 x D	261	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	381	.00075	.00112	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0052	.0060	.0067	.0075
		Finish Facing	.02 x D	.7 x D	349	.00064	.00097	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0064
		Helical Entry	3 x D	7 deg	308	.00026	.00039	.0005	.0007	.0008	.0009	.0010	.0013	.0016	.0018	.0021	.0023	.0026
		Straight Line Ramp	.75 x D	5 deg	270	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Zig Zag Pocket	1.25 x D	.625 x D	261	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
	2b) Austenitic Stainless Steels 30-48 HRC FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	2 x D	.25 x D	356	.00074	.00112	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0052	.0060	.0067	.0074
		Peripheral -Finish	3 x D	.012 x D	315	.00070	.00105	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Peripheral -HEM	3 x D	.2 x D	356	.00095	.00142	.0019	.0024	.0028	.0033	.0038	.0047	.0057	.0066	.0076	.0085	.0095
		Slotting -Traditional	.75 x D	1 x D	248	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	361	.00071	.00106	.0014	.0018	.0021	.0025	.0028	.0035	.0043	.0050	.0057	.0064	.0071
		Finish Facing	.02 x D	.65 x D	331	.00058	.00086	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058
		Helical Entry	3 x D	7 deg	292	.00024	.00036	.0005	.0006	.0007	.0008	.0010	.0012	.0014	.0017	.0019	.0022	.0024
		Straight Line Ramp	.63 x D	4 deg	248	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Zig Zag Pocket	.75 x D	.55 x D	248	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
	3a) Precipitation Hardening Stainless Steel 15-38 HRC 17-4, 15-5, 13-8	Peripheral -Rough	2 x D	.28 x D	351	.00067	.00101	.0013	.0017	.0020	.0023	.0027	.0034	.0040	.0047	.0054	.0060	.0067
		Peripheral -Finish	3 x D	.015 x D	309	.00062	.00093	.0012	.0015	.0019	.0022	.0025	.0031	.0037	.0043	.0049	.0056	.0062
		Peripheral -HEM	3 x D	.2 x D	347	.00083	.00125	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Slotting -Traditional	.75 x D	1 x D	238	.00040	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0040
		Rough Facing	.375 x D	.7 x D	376	.00062	.00093	.0012	.0015	.0019	.0022	.0025	.0031	.0037	.0043	.0050	.0056	.0062
		Finish Facing	.02 x D	.7 x D	324	.00054	.00081	.0011	.0014	.0016	.0019	.0022	.0027	.0032	.0038	.0043	.0049	.0054
		Helical Entry	3 x D	7 deg	285	.00025	.00037	.0005	.0006	.0007	.0009	.0010	.0012	.0015	.0017	.0020	.0022	.0025
		Straight Line Ramp	.63 x D	5 deg	243	.00035	.00053	.0007	.0009	.0011	.0012	.0014	.0018	.0021	.0025	.0028	.0032	.0035
		Zig Zag Pocket	.75 x D	.625 x D	238	.00040	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0040
	3b) Precipitation Hardening Stainless Steel 39-47 HRC 17-4, 15-5, 13-8	Peripheral -Rough	2 x D	.28 x D	337	.00061	.00092	.0012	.0015	.0018	.0021	.0025	.0031	.0037	.0043	.0049	.0055	.0061
Peripheral -Finish		3 x D	.012 x D	293	.00059	.00088	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059	
Peripheral -HEM		3 x D	.18 x D	329	.00079	.00118	.0016	.0020	.0024	.0028	.0032	.0039	.0047	.0055	.0063	.0071	.0079	
Slotting -Traditional		.625 x D	1 x D	225	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038	
Rough Facing		.35 x D	.65 x D	356	.00057	.00085	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0045	.0051	.0057	
Finish Facing		.02 x D	.65 x D	316	.00051	.00077	.0010	.0013	.0015	.0018	.0020	.0026	.0031	.0036	.0041	.0046	.0051	
Helical Entry		3 x D	6 deg	270	.00023	.00034	.0005	.0006	.0007	.0008	.0009	.0011	.0014	.0016	.0018	.0021	.0023	
Straight Line Ramp		.5 x D	4 deg	225	.00036	.00054	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0033	.0036	
Zig Zag Pocket		.625 x D	.55 x D	225	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038	
S	1a) Titanium Alloys 6AL-4V, 6-2-4 18-31 HRC	Peripheral -Rough	2 x D	.3 x D	261	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Peripheral -Finish	3 x D	.015 x D	285	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Peripheral -HEM	3 x D	.25 x D	390	.00095	.00143	.0019	.0024	.0029	.0033	.0038	.0048	.0057	.0067	.0076	.0086	.0095
		Slotting -Traditional	1 x D	1 x D	238	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	287	.00053	.00080	.0011	.0013	.0016	.0019	.0021	.0027	.0032	.0037	.0043	.0048	.0053
		Finish Facing	.02 x D	.7 x D	314	.00053	.00080	.0011	.0013	.0016	.0019	.0021	.0027	.0032	.0037	.0043	.0048	.0053
		Helical Entry	3 x D	20 deg	380	.00033	.00050	.0007	.0008	.0010	.0012	.0013	.0017	.0020	.0023	.0026	.0030	.0033
		Straight Line Ramp	1 x D	25 deg.	380	.00037	.00056	.0007	.0009	.0011	.0013	.0015	.0019	.0022	.0026	.0030	.0033	.0037
		Zig Zag Pocket	1 x D	.625 x D	238	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043

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ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (IPT)												
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
S	1b) Titanium Alloys 6AL-4V, 6-2-4 32-46 HRc	Peripheral -Rough	1.5 x D	.25 x D	248	.00056	.00084	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Peripheral -Finish	3 x D	.012 x D	270	.00056	.00084	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Peripheral -HEM	3 x D	.2 x D	365	.00090	.00135	.0018	.0023	.0027	.0032	.0036	.0045	.0054	.0063	.0072	.0081	.0090
		Slotting -Traditional	.75 x D	1 x D	225	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	272	.00051	.00076	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0035	.0041	.0046	.0051
		Finish Facing	.02 x D	.65 x D	290	.00049	.00074	.0010	.0012	.0015	.0017	.0020	.0025	.0029	.0034	.0039	.0044	.0049
		Helical Entry	3 x D	18 deg	360	.00033	.00050	.0007	.0008	.0010	.0012	.0013	.0017	.0020	.0023	.0026	.0030	.0033
		Straight Line Ramp	.75 x D	22 deg.	338	.00037	.00056	.0007	.0009	.0011	.0013	.0015	.0019	.0022	.0026	.0030	.0033	.0037
		Zig Zag Pocket	.75 x D	.55 x D	225	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
	2a) Difficult to machine titanium alloys 10-2-3 18-31 HRc	Peripheral -Rough	1.5 x D	.25 x D	233	.00048	.00071	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0033	.0038	.0043	.0048
		Peripheral -Finish	3 x D	.01 x D	238	.00050	.00075	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Peripheral -HEM	3 x D	.12 x D	328	.00076	.00114	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Slotting -Traditional	.75 x D	1 x D	214	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
		Rough Facing	.3 x D	.7 x D	256	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Finish Facing	.02 x D	.7 x D	261	.00046	.00069	.0009	.0011	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Helical Entry	3 x D	20 deg	324	.00029	.00044	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0026	.0029
		Straight Line Ramp	.63 x D	22 deg.	214	.00036	.00055	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0025	.0029	.0033	.0036
		Zig Zag Pocket	.75 x D	.625 x D	214	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
	2b) Difficult to machine titanium alloys 10-2-3 32-46 HRc	Peripheral -Rough	1.25 x D	.2 x D	221	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Peripheral -Finish	3 x D	.01 x D	225	.00047	.00071	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
		Peripheral -HEM	3 x D	.1 x D	306	.00072	.00108	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072
		Slotting -Traditional	.625 x D	1 x D	203	.00036	.00054	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
		Rough Facing	.28 x D	.65 x D	243	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Finish Facing	.02 x D	.65 x D	242	.00041	.00062	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041
		Helical Entry	3 x D	20 deg	324	.00029	.00044	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0026	.0029
		Straight Line Ramp	.5 x D	18 deg.	203	.00035	.00052	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035
		Zig Zag Pocket	.625 x D	.55 x D	203	.00036	.00054	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
	3a) Nickel Based Super Alloys Hastalloy, Waspalloy 15-30 HRc	Peripheral -Rough	1.25 x D	.25 x D	86	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
Peripheral -Finish		3 x D	.01 x D	190	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
Peripheral -HEM		2 x D	.075 x D	105	.00143	.00214	.0029	.0036	.0043	.0050	.0057	.0071	.0086	.0100	.0114	.0128	.0143	
Slotting -Traditional		.25 x D	1 x D	57	.00032	.00048	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0022	.0026	.0029	.0032	
Rough Facing		.3 x D	.7 x D	94	.00034	.00051	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0027	.0031	.0034	
Finish Facing		.02 x D	.7 x D	199	.00037	.00056	.0007	.0009	.0011	.0013	.0015	.0019	.0022	.0026	.0030	.0034	.0037	
Helical Entry		2 x D	12 deg	114	.00045	.00067	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045	
Straight Line Ramp		.5 x D	3 deg	54	.00029	.00044	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0023	.0026	.0029	
Zig Zag Pocket		.25 x D	.55 x D	57	.00032	.00048	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0022	.0026	.0029	.0032	
3b) Nickel Based Super Alloys Hastalloy, Waspalloy 31-42 HRc	Peripheral -Rough	1 x D	.2 x D	81	.00036	.00054	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036	
	Peripheral -Finish	3 x D	.01 x D	180	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	
	Peripheral -HEM	2 x D	.075 x D	99	.00135	.00203	.0027	.0034	.0041	.0047	.0054	.0068	.0081	.0095	.0108	.0122	.0135	
	Slotting -Traditional	.25 x D	1 x D	54	.00030	.00046	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030	
	Rough Facing	.28 x D	.65 x D	89	.00032	.00049	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0023	.0026	.0029	.0032	
	Finish Facing	.02 x D	.7 x D	188	.00034	.00052	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0034	
	Helical Entry	2.5 x D	10 deg	108	.00045	.00067	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045	
	Straight Line Ramp	.5 x D	3 deg	52	.00030	.00045	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030	
	Zig Zag Pocket	.25 x D	.55 x D	54	.00030	.00046	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030	

M936 POW-R-FEED

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (IPT)												
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
S	4a) Nickel Chromium based Super Alloys Inconel 718, Rene 88 10-25 HRc	Peripheral -Rough	1.25 x D	.25 x D	71	.00038	.00057	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
		Peripheral -Finish	3 x D	.01 x D	86	.00078	.00118	.0016	.0020	.0024	.0027	.0031	.0039	.0047	.0055	.0063	.0071	.0078
		Peripheral -HEM	2 x D	.08 x D	86	.00185	.00278	.0037	.0046	.0056	.0065	.0074	.0093	.0111	.0130	.0148	.0167	.0185
		Slotting -Traditional	.25 x D	1 x D	48	.00029	.00043	.0006	.0007	.0009	.0010	.0011	.0014	.0017	.0020	.0023	.0026	.0029
		Rough Facing	.28 x D	.7 x D	78	.00034	.00051	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0027	.0031	.0034
		Finish Facing	.02 x D	.65 x D	94	.00067	.00100	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Helical Entry	2 x D	12 deg	119	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Straight Line Ramp	.37 x D	3 deg	50	.00029	.00043	.0006	.0007	.0009	.0010	.0011	.0014	.0017	.0020	.0023	.0026	.0029
	Zig Zag Pocket	.25 x D	.5 x D	48	.00029	.00043	.0006	.0007	.0009	.0010	.0011	.0014	.0017	.0020	.0023	.0026	.0029	
	4b) Nickel Chromium based Super Alloys Inconel 718, Rene 88 26-39 HRc	Peripheral -Rough	1 x D	.2 x D	68	.00036	.00054	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
		Peripheral -Finish	3 x D	.01 x D	81	.00074	.00111	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0052	.0059	.0067	.0074
		Peripheral -HEM	2 x D	.05 x D	81	.00176	.00263	.0035	.0044	.0053	.0061	.0070	.0088	.0105	.0123	.0140	.0158	.0176
		Slotting -Traditional	.25 x D	1 x D	45	.00027	.00041	.0005	.0007	.0008	.0009	.0011	.0014	.0016	.0019	.0022	.0024	.0027
		Rough Facing	.28 x D	.65 x D	74	.00032	.00049	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0023	.0026	.0029	.0032
Finish Facing		.02 x D	.6 x D	85	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059	
Helical Entry		2.5 x D	8 deg	113	.00041	.00062	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041	
Straight Line Ramp		.5 x D	10 deg	500	.00062	.00094	.0012	.0016	.0019	.0022	.0025	.0031	.0037	.0044	.0050	.0056	.0062	
Zig Zag Pocket	.25 x D	.5 x D	45	.00027	.00041	.0005	.0007	.0008	.0009	.0011	.0014	.0016	.0019	.0022	.0024	.0027		
N	1a) Aluminum Alloys O-T6 2024, 6061, 7075	Peripheral -Rough	2.25 x D	.6 x D	500	.00175	.00263	.0035	.0044	.0053	.0061	.0070	.0088	.0105	.0123	.0140	.0158	.0175
		Peripheral -Finish	3 x D	.02 x D	750	.00063	.00094	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0044	.0050	.0056	.0063
		Peripheral -HEM	3 x D	.25 x D	700	.00175	.00263	.0035	.0044	.0053	.0061	.0070	.0088	.0105	.0123	.0140	.0158	.0175
		Slotting -Traditional	1 x D	1 x D	375	.00080	.00120	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0056	.0064	.0072	.0080
		Rough Facing	.375 x D	.7 x D	550	.00144	.00216	.0029	.0036	.0043	.0051	.0058	.0072	.0087	.0101	.0115	.0130	.0144
		Finish Facing	.02 x D	.7 x D	784	.00050	.00076	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Helical Entry	3 x D	10 deg	500	.00063	.00095	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0051	.0057	.0063
		Straight Line Ramp	.5 x D	10 deg	463	.00062	.00094	.0012	.0016	.0019	.0022	.0025	.0031	.0037	.0044	.0050	.0056	.0062
	Zig Zag Pocket	1 x D	.45 x D	375	.00080	.00120	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0056	.0064	.0072	.0080	
	1b) Aluminum Alloys 2024, 6061, 7075 96-175 Bhn	Peripheral -Rough	2.25 x D	.6 x D	475	.00166	.00249	.0033	.0042	.0050	.0058	.0067	.0083	.0100	.0116	.0133	.0150	.0166
		Peripheral -Finish	3 x D	.02 x D	713	.00052	.00078	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
		Peripheral -HEM	3 x D	.25 x D	665	.00166	.00249	.0033	.0042	.0050	.0058	.0067	.0083	.0100	.0116	.0133	.0150	.0166
		Slotting -Traditional	1 x D	1 x D	347	.00074	.00111	.0015	.0019	.0022	.0026	.0030	.0037	.0044	.0052	.0059	.0067	.0074
		Rough Facing	.35 x D	.65 x D	495	.00130	.00195	.0026	.0033	.0039	.0046	.0052	.0065	.0078	.0091	.0104	.0117	.0130
Finish Facing		.02 x D	.7 x D	743	.00046	.00070	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0046	
Helical Entry		3 x D	10 deg	450	.00057	.00085	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0046	.0051	.0057	
Straight Line Ramp		.5 x D	10 deg	438	.00061	.00092	.0012	.0015	.0018	.0021	.0024	.0031	.0037	.0043	.0049	.0055	.0061	
Zig Zag Pocket	1 x D	.45 x D	338	.00072	.00108	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072		
2a) High Silicon Aluminum Alloys A380, A390 45-75 Bhn	Peripheral -Rough	2.25 x D	.55 x D	495	.00150	.00225	.0030	.0038	.0045	.0053	.0060	.0075	.0090	.0105	.0120	.0135	.0150	
	Peripheral -Finish	3 x D	.02 x D	725	.00063	.00094	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0044	.0050	.0056	.0063	
	Peripheral -HEM	3 x D	.25 x D	600	.00163	.00244	.0033	.0041	.0049	.0057	.0065	.0081	.0098	.0114	.0130	.0146	.0163	
	Slotting -Traditional	1 x D	1 x D	347	.00074	.00110	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074	
	Rough Facing	.375 x D	.7 x D	545	.00124	.00186	.0025	.0031	.0037	.0043	.0049	.0062	.0074	.0087	.0099	.0111	.0124	
	Finish Facing	.02 x D	.7 x D	758	.00050	.00076	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0035	.0040	.0045	.0050	
	Helical Entry	3 x D	10 deg	486	.00061	.00092	.0012	.0015	.0018	.0021	.0024	.0031	.0037	.0043	.0049	.0055	.0061	
	Straight Line Ramp	.5 x D	10 deg	394	.00061	.00092	.0012	.0015	.0018	.0021	.0024	.0031	.0037	.0043	.0049	.0055	.0061	
Zig Zag Pocket	1 x D	.45 x D	365	.00078	.00116	.0016	.0019	.0023	.0027	.0031	.0039	.0047	.0054	.0062	.0070	.0078		

M936 POW-R-FEED

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (IPT)												
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
N	2b) High Silicon Aluminum Alloys A380, A390 76-195 Bhn	Peripheral -Rough	2.25 x D	.55 x D	470	.00143	.00214	.0029	.0036	.0043	.0050	.0057	.0071	.0086	.0100	.0114	.0128	.0143
		Peripheral -Finish	3 x D	.02 x D	689	.00052	.00078	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
		Peripheral -HEM	3 x D	.25 x D	570	.00152	.00228	.0030	.0038	.0046	.0053	.0061	.0076	.0091	.0106	.0122	.0137	.0152
		Slotting -Traditional	1 x D	1 x D	329	.00070	.00105	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Rough Facing	.35 x D	.65 x D	490	.00112	.00167	.0022	.0028	.0033	.0039	.0045	.0056	.0067	.0078	.0089	.0100	.0112
		Finish Facing	.02 x D	.7 x D	718	.00046	.00070	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0046
		Helical Entry	3 x D	10 deg	438	.00055	.00083	.0011	.0014	.0017	.0019	.0022	.0028	.0033	.0039	.0044	.0050	.0055
		Straight Line Ramp	.5 x D	4 deg	57	.00031	.00046	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0025	.0028	.0031
		Zig Zag Pocket	1 x D	.45 x D	329	.00070	.00105	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0049	.0056	.0063	.0070
	3a) Magnesium Alloys 47-140 Bhn	Peripheral -Rough	2.25 x D	.6 x D	500	.00175	.00263	.0035	.0044	.0053	.0061	.0070	.0088	.0105	.0123	.0140	.0158	.0175
		Peripheral -Finish	3 x D	.02 x D	750	.00063	.00094	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0044	.0050	.0056	.0063
		Peripheral -HEM	3 x D	.25 x D	665	.00166	.00249	.0033	.0042	.0050	.0058	.0067	.0083	.0100	.0116	.0133	.0150	.0166
		Slotting -Traditional	1 x D	1 x D	375	.00080	.00120	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0056	.0064	.0072	.0080
		Rough Facing	.375 x D	.7 x D	550	.00144	.00216	.0029	.0036	.0043	.0051	.0058	.0072	.0087	.0101	.0115	.0130	.0144
		Finish Facing	.02 x D	.7 x D	784	.00050	.00076	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Helical Entry	3 x D	10 deg	500	.00063	.00095	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0051	.0057	.0063
		Straight Line Ramp	.5 x D	10 deg	488	.00062	.00094	.0012	.0016	.0019	.0022	.0025	.0031	.0037	.0044	.0050	.0056	.0062
		Zig Zag Pocket	1 x D	.45 x D	375	.00080	.00120	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0056	.0064	.0072	.0080
	4a) Copper, Brass 111-170 Bhn	Peripheral -Rough	2 x D	.3 x D	361	.00059	.00089	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Peripheral -Finish	3 x D	.015 x D	366	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Peripheral -HEM	2.25 x D	.1 x D	380	.00107	.00160	.0021	.0027	.0032	.0037	.0043	.0053	.0064	.0075	.0086	.0096	.0107
		Slotting -Traditional	.75 x D	1 x D	276	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	418	.00049	.00073	.0010	.0012	.0015	.0017	.0019	.0024	.0029	.0034	.0039	.0044	.0049
		Finish Facing	.02 x D	.7 x D	402	.00046	.00070	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0046
		Helical Entry	3 x D	12 deg	304	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Straight Line Ramp	1 x D	20 deg	300	.00044	.00066	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0031	.0035	.0039	.0044
		Zig Zag Pocket	.75 x D	.625 x D	290	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
	4b) Copper Alloys, Brass Alloys 171-250 Bhn	Peripheral -Rough	1.5 x D	.3 x D	342	.00056	.00084	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Peripheral -Finish	3 x D	.012 x D	347	.00052	.00078	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052
		Peripheral -HEM	2.25 x D	.1 x D	360	.00095	.00142	.0019	.0024	.0028	.0033	.0038	.0047	.0057	.0066	.0076	.0085	.0095
		Slotting -Traditional	.7 x D	1 x D	261	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	376	.00044	.00066	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0031	.0035	.0039	.0044
		Finish Facing	.02 x D	.7 x D	381	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
Helical Entry		2.5 x D	10 deg	274	.00038	.00058	.0008	.0010	.0012	.0013	.0015	.0019	.0023	.0027	.0031	.0035	.0038	
Straight Line Ramp		.75 x D	18 deg	270	.00038	.00058	.0008	.0010	.0012	.0013	.0015	.0019	.0023	.0027	.0031	.0035	.0038	
Zig Zag Pocket		.7 x D	.55 x D	261	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	
5a) Bronze 111-201 Bhn	Peripheral -Rough	2 x D	.3 x D	356	.00057	.00086	.0011	.0014	.0017	.0020	.0023	.0029	.0034	.0040	.0046	.0051	.0057	
	Peripheral -Finish	3 x D	.015 x D	361	.00055	.00082	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055	
	Peripheral -HEM	2.25 x D	.1 x D	390	.00113	.00169	.0023	.0028	.0034	.0039	.0045	.0056	.0068	.0079	.0090	.0101	.0113	
	Slotting -Traditional	.75 x D	1 x D	266	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
	Rough Facing	.375 x D	.7 x D	413	.00047	.00070	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0047	
	Finish Facing	.02 x D	.7 x D	397	.00046	.00070	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0046	
	Helical Entry	3 x D	12 deg	315	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
	Straight Line Ramp	1 x D	20 deg	295	.00044	.00066	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0031	.0035	.0039	.0044	
	Zig Zag Pocket	.75 x D	.625 x D	280	.00045	.00068	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045	

M936 POW-R-FEED

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (IPT)												
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	1-1/8	1-1/4
N	5b) Bronze, High Tin Bronze, Manganese Bronze, Work Hardened Bronze 201-277 Bhn	Peripheral -Rough	1.5 x D	.3 x D	338	.00054	.00081	.0011	.0014	.0016	.0019	.0022	.0027	.0032	.0038	.0043	.0049	.0054
		Peripheral -Finish	3 x D	.012 x D	342	.00052	.00078	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052
		Peripheral -HEM	2.25 x D	.1 x D	351	.00095	.00142	.0019	.0024	.0028	.0033	.0038	.0047	.0057	.0066	.0076	.0085	.0095
		Slotting -Traditional	.7 x D	1 x D	252	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	371	.00042	.00063	.0008	.0011	.0013	.0015	.0017	.0021	.0025	.0029	.0034	.0038	.0042
		Finish Facing	.02 x D	.7 x D	376	.00043	.00064	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Helical Entry	2.5 x D	10 deg	270	.00038	.00058	.0008	.0010	.0012	.0013	.0015	.0019	.0023	.0027	.0031	.0035	.0038
		Straight Line Ramp	.75 x D	18 deg	269	.00039	.00059	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0039
		Zig Zag Pocket	.7 x D	.55 x D	252	.00041	.00061	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
	6a) Composites, Plastics, Fiberglass	Peripheral -Rough	1.5 x D	.5 x D	428	.00071	.00107	.0014	.0018	.0021	.0025	.0029	.0036	.0043	.0050	.0057	.0064	.0071
		Peripheral -Finish	3 x D	.015 x D	447	.00069	.00103	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Peripheral -HEM	2.25 x D	.12 x D	475	.00119	.00178	.0024	.0030	.0036	.0042	.0048	.0059	.0071	.0083	.0095	.0107	.0119
		Slotting -Traditional	1 x D	1 x D	380	.00067	.00100	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Rough Facing	.375 x D	.7 x D	495	.00058	.00087	.0012	.0015	.0017	.0020	.0023	.0029	.0035	.0041	.0047	.0052	.0058
		Finish Facing	.02 x D	.7 x D	491	.00059	.00088	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059
Helical Entry		3 x D	20 deg	400	.00067	.00100	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067	
Straight Line Ramp		1 x D	25 deg.	400	.00063	.00095	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0051	.0057	.0063	
Zig Zag Pocket	1 x D	.625 x D	400	.00070	.00105	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0056	.0063	.0070		