

# 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	1b] Cast Iron- Gray ASTM-A48 Class 20, 25,30,35 & 40	Peripheral -Rough	1.5 x D	.25 x D	333	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0047	.0054	.0061	.0068
		Peripheral -Finish	3 x D	.01 x D	338	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0052	.0059	.0065
		Peripheral -HEM	3	.07 x D	342	.0016	.0024	.0032	.0039	.0047	.0055	.0063	.0079	.0095	.0110	.0126	.0142	.0158
		Slotting -Traditional	.5 x D	1 x D	270	.0005	.0007	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
		Rough Facing	.35 x D	.65 x D	354	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Finish Facing	.02 x D	.65 x D	354	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0029	.0034	.0040	.0046	.0051	.0057
		Helical Entry	2 x D	12 deg.	292	.0004	.0006	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0029	.0033	.0037
		Straight Line Ramp	.5 x D	10 deg	270	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Zig Zag Pocket	.5 x D	.55 x D	270	.0005	.0007	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
	2a] Cast Iron- Ductile	Peripheral -Rough	1.5 x D	.32 x D	333	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Peripheral -Finish	3 x D	.015 x D	333	.0006	.0009	.0012	.0015	.0019	.0022	.0025	.0031	.0037	.0043	.0049	.0056	.0062
		Peripheral -HEM	3 x D	.08 x D	371	.0018	.0027	.0036	.0045	.0053	.0062	.0071	.0089	.0107	.0125	.0143	.0160	.0178
		Slotting -Traditional	.63 x D	1 x D	247	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Rough Facing	.375 x D	.7 x D	366	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Finish Facing	.02 x D	.7 x D	349	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0045	.0051	.0057
		Helical Entry	3 x D	20 deg.	275	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Straight Line Ramp	.63 x D	14 deg	247	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Zig Zag Pocket	.63 x D	.63 x D	247	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
	2b] Cast Iron- Ductile	Peripheral -Rough	1.5 x D	.3 x D	315	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0050	.0057	.0063
		Peripheral -Finish	3 x D	.01 x D	315	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Peripheral -HEM	3 x D	.07 x D	351	.0017	.0025	.0034	.0042	.0051	.0059	.0068	.0084	.0101	.0118	.0135	.0152	.0169
		Slotting -Traditional	.5 x D	1 x D	234	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.35 x D	.65 x D	347	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0045	.0051	.0057
		Finish Facing	.02 x D	.65 x D	331	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0026	.0031	.0036	.0041	.0046	.0051
		Helical Entry	3 x D	18 deg.	260	.0004	.0006	.0008	.0010	.0012	.0015	.0017	.0021	.0025	.0029	.0033	.0037	.0042
		Straight Line Ramp	.50 x D	13 deg	234	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Zig Zag Pocket	.50 x D	.55 x D	234	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
	3a] Cast Iron- Malleable	Peripheral -Rough	1.5 x D	.32 x D	333	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
Peripheral -Finish		3 x D	.015 x D	333	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059	
Peripheral -HEM		3 x D	.08 x D	371	.0018	.0026	.0035	.0044	.0053	.0062	.0070	.0088	.0105	.0123	.0141	.0158	.0176	
Slotting -Traditional		.63 x D	1 x D	252	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
Rough Facing		.375 x D	.7 x D	366	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058	
Finish Facing		.02 x D	.7 x D	349	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055	
Helical Entry		.02 x D	.7 x D	349	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055	
Straight Line Ramp		3 x D	20 deg.	270	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043	
Zig Zag Pocket		.63 x D	14 deg	252	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	
3b] Cast Iron- Malleable	Peripheral -Rough	1.5 x D	.3 x D	315	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061	
	Peripheral -Finish	3 x D	.01 x D	315	.0006	.0009	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059	
	Peripheral -HEM	3 x D	.07 x D	351	.0017	.0025	.0033	.0042	.0050	.0058	.0067	.0083	.0100	.0117	.0133	.0150	.0167	
	Slotting -Traditional	.5 x D	1 x D	239	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	
	Rough Facing	.35 x D	.65 x D	347	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055	
	Finish Facing	.02 x D	.65 x D	331	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0034	.0039	.0044	.0049	
	Helical Entry	3 x D	18 deg.	256	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0035	.0039	
	Straight Line Ramp	.50 x D	13 deg	239	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	
	Zig Zag Pocket	.50 x D	.55 x D	239	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041	

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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	1a] Low Carbon Steel ≤33 HRC 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	2 x D	.55 x D	361	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -Finish	3 x D	.015 x D	380	.0009	.0013	.0018	.0022	.0026	.0031	.0035	.0044	.0053	.0062	.0070	.0079	.0088
		Peripheral -HEM	3 x D	.09 x D	418	.0015	.0023	.0031	.0039	.0046	.0054	.0062	.0077	.0093	.0108	.0124	.0139	.0154
		Slotting -Traditional	1 x D	1 x D	309	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Rough Facing	.375 x D	.7 x D	397	.0007	.0011	.0015	.0018	.0022	.0025	.0029	.0036	.0044	.0051	.0058	.0065	.0073
		Finish Facing	.02 x D	.7 x D	399	.0009	.0013	.0017	.0021	.0026	.0030	.0034	.0043	.0051	.0060	.0068	.0077	.0085
		Helical Entry	3 x D	25 deg.	371	.0005	.0007	.0009	.0012	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Straight Line Ramp	1 x D	20 deg	380	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038
		Zig Zag Pocket	1 x D	.63 x D	309	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
	1b] Low Carbon Steel ≤48 HRC 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	1.5 x D	.52 x D	342	.0008	.0011	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Peripheral -Finish	3 x D	.012 x D	360	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Peripheral -HEM	3 x D	0.07 x D	396	.0015	.0022	.0029	.0037	.0044	.0051	.0059	.0073	.0088	.0102	.0117	.0132	.0146
		Slotting -Traditional	.75 x D	1 x D	293	.0006	.0008	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Rough Facing	.35 x D	.65 x D	376	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Finish Facing	.02 x D	.65 x D	378	.0008	.0012	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0062	.0069	.0077
		Helical Entry	3 x D	20 deg.	350	.0004	.0006	.0008	.0011	.0013	.0015	.0017	.0021	.0025	.0030	.0034	.0038	.0042
		Straight Line Ramp	.75 x D	18 deg	360	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038
		Zig Zag Pocket	.75 x D	.55 x D	293	.0006	.0008	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
	2a] Medium Carbon Steel ≤32 HRC 1045, 4140, 4340, 5140	Peripheral -Rough	2 x D	.55 x D	356	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Peripheral -Finish	3 x D	.015 x D	356	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -HEM	3 x D	.09 x D	380	.0014	.0021	.0028	.0034	.0041	.0048	.0055	.0069	.0083	.0096	.0110	.0124	.0138
		Slotting -Traditional	1 x D	1 x D	285	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Rough Facing	.375 x D	.7 x D	392	.0007	.0010	.0014	.0017	.0021	.0024	.0027	.0034	.0041	.0048	.0055	.0062	.0068
		Finish Facing	.02 x D	.7 x D	374	.0008	.0012	.0016	.0020	.0023	.0027	.0031	.0039	.0047	.0055	.0063	.0070	.0078
		Helical Entry	3 x D	25 deg.	356	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0025	.0029	.0033	.0037	.0041
		Straight Line Ramp	1 x D	20 deg	380	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035
		Zig Zag Pocket	1 x D	.63 x D	285	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
	2b] Medium Carbon Steel ≤48 HRC 1045, 4140, 4340, 5140	Peripheral -Rough	1.5 x D	.52 x D	338	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072
		Peripheral -Finish	3 x D	.012 x D	338	.0008	.0011	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Peripheral -HEM	3 x D	.07 x D	369	.0013	.0020	.0026	.0033	.0039	.0046	.0052	.0065	.0078	.0091	.0104	.0117	.0131
		Slotting -Traditional	.75 x D	1 x D	270	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052
		Rough Facing	.35 x D	.65 x D	371	.0006	.0010	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0065
		Finish Facing	.02 x D	.65 x D	354	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0057	.0064	.0071
		Helical Entry	3 x D	20 deg.	338	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038
		Straight Line Ramp	.75 x D	18 deg	351	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035
		Zig Zag Pocket	.75 x D	.55 x D	270	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052
3a] Tool & Die Steels ≤28 HRc A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.5 x D	.52 x D	333	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064	
	Peripheral -Finish	3 x D	.015 x D	333	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069	
	Peripheral -HEM	3 x D	.08 x D	371	.0011	.0017	.0023	.0029	.0034	.0040	.0046	.0057	.0068	.0080	.0091	.0103	.0114	
	Slotting -Traditional	.75 x D	1 x D	261	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045	
	Rough Facing	.375 x D	.7 x D	366	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058	
	Finish Facing	.02 x D	.7 x D	349	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067	
	Helical Entry	3 x D	18 deg.	285	.0004	.0005	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036	
	Straight Line Ramp	.75 x D	18 deg	333	.0003	.0004	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0027	.0030	
	Zig Zag Pocket	.75 x D	.63 x D	261	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045	

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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	3b] Tool & Die Steels ≤42 HRC A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.25 x D	.4 x D	315	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Peripheral -Finish	3 x D	.012 x D	315	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0052	.0059	.0065
		Peripheral -HEM	3 x D	.07 x D	347	.0011	.0016	.0022	.0027	.0032	.0038	.0043	.0054	.0065	.0076	.0086	.0097	.0108
		Slotting -Traditional	.63 x D	1 x D	248	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.35 x D	.65 x D	347	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Finish Facing	.02 x D	.65 x D	331	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Helical Entry	2 x D	12 deg.	270	.0003	.0005	.0007	.0008	.0010	.0012	.0013	.0017	.0020	.0023	.0027	.0030	.0033
		Straight Line Ramp	.63 x D	16 deg	285	.0003	.0004	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0027	.0030
		Zig Zag Pocket	.63 x D	.55 x D	248	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
H	1a] Tool & Die Steels 42-52 HRC	Peripheral -Rough	1 x D	.25 x D	290	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0033	.0038	.0043	.0048
		Peripheral -Finish	3 x D	.01 x D	285	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Peripheral -HEM	3 x D	.05 x D	337	.0014	.0020	.0027	.0034	.0041	.0047	.0054	.0068	.0081	.0095	.0108	.0122	.0135
		Slotting -Traditional	.45 x D	1 x D	238	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Rough Facing	.35 x D	.65 x D	319	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Finish Facing	.02 x D	.65 x D	298	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Helical Entry	.88 x D	12 deg.	238	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035
		Straight Line Ramp	.5 x D	8 deg	257	.0002	.0004	.0005	.0006	.0007	.0009	.0010	.0012	.0015	.0017	.0020	.0022	.0024
		Zig Zag Pocket	.45 x D	.4 x D	238	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
M	1a] Martensitic & Ferritic Stainless Steels 410, 416, 440	Peripheral -Rough	2 x D	.25 x D	375	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Peripheral -Finish	3 x D	.015 x D	356	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -HEM	3 x D	.2 x D	380	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Slotting -Traditional	1 x D	1 x D	261	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	413	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Finish Facing	.02 x D	.7 x D	374	.0007	.0010	.0014	.0017	.0021	.0024	.0027	.0034	.0041	.0048	.0055	.0062	.0069
		Helical Entry	3 x D	7 deg.	314	.0003	.0004	.0005	.0007	.0008	.0010	.0011	.0014	.0016	.0019	.0022	.0025	.0027
		Straight Line Ramp	.75 x D	5 deg	261	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Zig Zag Pocket	1 x D	.63 x D	261	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
M	1b] Martensitic & Ferritic Stainless Steels 410, 416, 440	Peripheral -Rough	1.75 x D	.2 x D	356	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Peripheral -Finish	3 x D	.012 x D	338	.0008	.0011	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Peripheral -HEM	3 x D	.2 x D	360	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0052	.0059	.0065
		Slotting -Traditional	.75 x D	1 x D	248	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	391	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0045	.0051	.0057
		Finish Facing	.02 x D	.65 x D	345	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0051	.0057	.0063
		Helical Entry	3 x D	7 deg.	297	.0002	.0004	.0005	.0006	.0007	.0008	.0009	.0012	.0014	.0017	.0019	.0021	.0024
		Straight Line Ramp	.63 x D	4 deg	248	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Zig Zag Pocket	.75 x D	.55 x D	248	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
M	2a] Austenitic Stainless Steels FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	2 x D	.25 x D	371	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
		Peripheral -Finish	3 x D	.015 x D	333	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074
		Peripheral -HEM	3 x D	.2 x D	371	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067
		Slotting -Traditional	1 x D	1 x D	261	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	408	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058
		Finish Facing	.02 x D	.7 x D	349	.0006	.0010	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0064
		Helical Entry	3 x D	7 deg.	308	.0003	.0004	.0005	.0007	.0008	.0009	.0010	.0013	.0016	.0018	.0021	.0023	.0026
		Straight Line Ramp	.75 x D	5 deg	270	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Zig Zag Pocket	1 x D	.63 x D	261	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043

# 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	2b] Austenitic Stainless Steels FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	1.75 x D	.2 x D	351	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Peripheral -Finish	3 x D	.012 x D	315	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Peripheral -HEM	3 x D	.2 x D	351	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0044	.0050	.0057	.0063
		Slotting -Traditional	.75 x D	1 x D	248	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	386	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Finish Facing	.02 x D	.65 x D	331	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058
		Helical Entry	3 x D	7 deg.	292	.0002	.0004	.0005	.0006	.0007	.0008	.0010	.0012	.0014	.0017	.0019	.0022	.0024
		Straight Line Ramp	.63 x D	4 deg	248	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Zig Zag Pocket	.75 x D	.55 x D	248	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
	3a] Precipitation Hardening Stainless Steel 17-4, 15-5, 13-8	Peripheral -Rough	1.5 x D	.22 x D	333	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
		Peripheral -Finish	3 x D	.015 x D	309	.0006	.0009	.0012	.0015	.0019	.0022	.0025	.0031	.0037	.0043	.0049	.0056	.0062
		Peripheral -HEM	3 x D	.2 x D	347	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
		Slotting -Traditional	.63 x D	1 x D	238	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0040
		Rough Facing	.375 x D	.7 x D	366	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0024	.0028	.0033	.0038	.0042	.0047
		Finish Facing	.02 x D	.7 x D	324	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0032	.0038	.0043	.0049	.0054
		Helical Entry	3 x D	7 deg.	285	.0002	.0004	.0005	.0006	.0007	.0009	.0010	.0012	.0015	.0017	.0020	.0022	.0025
		Straight Line Ramp	.63 x D	5 deg	243	.0004	.0005	.0007	.0009	.0011	.0012	.0014	.0018	.0021	.0025	.0028	.0032	.0035
		Zig Zag Pocket	.63 x D	.63 x D	238	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0040
	3b] Precipitation Hardening Stainless Steel 17-4, 15-5, 13-8	Peripheral -Rough	1.25 x D	.2 x D	306	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0034	.0039	.0043	.0048
		Peripheral -Finish	3 x D	.012 x D	293	.0006	.0009	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059
		Peripheral -HEM	3 x D	.18 x D	329	.0005	.0007	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
		Slotting -Traditional	.50 x D	1 x D	225	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
		Rough Facing	.35 x D	.65 x D	347	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Finish Facing	.02 x D	.65 x D	316	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0026	.0031	.0036	.0041	.0046	.0051
		Helical Entry	3 x D	6 deg.	270	.0002	.0003	.0005	.0006	.0007	.0008	.0009	.0011	.0014	.0016	.0018	.0021	.0023
		Straight Line Ramp	.5 x D	4 deg	225	.0004	.0005	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0033	.0036
		Zig Zag Pocket	.5 x D	.55 x D	225	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0031	.0034	.0038
	S	1a] Titanium Alloys 6AL-4V, 6-2-4	Peripheral -Rough	2 x D	.3 x D	261	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053
Peripheral -Finish			3 x D	.015 x D	285	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
Peripheral -HEM			3 x D	.12 x D	390	.0010	.0014	.0019	.0024	.0029	.0033	.0038	.0048	.0057	.0067	.0076	.0086	.0095
Slotting -Traditional			1 x D	1 x D	238	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
Rough Facing			.375 x D	.7 x D	287	.0005	.0008	.0011	.0013	.0016	.0019	.0021	.0027	.0032	.0037	.0043	.0048	.0053
Finish Facing			.02 x D	.7 x D	314	.0005	.0008	.0011	.0013	.0016	.0019	.0021	.0027	.0032	.0037	.0043	.0048	.0053
Helical Entry			3 x D	20 deg.	380	.0003	.0005	.0007	.0008	.0010	.0012	.0013	.0017	.0020	.0023	.0026	.0030	.0033
Straight Line Ramp			1 x D	25 deg.	380	.0004	.0006	.0007	.0009	.0011	.0013	.0015	.0019	.0022	.0026	.0030	.0033	.0037
Zig Zag Pocket			1 x D	.63 x D	214	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
1b] Titanium Alloys 6AL-4V, 6-2-4		Peripheral -Rough	1.5 x D	.25 x D	248	.0006	.0008	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Peripheral -Finish	3 x D	.012 x D	270	.0006	.0008	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Peripheral -HEM	3 x D	.1 x D	365	.0009	.0014	.0018	.0023	.0027	.0032	.0036	.0045	.0054	.0063	.0072	.0081	.0090
		Slotting -Traditional	.75 x D	1 x D	225	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	272	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0035	.0041	.0046	.0051
		Finish Facing	.02 x D	.65 x D	290	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0029	.0034	.0039	.0044	.0049
		Helical Entry	3 x D	18 deg.	360	.0003	.0005	.0007	.0008	.0010	.0012	.0013	.0017	.0020	.0023	.0026	.0030	.0033
		Straight Line Ramp	.75 x D	22 deg.	338	.0004	.0006	.0007	.0009	.0011	.0013	.0015	.0019	.0022	.0026	.0030	.0033	.0037
		Zig Zag Pocket	.75 x D	.55 x D	203	.0004	.0006	.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
S	2a] Difficult to machine titanium alloys 10-2-3	Peripheral -Rough	1.5 x D	.25 x D	233	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0033	.0038	.0043	.0048
		Peripheral -Finish	3 x D	.01 x D	238	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Peripheral -HEM	3 x D	.12 x D	328	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Slotting -Traditional	.75 x D	1 x D	214	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
		Rough Facing	.3 x D	.7 x D	256	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Finish Facing	.02 x D	.7 x D	261	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Helical Entry	3 x D	20 deg.	342	.0003	.0004	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0026	.0029
		Straight Line Ramp	.63 x D	22 deg.	214	.0004	.0005	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0025	.0029	.0033	.0036
		Zig Zag Pocket	.75 x D	.63 x D	214	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
	2b] Difficult to machine titanium alloys 10-2-3	Peripheral -Rough	1.25 x D	.2 x D	221	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
		Peripheral -Finish	3 x D	.01 x D	225	.0005	.0007	.0009	.0012	.0014	.0017	.0019	.0024	.0028	.0033	.0038	.0043	.0047
		Peripheral -HEM	3 x D	.1 x D	306	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0058	.0065	.0072
		Slotting -Traditional	.63 x D	1 x D	203	.0004	.0005	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
		Rough Facing	.28 x D	.65 x D	243	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Finish Facing	.02 x D	.65 x D	242	.0004	.0006	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041
		Helical Entry	3 x D	18 deg.	324	.0003	.0004	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0024	.0026	.0029
		Straight Line Ramp	.5 x D	18 deg.	203	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0035
		Zig Zag Pocket	.63 x D	.55 x D	203	.0004	.0005	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
	3a] Nickel Based Super Alloys Hastalloy, Waspalloy	Peripheral -Rough	1.25 x D	.25 x D	86	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
		Peripheral -Finish	3 x D	.01 x D	190	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Peripheral -HEM	2 x D	.075 x D	105	.0014	.0021	.0029	.0036	.0043	.0050	.0057	.0071	.0086	.0100	.0114	.0128	.0143
		Slotting -Traditional	.25 x D	1 x D	57	.0003	.0005	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0022	.0026	.0029	.0032
		Rough Facing	.3 x D	.7 x D	94	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0027	.0031	.0034
		Finish Facing	.02 x D	.7 x D	199	.0004	.0006	.0007	.0009	.0011	.0013	.0015	.0019	.0022	.0026	.0030	.0034	.0037
		Helical Entry	2 x D	12 deg.	114	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Straight Line Ramp	.5 x D	4 deg	57	.0003	.0005	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0025	.0028	.0031
		Zig Zag Pocket	.25 x D	.55 x D	57	.0003	.0005	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0022	.0026	.0029	.0032
	3b] Nickel Based Super Alloys Hastalloy, Waspalloy	Peripheral -Rough	1 x D	.2 x D	81	.0004	.0005	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
		Peripheral -Finish	3 x D	.01 x D	180	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Peripheral -HEM	2 x D	.075 x D	99	.0014	.0020	.0027	.0034	.0041	.0047	.0054	.0068	.0081	.0095	.0108	.0122	.0135
		Slotting -Traditional	.25 x D	1 x D	54	.0003	.0005	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030
		Rough Facing	.28 x D	.65 x D	89	.0003	.0005	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0023	.0026	.0029	.0032
		Finish Facing	.02 x D	.7 x D	188	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0028	.0031	.0034
		Helical Entry	2.5 x D	10 deg.	108	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Straight Line Ramp	.5 x D	3 deg	54	.0003	.0004	.0006	.0007	.0009	.0010	.0012	.0015	.0018	.0021	.0023	.0026	.0029
		Zig Zag Pocket	.25 x D	.55 x D	54	.0003	.0005	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030
4a] Nickel Chromium based Super Alloys Inconel 718, Rene 88	Peripheral -Rough	1.25 x D	.25 x D	71	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038	
	Peripheral -Finish	3 x D	.01 x D	86	.0008	.0012	.0016	.0020	.0024	.0027	.0031	.0039	.0047	.0055	.0063	.0071	.0078	
	Peripheral -HEM	2 x D	.08 x D	86	.0019	.0028	.0037	.0046	.0056	.0065	.0074	.0093	.0111	.0130	.0148	.0167	.0185	
	Slotting -Traditional	.25 x D	1 x D	48	.0003	.0004	.0006	.0007	.0009	.0010	.0011	.0014	.0017	.0020	.0023	.0026	.0029	
	Rough Facing	.28 x D	.7 x D	78	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0027	.0031	.0034	
	Finish Facing	.02 x D	.65 x D	94	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067	
	Helical Entry	2 x D	12 deg.	119	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045	
	Straight Line Ramp	.50 x D	3 deg	52	.0003	.0005	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030	
	Zig Zag Pocket	.25 x D	.5 x D	48	.0003	.0004	.0006	.0007	.0009	.0010	.0011	.0014	.0017	.0020	.0023	.0026	.0029	

# 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	4b] Nickel Chromium based Super Alloys Inconel 718, Rene 88	Peripheral -Rough	1 x D	.2 x D	68	.0004	.0005	.0007	.0009	.0011	.0013	.0014	.0018	.0022	.0025	.0029	.0032	.0036
		Peripheral -Finish	3 x D	.01 x D	81	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0052	.0059	.0067	.0074
		Peripheral -HEM	2 x D	.05 x D	81	.0018	.0026	.0035	.0044	.0053	.0061	.0070	.0088	.0105	.0123	.0140	.0158	.0176
		Slotting -Traditional	.25 x D	1 x D	45	.0003	.0004	.0005	.0007	.0008	.0009	.0011	.0014	.0016	.0019	.0022	.0024	.0027
		Rough Facing	.35 x D	.65 x D	74	.0003	.0005	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0023	.0026	.0029	.0032
		Finish Facing	.02 x D	.6 x D	85	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Helical Entry	2.5 x D	8 deg.	113	.0004	.0006	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041
		Straight Line Ramp	.37 x D	3 deg	50	.0003	.0004	.0006	.0007	.0009	.0010	.0011	.0014	.0017	.0020	.0023	.0026	.0029
		Zig Zag Pocket	.25 x D	.5 x D	45	.0003	.0004	.0005	.0007	.0008	.0009	.0011	.0014	.0016	.0019	.0022	.0024	.0027
N	4a] Copper alloys, Brass	Peripheral -Rough	2 x D	.3 x D	361	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Peripheral -Finish	3 x D	.015 x D	366	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Peripheral -HEM	2.25 x D	.1 x D	380	.0011	.0016	.0021	.0027	.0032	.0037	.0043	.0053	.0064	.0075	.0086	.0096	.0107
		Slotting -Traditional	.75 x D	1 x D	276	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	418	.0005	.0007	.0010	.0012	.0015	.0017	.0019	.0024	.0029	.0034	.0039	.0044	.0049
		Finish Facing	.02 x D	.7 x D	402	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0046
		Helical Entry	3 x D	12 deg.	304	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Straight Line Ramp	1 x D	20 deg	300	.0004	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0031	.0035	.0039	.0044
		Zig Zag Pocket	.75 x D	.63 x D	290	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
N	4b] Copper alloys, Brass	Peripheral -Rough	1.5 x D	.3 x D	342	.0006	.0008	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0039	.0045	.0051	.0056
		Peripheral -Finish	3 x D	.012 x D	347	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052
		Peripheral -HEM	2.25 x D	.1 x D	360	.0009	.0014	.0019	.0024	.0028	.0033	.0038	.0047	.0057	.0066	.0076	.0085	.0095
		Slotting -Traditional	.7 x D	1 x D	261	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	376	.0004	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0031	.0035	.0039	.0044
		Finish Facing	.02 x D	.7 x D	381	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Helical Entry	2.5 x D	10 deg.	274	.0004	.0006	.0008	.0010	.0012	.0013	.0015	.0019	.0023	.0027	.0031	.0035	.0038
		Straight Line Ramp	.75 x D	18 deg	270	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Zig Zag Pocket	.7 x D	.55 x D	261	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
N	5a] Bronze	Peripheral -Rough	2 x D	.3 x D	356	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0029	.0034	.0040	.0046	.0051	.0057
		Peripheral -Finish	3 x D	.015 x D	361	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Peripheral -HEM	2.25 x D	.1 x D	390	.0011	.0017	.0023	.0028	.0034	.0039	.0045	.0056	.0068	.0079	.0090	.0101	.0113
		Slotting -Traditional	.75 x D	1 x D	266	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Rough Facing	.375 x D	.7 x D	413	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0047
		Finish Facing	.02 x D	.7 x D	397	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0033	.0037	.0042	.0046
		Helical Entry	3 x D	12 deg.	315	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Straight Line Ramp	1 x D	20 deg	295	.0004	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0026	.0031	.0035	.0039	.0044
		Zig Zag Pocket	.75 x D	.63 x D	280	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
N	5b] Bronze	Peripheral -Rough	1.5 x D	.3 x D	338	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0032	.0038	.0043	.0049	.0054
		Peripheral -Finish	3 x D	.012 x D	342	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0036	.0041	.0047	.0052
		Peripheral -HEM	2.25 x D	.1 x D	351	.0009	.0014	.0019	.0024	.0028	.0033	.0038	.0047	.0057	.0066	.0076	.0085	.0095
		Slotting -Traditional	.7 x D	1 x D	252	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Rough Facing	.35 x D	.65 x D	371	.0004	.0006	.0008	.0011	.0013	.0015	.0017	.0021	.0025	.0029	.0034	.0038	.0042
		Finish Facing	.02 x D	.7 x D	376	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Helical Entry	2.5 x D	10 deg.	270	.0004	.0006	.0008	.0010	.0012	.0013	.0015	.0019	.0023	.0027	.0031	.0035	.0038
		Straight Line Ramp	.75 x D	18 deg	270	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
Zig Zag Pocket	.7 x D	.55 x D	252	.0004	.0006	.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		
N	6a] Composites, Plastics, Fiberglass	Peripheral -Rough	1.5 x D	.5 x D	428	.0007	.0011	.0014	.0018	.0021	.0025	.0029	.0036	.0043	.0050	.0057	.0064	.0071		
		Peripheral -Finish	3 x D	.015 x D	447	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069		
		Peripheral -HEM	2.25 x D	.12 x D	475	.0012	.0018	.0024	.0030	.0036	.0042	.0048	.0059	.0071	.0083	.0095	.0107	.0119		
		Slotting -Traditional	1 x D	1 x D	380	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067		
		Rough Facing	.375 x D	.7 x D	495	.0006	.0009	.0012	.0015	.0017	.0020	.0023	.0029	.0035	.0041	.0047	.0052	.0058		
		Finish Facing	.02 x D	.7 x D	491	.0006	.0009	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059		
		Helical Entry	3 x D	20 deg.	400	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0033	.0040	.0047	.0053	.0060	.0067		
		Straight Line Ramp	1 x D	25 deg.	400	.0006	.0010	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0065		
		Zig Zag Pocket	1 x D	.63 x D	400	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0056	.0063	.0070		