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	Cast iron- Gray ASTM-A48 Class 20, 25,30, 35 & 40	Peripheral -Rough	1.300 x D	.500 x D	384	.0007	.0011	.0015	.0018	.0022	.0026	.0030	.0037	.0044	.0052	.0059	.0066	.0074
		Peripheral -Finish	3.000 x D	.015 x D	465	.0009	.0013	.0017	.0021	.0026	.0030	.0034	.0043	.0051	.0060	.0068	.0077	.0085
		Peripheral -HEM	4.000 x D	.080 x D	342	.0017	.0025	.0034	.0042	.0051	.0059	.0068	.0084	.0101	.0118	.0135	.0152	.0169
		Slotting -Traditional	1.500 x D	1.000 x D	333	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
		Rough Facing	.375 x D	.700 x D	468	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0053	.0059	.0066
		Finish Facing	.020 x D	.700 x D	505	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0052	.0060	.0067	.0075
		Helical Entry	3.000 x D	18 deg	351	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Straight Line Ramp	1.500 x D	18 deg	333	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Trad. Style Pocket	1.500 x D	1.000 x D	333	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
	Cast iron- Ductile 15-25 HRc	Peripheral -Rough	1.300 x D	.500 x D	355	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0034	.0041	.0048	.0055	.0062	.0069
		Peripheral -Finish	3.000 x D	.015 x D	450	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0039	.0047	.0054	.0062	.0070	.0078
		Peripheral -HEM	3.000 x D	.070 x D	390	.0021	.0032	.0043	.0053	.0064	.0074	.0085	.0106	.0128	.0149	.0170	.0191	.0213
		Slotting -Traditional	1.500 x D	1.000 x D	327	.0005	.0008	.0011	.0013	.0016	.0019	.0021	.0027	.0032	.0038	.0043	.0048	.0054
		Rough Facing	.375 x D	.700 x D	432	.0006	.0009	.0012	.0015	.0018	.0021	.0025	.0031	.0037	.0043	.0049	.0055	.0061
		Finish Facing	.020 x D	.700 x D	489	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074
		Helical Entry	3.000 x D	20 deg	355	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0044
		Straight Line Ramp	1.500 x D	20 deg	318	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0034	.0039	.0043	.0048
		Trad. Style Pocket	1.500 x D	1.000 x D	318	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
	Cast iron- Malleable 15-25 HRc	Peripheral -Rough	1.300 x D	.500 x D	346	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0053	.0059	.0066
		Peripheral -Finish	3.000 x D	.015 x D	415	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0038	.0045	.0053	.0060	.0068	.0075
		Peripheral -HEM	3.000 x D	.070 x D	390	.0021	.0031	.0042	.0052	.0062	.0073	.0083	.0104	.0125	.0145	.0166	.0187	.0208
		Slotting -Traditional	1.500 x D	1.000 x D	309	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
		Rough Facing	.375 x D	.700 x D	426	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Finish Facing	.020 x D	.700 x D	451	.0007	.0011	.0014	.0018	.0021	.0025	.0029	.0036	.0043	.0050	.0057	.0064	.0071
		Helical Entry	3.000 x D	20 deg	344	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0044
		Straight Line Ramp	1.500 x D	20 deg	309	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0034	.0039	.0043	.0048
		Trad. Style Pocket	1.500 x D	1.000 x D	309	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
P	Low carbon steel ≤38 HRc 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	1.500 x D	.450 x D	419	.0008	.0012	.0016	.0020	.0024	.0028	.0033	.0041	.0049	.0057	.0065	.0073	.0081
		Peripheral -Finish	3.000 x D	.015 x D	508	.0009	.0014	.0018	.0023	.0027	.0032	.0037	.0046	.0055	.0064	.0073	.0082	.0091
		Peripheral -HEM	3.000 x D	.080 x D	435	.0030	.0045	.0060	.0075	.0090	.0105	.0120	.0150	.0180	.0210	.0240	.0270	.0300
		Slotting -Traditional	1.500 x D	1.000 x D	366	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0053	.0059	.0066
		Rough Facing	.375 x D	.700 x D	502	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0051	.0058	.0065	.0072
		Finish Facing	.020 x D	.700 x D	525	.0008	.0013	.0017	.0021	.0025	.0029	.0034	.0042	.0050	.0059	.0067	.0075	.0084
		Helical Entry	3.000 x D	20 deg	385	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Straight Line Ramp	1.500 x D	20 deg	392	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0041
		Trad. Style Pocket	1.500 x D	1.000 x D	356	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
	Medium carbon Steel ≤40 HRc 1045, 4140, 4340, 5140	Peripheral -Rough	1.500 x D	.350 x D	442	.0007	.0011	.0014	.0018	.0021	.0025	.0029	.0036	.0043	.0050	.0057	.0064	.0071
		Peripheral -Finish	3.000 x D	.015 x D	465	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0041	.0050	.0058	.0066	.0074	.0083
		Peripheral -HEM	3.000 x D	.080 x D	415	.0029	.0043	.0058	.0072	.0086	.0101	.0115	.0144	.0173	.0201	.0230	.0259	.0288
		Slotting -Traditional	1.500 x D	1.000 x D	317	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0037	.0043	.0049	.0055	.0061
		Rough Facing	.375 x D	.700 x D	549	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0053	.0059	.0066
		Finish Facing	.020 x D	.700 x D	488	.0008	.0011	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0053	.0061	.0069	.0076
		Helical Entry	3.000 x D	20 deg	342	.0004	.0007	.0009	.0011	.0013	.0016	.0018	.0022	.0027	.0031	.0036	.0040	.0045
		Straight Line Ramp	1.500 x D	20 deg	349	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0023	.0027	.0031	.0035	.0039
		Trad. Style Pocket	1.500 x D	1.000 x D	309	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059

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
P	Tool & die steels ≤34 HRc A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.500 x D	.325 x D	413	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
		Peripheral -Finish	3.000 x D	.015 x D	460	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0038	.0045	.0053	.0060	.0068	.0075
		Peripheral -HEM	3.000 x D	.080 x D	385	.0024	.0036	.0048	.0060	.0072	.0084	.0096	.0120	.0144	.0168	.0192	.0216	.0240
		Slotting -Traditional	1.250 x D	1.000 x D	317	.0006	.0009	.0012	.0015	.0018	.0020	.0023	.0029	.0035	.0041	.0047	.0053	.0059
		Rough Facing	.375 x D	.700 x D	513	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0041	.0047	.0053	.0059
		Finish Facing	.020 x D	.700 x D	483	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0049	.0056	.0063	.0069
		Helical Entry	3.000 x D	18 deg	337	.0004	.0006	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041
		Straight Line Ramp	1.250 x D	18 deg	340	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0034	.0038
		Trad. Style Pocket	1.250 x D	1.000 x D	309	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0029	.0034	.0040	.0046	.0051	.0057
H	Tool & die steels 40-48- HRc	Peripheral -Rough	1.250 x D	.250 x D	350	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058
		Peripheral -Finish	3.000 x D	.012 x D	414	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0048	.0055	.0061	.0068
		Peripheral -HEM	3.000 x D	.050 x D	325	.0021	.0031	.0041	.0051	.0062	.0072	.0082	.0103	.0123	.0144	.0164	.0185	.0205
		Slotting -Traditional	.750 x D	1.000 x D	261	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Rough Facing	.350 x D	.650 x D	366	.0005	.0008	.0011	.0013	.0016	.0019	.0021	.0026	.0032	.0037	.0042	.0048	.0053
		Finish Facing	.020 x D	.650 x D	444	.0006	.0010	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0065
		Helical Entry	.880 x D	12 deg	261	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0019	.0023	.0027	.0031	.0035	.0039
		Straight Line Ramp	.750 x D	8 deg	282	.0003	.0004	.0005	.0007	.0008	.0009	.0011	.0014	.0016	.0019	.0022	.0024	.0027
		Trad. Style Pocket	.750 x D	1.000 x D	261	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
M	Martensitic & ferritic stainless steels 15-29 HRc 410, 416, 440	Peripheral -Rough	1.250 x D	.480 x D	330	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Peripheral -Finish	3.000 x D	.015 x D	439	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0039	.0047	.0054	.0062	.0070	.0078
		Peripheral -HEM	3.000 x D	.080 x D	404	.0028	.0041	.0055	.0069	.0083	.0096	.0110	.0138	.0165	.0193	.0220	.0248	.0275
		Slotting -Traditional	1.500 x D	1.000 x D	315	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0028	.0033	.0039	.0044	.0050	.0055
		Rough Facing	.375 x D	.700 x D	396	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Finish Facing	.020 x D	.700 x D	473	.0007	.0011	.0014	.0018	.0021	.0025	.0029	.0036	.0043	.0050	.0057	.0064	.0071
		Helical Entry	3.000 x D	15 deg	408	.0003	.0005	.0006	.0008	.0010	.0011	.0013	.0016	.0019	.0023	.0026	.0029	.0032
		Straight Line Ramp	1.500 x D	15 deg	299	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0025	.0031	.0036	.0041	.0046	.0051
		Trad. Style Pocket	1.500 x D	1.000 x D	299	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
	Austenitic stainless steels 15-29 HRc FeNi alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	1.250 x D	.480 x D	325	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Peripheral -Finish	3.000 x D	.015 x D	410	.0008	.0012	.0016	.0020	.0024	.0028	.0033	.0041	.0049	.0057	.0065	.0073	.0081
		Peripheral -HEM	3.000 x D	.080 x D	385	.0028	.0041	.0055	.0069	.0083	.0096	.0110	.0138	.0165	.0193	.0220	.0248	.0275
		Slotting -Traditional	1.500 x D	1.000 x D	305	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0028	.0033	.0039	.0044	.0050	.0055
		Rough Facing	.375 x D	.700 x D	390	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Finish Facing	.020 x D	.700 x D	431	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0051	.0058	.0065	.0072
		Helical Entry	3.000 x D	15 deg	395	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0017	.0021	.0024	.0027	.0031	.0034
		Straight Line Ramp	1.500 x D	15 deg	290	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0025	.0031	.0036	.0041	.0046	.0051
		Trad. Style Pocket	1.500 x D	1.000 x D	290	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0026	.0031	.0037	.0042	.0047	.0052
	Precipitation hardening stainless steel 15-38 HRc 17-4, 15-5, 13-8	Peripheral -Rough	1.250 x D	.425 x D	297	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0034	.0040	.0047	.0054	.0060	.0067
		Peripheral -Finish	3.000 x D	.015 x D	376	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0052	.0059	.0065
		Peripheral -HEM	3.000 x D	.080 x D	356	.0021	.0032	.0043	.0053	.0064	.0074	.0085	.0106	.0128	.0149	.0170	.0191	.0213
		Slotting -Traditional	1.000 x D	1.000 x D	285	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0033	.0038	.0043	.0048
		Rough Facing	.375 x D	.700 x D	366	.0006	.0010	.0013	.0016	.0019	.0022	.0025	.0032	.0038	.0045	.0051	.0057	.0064
		Finish Facing	.020 x D	.700 x D	399	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0054	.0060
		Helical Entry	3.000 x D	12 deg	360	.0003	.0005	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0027	.0030
		Straight Line Ramp	1.000 x D	12 deg	285	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0032	.0037	.0042	.0046
		Trad. Style Pocket	1.000 x D	1.000 x D	285	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0024	.0029	.0033	.0038	.0043	.0048

M934 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	**Titanium alloys 6AL-4V, 6-2-4 18-31 HRc**	Peripheral -Rough	2.000 x D	.550 x D	346	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0056	.0064	.0072	.0080
		Peripheral -Finish	3.000 x D	.020 x D	414	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0037	.0043	.0049	.0055	.0061
		Peripheral -HEM	3.000 x D	.080 x D	380	.0016	.0024	.0032	.0040	.0048	.0057	.0065	.0081	.0097	.0113	.0129	.0145	.0162
		Slotting -Traditional	1.500 x D	1.000 x D	300	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0047	.0054	.0061	.0068
		Rough Facing	.375 x D	.700 x D	371	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0056	.0063	.0071
		Finish Facing	.020 x D	.700 x D	444	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0027	.0033	.0038	.0044	.0049	.0055
		Helical Entry	3.000 x D	20 deg	403	.0004	.0007	.0009	.0011	.0013	.0015	.0017	.0022	.0026	.0030	.0035	.0039	.0043
		Straight Line Ramp	1.500 x D	20 deg	299	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0043	.0049	.0055	.0061
		Trad. Style Pocket	1.500 x D	1.000 x D	285	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0032	.0038	.0045	.0051	.0058	.0064
	Difficult-to-machine titanium alloys 10-2-3 18-31 HRc	Peripheral -Rough	1.500 x D	.375 x D	288	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0046	.0053	.0059	.0066
		Peripheral -Finish	3.000 x D	.010 x D	337	.0005	.0008	.0011	.0013	.0016	.0019	.0021	.0027	.0032	.0038	.0043	.0048	.0054
		Peripheral -HEM	3.000 x D	.075 x D	356	.0013	.0020	.0026	.0033	.0039	.0046	.0052	.0065	.0078	.0091	.0105	.0118	.0131
		Slotting -Traditional	1.250 x D	1.000 x D	250	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0044	.0050	.0056	.0063
		Rough Facing	.300 x D	.700 x D	308	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0029	.0035	.0040	.0046	.0052	.0058
		Finish Facing	.020 x D	.700 x D	371	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0025	.0030	.0035	.0040	.0045	.0050
		Helical Entry	3.000 x D	18 deg	380	.0004	.0006	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041
		Straight Line Ramp	1.250 x D	18 deg	256	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0028	.0034	.0040	.0046	.0051	.0057
		Trad. Style Pocket	1.250 x D	1.000 x D	238	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0042	.0048	.0053	.0059
	Nickel-based super alloys Hastalloy, Waspalloy 15-30 HRc	Peripheral -Rough	1.500 x D	.250 x D	238	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Peripheral -Finish	3.000 x D	.015 x D	296	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0021	.0026	.0030	.0034	.0038	.0043
		Peripheral -HEM	3.000 x D	.070 x D	214	.0015	.0022	.0030	.0037	.0045	.0052	.0060	.0075	.0090	.0105	.0120	.0135	.0150
		Slotting -Traditional	.450 x D	1.000 x D	219	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0023	.0028	.0032	.0037	.0042	.0046
		Rough Facing	.300 x D	.700 x D	261	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0036	.0039
		Finish Facing	.020 x D	.700 x D	326	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0028	.0032	.0037	.0041	.0046
		Helical Entry	2.000 x D	12 deg	257	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0024	.0028	.0033	.0038	.0042	.0047
		Straight Line Ramp	.450 x D	12 deg	224	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0022	.0026	.0030	.0035	.0039	.0043
		Trad. Style Pocket	.450 x D	1.000 x D	214	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0041	.0045
	Nickel Chromium- based super alloys Inconel 718, Rene 88 10-25 HRc	Peripheral -Rough	1.250 x D	.225 x D	71	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0019	.0023	.0027	.0030	.0034	.0038
		Peripheral -Finish	3.000 x D	.015 x D	93	.0009	.0013	.0018	.0022	.0026	.0031	.0035	.0044	.0053	.0061	.0070	.0079	.0088
		Peripheral -HEM	2.000 x D	.060 x D	86	.0020	.0030	.0040	.0050	.0061	.0071	.0081	.0101	.0121	.0141	.0162	.0182	.0202
		Slotting -Traditional	.250 x D	1.000 x D	59	.0003	.0004	.0005	.0007	.0008	.0009	.0011	.0013	.0016	.0019	.0021	.0024	.0027
		Rough Facing	.280 x D	.700 x D	78	.0004	.0005	.0007	.0009	.0011	.0012	.0014	.0018	.0021	.0025	.0028	.0032	.0035
		Finish Facing	.020 x D	.650 x D	92	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0050	.0057	.0065	.0072
		Helical Entry	1.000 x D	8 deg	71	.0004	.0006	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0037	.0041
		Straight Line Ramp	.250 x D	8 deg	59	.0003	.0004	.0005	.0007	.0008	.0009	.0011	.0013	.0016	.0019	.0021	.0024	.0027
		Trad. Style Pocket	.250 x D	1.000 x D	57	.0003	.0004	.0005	.0007	.0008	.0009	.0010	.0013	.0016	.0018	.0021	.0024	.0026
N	**Aluminum alloys O-T6 2024, 6061, 7075**	Peripheral -Rough	2.250 x D	.600 x D	750	.0015	.0023	.0030	.0038	.0045	.0053	.0060	.0075	.0090	.0105	.0120	.0135	.0150
		Peripheral -Finish	3.000 x D	.020 x D	900	.0010	.0014	.0019	.0024	.0029	.0033	.0038	.0048	.0057	.0067	.0076	.0086	.0095
		Peripheral -HEM	3.000 x D	.250 x D	900	.0023	.0034	.0045	.0056	.0068	.0079	.0090	.0113	.0135	.0158	.0180	.0203	.0225
		Slotting -Traditional	1.750 x D	1.000 x D	700	.0009	.0014	.0019	.0023	.0028	.0032	.0037	.0046	.0056	.0065	.0074	.0083	.0093
		Rough Facing	.375 x D	.700 x D	825	.0012	.0019	.0025	.0031	.0037	.0044	.0050	.0062	.0075	.0087	.0099	.0112	.0124
		Finish Facing	.020 x D	.700 x D	941	.0008	.0012	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Helical Entry	3.000 x D	25 deg	910	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0044	.0052	.0059	.0067	.0074
		Straight Line Ramp	1.750 x D	25 deg	875	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0051	.0058	.0065	.0072
		Trad. Style Pocket	1.750 x D	1.000 x D	700	.0009	.0014	.0019	.0023	.0028	.0032	.0037	.0046	.0056	.0065	.0074	.0083	.0093

FRACTIONAL / in

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
	High-silicon aluminum alloys A380, A390 45-75 Bhn	Peripheral -Rough	2.250 x D	.600 x D	740	.0015	.0023	.0030	.0038	.0045	.0053	.0060	.0075	.0090	.0105	.0120	.0135	.0150
		Peripheral -Finish	3.000 x D	.020 x D	800	.0009	.0014	.0018	.0023	.0027	.0032	.0036	.0045	.0054	.0063	.0072	.0081	.0090
		Peripheral -HEM	3.000 x D	.250 x D	750	.0016	.0024	.0033	.0041	.0049	.0057	.0065	.0081	.0098	.0114	.0130	.0146	.0163
		Slotting -Traditional	1.750 x D	1.000 x D	618	.0008	.0012	.0016	.0020	.0024	.0027	.0031	.0039	.0047	.0055	.0063	.0071	.0078
		Rough Facing	.375 x D	.700 x D	814	.0012	.0019	.0025	.0031	.0037	.0044	.0050	.0062	.0075	.0087	.0099	.0112	.0124
		Finish Facing	.020 x D	.700 x D	836	.0007	.0011	.0015	.0018	.0022	.0025	.0029	.0036	.0044	.0051	.0058	.0065	.0073
		Helical Entry	3.000 x D	20 deg	845	.0007	.0010	.0013	.0017	.0020	.0023	.0026	.0033	.0040	.0046	.0053	.0059	.0066
		Straight Line Ramp	1.750 x D	20 deg	780	.0006	.0010	.0013	.0016	.0019	.0023	.0026	.0032	.0039	.0045	.0052	.0058	.0065
		Trad. Style Pocket	1.750 x D	1.000 x D	650	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0041	.0050	.0058	.0066	.0074	.0083
	Magnesium alloys 47-140 Bhn	Peripheral -Rough	2.250 x D	.600 x D	750	.0015	.0023	.0030	.0038	.0045	.0053	.0060	.0075	.0090	.0105	.0120	.0135	.0150
		Peripheral -Finish	3.000 x D	.020 x D	900	.0010	.0014	.0019	.0024	.0029	.0033	.0038	.0048	.0057	.0067	.0076	.0086	.0095
		Peripheral -HEM	3.000 x D	.250 x D	855	.0021	.0032	.0043	.0053	.0064	.0075	.0086	.0107	.0128	.0150	.0171	.0192	.0214
		Slotting -Traditional	1.750 x D	1.000 x D	700	.0009	.0014	.0019	.0023	.0028	.0032	.0037	.0046	.0056	.0065	.0074	.0083	.0093
		Rough Facing	.375 x D	.700 x D	825	.0012	.0019	.0025	.0031	.0037	.0044	.0050	.0062	.0075	.0087	.0099	.0112	.0124
		Finish Facing	.020 x D	.700 x D	941	.0008	.0012	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Helical Entry	3.000 x D	25 deg	910	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0044	.0052	.0059	.0067	.0074
		Straight Line Ramp	1.750 x D	25 deg	875	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0036	.0043	.0051	.0058	.0065	.0072
		Trad. Style Pocket	1.750 x D	1.000 x D	700	.0009	.0014	.0019	.0023	.0028	.0032	.0037	.0046	.0056	.0065	.0074	.0083	.0093
N	Copper, brass 111-170 Bhn	Peripheral -Rough	2.250 x D	.600 x D	428	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Peripheral -Finish	3.000 x D	.015 x D	570	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0057	.0065	.0073	.0081
		Peripheral -HEM	3.000 x D	.100 x D	499	.0017	.0026	.0035	.0043	.0052	.0061	.0069	.0087	.0104	.0121	.0139	.0156	.0173
		Slotting -Traditional	1.500 x D	1.000 x D	356	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Rough Facing	.375 x D	.700 x D	495	.0008	.0012	.0016	.0020	.0024	.0027	.0031	.0039	.0047	.0055	.0063	.0071	.0078
		Finish Facing	.020 x D	.700 x D	660	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0045	.0052	.0060	.0067	.0075
		Helical Entry	3.000 x D	20 deg	428	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0042	.0050	.0058	.0067	.0075	.0083
		Straight Line Ramp	1.500 x D	20 deg	388	.0008	.0012	.0015	.0019	.0023	.0027	.0031	.0038	.0046	.0054	.0061	.0069	.0077
		Trad. Style Pocket	1.500 x D	1.000 x D	375	.0009	.0013	.0018	.0022	.0026	.0031	.0035	.0044	.0053	.0061	.0070	.0079	.0088
	Bronze 111-201 Bhn	Peripheral -Rough	2.000 x D	.450 x D	418	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Peripheral -Finish	3.000 x D	.012 x D	546	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074
		Peripheral -HEM	3.000 x D	.080 x D	502	.0018	.0026	.0035	.0044	.0053	.0061	.0070	.0088	.0105	.0123	.0140	.0158	.0176
		Slotting -Traditional	1.500 x D	1.000 x D	347	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074
		Rough Facing	.375 x D	.700 x D	484	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0037	.0044	.0052	.0059	.0067	.0074
		Finish Facing	.020 x D	.700 x D	633	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Helical Entry	3.000 x D	20 deg	438	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0037	.0044	.0052	.0059	.0066	.0074
		Straight Line Ramp	1.500 x D	20 deg	374	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0048	.0054	.0061	.0068
		Trad. Style Pocket	1.500 x D	1.000 x D	365	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0039	.0047	.0054	.0062	.0070	.0078
	Composites, plastics, fiberglass	Peripheral -Rough	2.250 x D	.450 x D	618	.0014	.0021	.0029	.0036	.0043	.0050	.0057	.0071	.0086	.0100	.0114	.0128	.0143
		Peripheral -Finish	3.000 x D	.020 x D	641	.0011	.0016	.0021	.0027	.0032	.0037	.0043	.0053	.0064	.0075	.0086	.0096	.0107
		Peripheral -HEM	3.000 x D	.100 x D	684	.0021	.0031	.0042	.0052	.0063	.0073	.0084	.0105	.0125	.0146	.0167	.0188	.0209
		Slotting -Traditional	1.750 x D	1.000 x D	570	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Rough Facing	.375 x D	.700 x D	715	.0011	.0017	.0023	.0029	.0034	.0040	.0046	.0057	.0068	.0080	.0091	.0103	.0114
		Finish Facing	.020 x D	.700 x D	743	.0010	.0015	.0020	.0025	.0030	.0035	.0040	.0050	.0061	.0071	.0081	.0091	.0101
		Helical Entry	3.000 x D	25 deg	720	.0008	.0011	.0015	.0019	.0023	.0027	.0030	.0038	.0046	.0053	.0061	.0068	.0076
		Straight Line Ramp	1.750 x D	25 deg	630	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0035	.0042	.0049	.0056	.0063	.0070
		Trad. Style Pocket	1.750 x D	1.000 x D	600	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0056	.0064	.0072	.0080