

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)									
						6.0	8.0	10.0	12.0	14.0	16.0	20.0	22.0	25.0	32.0
K	Cast iron- Gray ASTM-A48 Class 20, 25,30, 35 & 40	Peripheral -Rough	1.300 x D	.500 x D	117	.0355	.0473	.0591	.0709	.0828	.0946	.1182	.1300	.1477	.1891
		Peripheral -Finish	3.000 x D	.015 x D	142	.0408	.0544	.0680	.0816	.0953	.1088	.1360	.1496	.1700	.2176
		Peripheral -HEM	3.000 x D	.080 x D	116	.0900	.1200	.1500	.1800	.2102	.2400	.3000	.3300	.3750	.4800
		Slotting -Traditional	1.500 x D	1.000 x D	101	.0285	.0380	.0475	.0570	.0666	.0760	.0950	.1045	.1187	.1520
		Rough Facing	.375 x D	.700 x D	143	.0316	.0421	.0526	.0632	.0738	.0842	.1053	.1158	.1316	.1685
		Finish Facing	.020 x D	.700 x D	154	.0358	.0477	.0597	.0716	.0836	.0955	.1193	.1313	.1492	.1909
		Helical Entry	3.000 x D	18 deg	107	.0214	.0285	.0356	.0427	.0499	.0570	.0712	.0784	.0891	.1140
		Straight Line Ramp	1.500 x D	18 deg	101	.0262	.0350	.0437	.0525	.0613	.0700	.0875	.0962	.1094	.1400
		Trad. Style Pocket	1.500 x D	.625 x D	101	.0285	.0380	.0475	.0570	.0666	.0760	.0950	.1045	.1187	.1520
	Cast iron- Ductile 15-25 HRc	Peripheral -Rough	1.300 x D	.500 x D	108	.0331	.0441	.0552	.0662	.0773	.0883	.1103	.1214	.1379	.1765
		Peripheral -Finish	3.000 x D	.015 x D	137	.0372	.0496	.0620	.0744	.0869	.0992	.1240	.1364	.1550	.1984
		Peripheral -HEM	3.000 x D	.070 x D	119	.1020	.1360	.1700	.2040	.2383	.2720	.3400	.3740	.4250	.5440
		Slotting -Traditional	1.500 x D	1.000 x D	100	.0257	.0343	.0429	.0515	.0601	.0686	.0858	.0944	.1072	.1373
		Rough Facing	.375 x D	.700 x D	132	.0295	.0393	.0491	.0590	.0689	.0786	.0983	.1081	.1228	.1572
		Finish Facing	.020 x D	.700 x D	149	.0354	.0472	.0589	.0707	.0826	.0943	.1179	.1297	.1473	.1886
		Helical Entry	3.000 x D	20 deg	108	.0213	.0284	.0355	.0426	.0498	.0568	.0711	.0782	.0888	.1137
		Straight Line Ramp	1.500 x D	20 deg	97	.0231	.0308	.0385	.0462	.0540	.0616	.0770	.0847	.0962	.1232
		Trad. Style Pocket	1.500 x D	.625 x D	97	.0251	.0334	.0418	.0502	.0586	.0669	.0836	.0920	.1045	.1338
	Cast iron- Malleable 15-25 HRc	Peripheral -Rough	1.300 x D	.500 x D	105	.0316	.0421	.0526	.0632	.0738	.0842	.1053	.1158	.1316	.1685
		Peripheral -Finish	3.000 x D	.015 x D	126	.0360	.0480	.0600	.0720	.0841	.0960	.1200	.1320	.1500	.1920
		Peripheral -HEM	3.000 x D	.070 x D	119	.0996	.1328	.1660	.1992	.2327	.2656	.3320	.3652	.4150	.5312
		Slotting -Traditional	1.500 x D	1.000 x D	94	.0251	.0334	.0418	.0502	.0586	.0669	.0836	.0920	.1045	.1338
		Rough Facing	.375 x D	.700 x D	130	.0292	.0389	.0486	.0583	.0681	.0778	.0972	.1069	.1215	.1555
		Finish Facing	.020 x D	.700 x D	137	.0342	.0456	.0570	.0684	.0799	.0913	.1141	.1255	.1426	.1825
		Helical Entry	3.000 x D	20 deg	105	.0213	.0284	.0355	.0426	.0498	.0568	.0711	.0782	.0888	.1137
		Straight Line Ramp	1.500 x D	20 deg	94	.0231	.0308	.0385	.0462	.0540	.0616	.0770	.0847	.0962	.1232
		Trad. Style Pocket	1.500 x D	.625 x D	94	.0251	.0334	.0418	.0502	.0586	.0669	.0836	.0920	.1045	.1338
P	Low carbon steel ≤38 HRc 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	1.500 x D	.450 x D	128	.0390	.0520	.0650	.0780	.0911	.1040	.1300	.1430	.1625	.2080
		Peripheral -Finish	3.000 x D	.015 x D	155	.0438	.0585	.0731	.0877	.1024	.1169	.1462	.1608	.1827	.2339
		Peripheral -HEM	3.000 x D	.080 x D	133	.1440	.1920	.2400	.2880	.3364	.3840	.4800	.5280	.6000	.7680
		Slotting -Traditional	1.500 x D	1.000 x D	111	.0316	.0421	.0526	.0632	.0738	.0842	.1053	.1158	.1316	.1685
		Rough Facing	.375 x D	.700 x D	153	.0347	.0463	.0579	.0695	.0812	.0927	.1158	.1274	.1448	.1853
		Finish Facing	.020 x D	.700 x D	160	.0402	.0536	.0670	.0804	.0940	.1073	.1341	.1475	.1676	.2145
		Helical Entry	3.000 x D	20 deg	117	.0239	.0318	.0398	.0477	.0557	.0636	.0795	.0875	.0994	.1272
		Straight Line Ramp	1.500 x D	20 deg	119	.0194	.0259	.0324	.0389	.0454	.0518	.0648	.0713	.0810	.1037
		Trad. Style Pocket	1.500 x D	.625 x D	109	.0308	.0410	.0513	.0616	.0719	.0821	.1026	.1129	.1282	.1642
	Medium carbon Steel ≤40 HRc 1045, 4140, 4340, 5140	Peripheral -Rough	1.500 x D	.350 x D	135	.0342	.0456	.0570	.0684	.0799	.0912	.1140	.1254	.1425	.1824
		Peripheral -Finish	3.000 x D	.015 x D	142	.0396	.0528	.0660	.0792	.0925	.1056	.1320	.1452	.1650	.2112
		Peripheral -HEM	3.000 x D	.080 x D	126	.1380	.1840	.2300	.2760	.3224	.3680	.4600	.5060	.5750	.7360
		Slotting -Traditional	1.500 x D	1.000 x D	97	.0292	.0390	.0487	.0585	.0683	.0780	.0975	.1072	.1219	.1560
		Rough Facing	.375 x D	.700 x D	167	.0316	.0421	.0526	.0632	.0738	.0842	.1053	.1158	.1316	.1685
		Finish Facing	.020 x D	.700 x D	149	.0367	.0489	.0611	.0734	.0857	.0978	.1223	.1345	.1528	.1956
		Helical Entry	3.000 x D	20 deg	104	.0214	.0285	.0356	.0427	.0499	.0570	.0712	.0784	.0891	.1140
		Straight Line Ramp	1.500 x D	20 deg	106	.0187	.0250	.0312	.0375	.0438	.0500	.0625	.0687	.0781	.1000
		Trad. Style Pocket	1.500 x D	.625 x D	94	.0285	.0380	.0475	.0570	.0666	.0760	.0950	.1045	.1187	.1520

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)									
						6.0	8.0	10.0	12.0	14.0	16.0	20.0	22.0	25.0	32.0
P	Tool & die steels ≤34 HRC A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.500 x D	.325 x D	126	.0308	.0410	.0513	.0616	.0719	.0821	.1026	.1129	.1282	.1642
		Peripheral -Finish	3.000 x D	.015 x D	140	.0360	.0480	.0600	.0720	.0841	.0960	.1200	.1320	.1500	.1920
		Peripheral -HEM	3.000 x D	.080 x D	117	.1152	.1536	.1920	.2304	.2691	.3072	.3840	.4224	.4800	.6144
		Slotting -Traditional	1.250 x D	1.000 x D	97	.0281	.0374	.0468	.0562	.0656	.0749	.0936	.1030	.1170	.1498
		Rough Facing	.375 x D	.700 x D	156	.0284	.0379	.0474	.0569	.0664	.0758	.0948	.1042	.1185	.1516
		Finish Facing	.020 x D	.700 x D	147	.0333	.0445	.0556	.0667	.0779	.0889	.1111	.1223	.1389	.1778
		Helical Entry	3.000 x D	18 deg	103	.0198	.0264	.0331	.0397	.0463	.0529	.0661	.0727	.0826	.1058
		Straight Line Ramp	1.250 x D	18 deg	104	.0181	.0242	.0302	.0363	.0424	.0484	.0605	.0665	.0756	.0968
		Trad. Style Pocket	1.250 x D	.625 x D	94	.0274	.0365	.0456	.0547	.0639	.0730	.0912	.1003	.1140	.1459
H	Tool & die steels 40-48- HRC	Peripheral -Rough	1.250 x D	.250 x D	107	.0276	.0368	.0460	.0552	.0645	.0736	.0920	.1012	.1150	.1472
		Peripheral -Finish	3.000 x D	.012 x D	126	.0328	.0437	.0546	.0655	.0765	.0874	.1092	.1201	.1365	.1747
		Peripheral -HEM	3.000 x D	.050 x D	99	.0984	.1312	.1640	.1968	.2299	.2624	.3280	.3608	.4100	.5248
		Slotting -Traditional	.750 x D	1.000 x D	80	.0239	.0319	.0399	.0479	.0559	.0638	.0798	.0878	.0997	.1277
		Rough Facing	.350 x D	.650 x D	111	.0254	.0339	.0424	.0509	.0594	.0678	.0848	.0933	.1060	.1356
		Finish Facing	.020 x D	.650 x D	135	.0311	.0415	.0519	.0622	.0727	.0830	.1037	.1141	.1297	.1660
		Helical Entry	.880 x D	12 deg	80	.0186	.0247	.0309	.0371	.0433	.0495	.0618	.0680	.0773	.0990
		Straight Line Ramp	.750 x D	8 deg	86	.0130	.0173	.0216	.0260	.0303	.0346	.0433	.0476	.0541	.0692
		Trad. Style Pocket	.750 x D	.400 x D	80	.0239	.0319	.0399	.0479	.0559	.0638	.0798	.0878	.0997	.1277
M	Martensitic & ferritic stainless steels 15-29 HRC 410, 416, 440	Peripheral -Rough	1.250 x D	.480 x D	101	.0365	.0486	.0608	.0730	.0852	.0973	.1216	.1338	.1520	.1946
		Peripheral -Finish	3.000 x D	.015 x D	134	.0372	.0496	.0620	.0744	.0869	.0992	.1240	.1364	.1550	.1984
		Peripheral -HEM	3.000 x D	.080 x D	123	.1320	.1760	.2200	.2640	.3083	.3520	.4400	.4840	.5500	.7040
		Slotting -Traditional	1.500 x D	1.000 x D	96	.0264	.0352	.0440	.0528	.0617	.0704	.0880	.0968	.1100	.1408
		Rough Facing	.375 x D	.700 x D	121	.0337	.0449	.0562	.0674	.0787	.0899	.1123	.1236	.1404	.1797
		Finish Facing	.020 x D	.700 x D	144	.0342	.0456	.0570	.0684	.0799	.0913	.1141	.1255	.1426	.1825
		Helical Entry	3.000 x D	15 deg	124	.0156	.0208	.0260	.0312	.0364	.0416	.0520	.0572	.0649	.0831
		Straight Line Ramp	1.500 x D	15 deg	91	.0244	.0326	.0407	.0488	.0570	.0651	.0814	.0895	.1017	.1302
		Trad. Style Pocket	.400 x D	.300 x D	48	.0132	.0176	.0220	.0264	.0308	.0352	.0440	.0484	.0550	.0704
	Austenitic stainless steels 15-29 HRC FeNi alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	1.250 x D	.480 x D	99	.0365	.0486	.0608	.0730	.0852	.0973	.1216	.1338	.1520	.1946
		Peripheral -Finish	3.000 x D	.015 x D	125	.0390	.0520	.0650	.0780	.0911	.1040	.1300	.1430	.1625	.2080
		Peripheral -HEM	3.000 x D	.080 x D	117	.1320	.1760	.2200	.2640	.3083	.3520	.4400	.4840	.5500	.7040
		Slotting -Traditional	1.500 x D	1.000 x D	93	.0264	.0352	.0440	.0528	.0617	.0704	.0880	.0968	.1100	.1408
		Rough Facing	.375 x D	.700 x D	119	.0337	.0449	.0562	.0674	.0787	.0899	.1123	.1236	.1404	.1797
		Finish Facing	.020 x D	.700 x D	131	.0346	.0462	.0577	.0693	.0809	.0924	.1155	.1270	.1444	.1848
		Helical Entry	3.000 x D	15 deg	120	.0164	.0219	.0273	.0328	.0383	.0438	.0547	.0602	.0684	.0875
		Straight Line Ramp	1.500 x D	15 deg	88	.0244	.0326	.0407	.0488	.0570	.0651	.0814	.0895	.1017	.1302
		Trad. Style Pocket	1.500 x D	.625 x D	88	.0251	.0334	.0418	.0502	.0586	.0669	.0836	.0920	.1045	.1338
	Precipitation hardening stainless steel 15-38 HRC 17-4, 15-5, 13-8	Peripheral -Rough	1.250 x D	.425 x D	91	.0322	.0429	.0536	.0644	.0752	.0858	.1073	.1180	.1341	.1717
		Peripheral -Finish	3.000 x D	.015 x D	115	.0312	.0416	.0520	.0624	.0729	.0832	.1040	.1144	.1300	.1664
		Peripheral -HEM	3.000 x D	.080 x D	108	.1020	.1360	.1700	.2040	.2383	.2720	.3400	.3740	.4250	.5440
		Slotting -Traditional	1.000 x D	1.000 x D	87	.0228	.0304	.0380	.0456	.0533	.0608	.0760	.0836	.0950	.1216
		Rough Facing	.375 x D	.700 x D	112	.0305	.0407	.0509	.0611	.0713	.0814	.1018	.1120	.1272	.1629
		Finish Facing	.020 x D	.700 x D	122	.0287	.0383	.0478	.0574	.0671	.0765	.0957	.1052	.1196	.1531
		Helical Entry	3.000 x D	12 deg	110	.0146	.0195	.0243	.0292	.0341	.0389	.0486	.0535	.0608	.0778
		Straight Line Ramp	1.000 x D	12 deg	87	.0222	.0296	.0370	.0444	.0519	.0592	.0740	.0814	.0925	.1184
		Trad. Style Pocket	1.000 x D	.625 x D	87	.0228	.0304	.0380	.0456	.0533	.0608	.0760	.0836	.0950	.1216

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						6.0	8.0	10.0	12.0	14.0	16.0	20.0	22.0	25.0	32.0
S	Titanium alloys 6AL-4V, 6-2-4 18-31 HRC	Peripheral -Rough	2.000 x D	.550 x D	105	.0386	.0515	.0643	.0772	.0902	.1030	.1287	.1416	.1609	.2059
		Peripheral -Finish	3.000 x D	.020 x D	126	.0292	.0390	.0487	.0585	.0683	.0780	.0975	.1072	.1219	.1560
		Peripheral -HEM	3.000 x D	.080 x D	116	.0775	.1034	.1292	.1550	.1811	.2067	.2584	.2842	.3230	.4134
		Slotting -Traditional	1.500 x D	1.000 x D	91	.0324	.0432	.0540	.0648	.0757	.0864	.1080	.1188	.1350	.1728
		Rough Facing	.375 x D	.700 x D	113	.0339	.0451	.0564	.0677	.0791	.0903	.1129	.1241	.1411	.1806
		Finish Facing	.020 x D	.700 x D	135	.0262	.0350	.0437	.0525	.0613	.0700	.0875	.0962	.1094	.1400
		Helical Entry	3.000 x D	20 deg	123	.0208	.0278	.0347	.0417	.0487	.0556	.0695	.0764	.0868	.1111
		Straight Line Ramp	1.500 x D	20 deg	91	.0292	.0389	.0486	.0583	.0681	.0778	.0972	.1069	.1215	.1555
		Trad. Style Pocket	1.500 x D	.625 x D	87	.0308	.0410	.0513	.0616	.0719	.0821	.1026	.1129	.1282	.1642
	Difficult-to-machine titanium alloys 10-2-3 18-31 HRC	Peripheral -Rough	1.500 x D	.375 x D	88	.0316	.0421	.0526	.0632	.0738	.0842	.1053	.1158	.1316	.1685
		Peripheral -Finish	3.000 x D	.010 x D	103	.0257	.0343	.0429	.0515	.0601	.0686	.0858	.0944	.1072	.1373
		Peripheral -HEM	3.000 x D	.075 x D	109	.0627	.0836	.1045	.1254	.1465	.1672	.2090	.2299	.2612	.3344
		Slotting -Traditional	1.250 x D	1.000 x D	76	.0300	.0400	.0500	.0600	.0701	.0800	.1000	.1100	.1250	.1600
		Rough Facing	.300 x D	.700 x D	94	.0277	.0369	.0462	.0554	.0647	.0739	.0923	.1016	.1154	.1477
		Finish Facing	.020 x D	.700 x D	113	.0238	.0317	.0396	.0475	.0555	.0634	.0792	.0871	.0990	.1267
		Helical Entry	3.000 x D	18 deg	116	.0198	.0265	.0331	.0397	.0464	.0529	.0661	.0728	.0827	.1058
		Straight Line Ramp	1.250 x D	18 deg	78	.0273	.0364	.0455	.0546	.0638	.0728	.0910	.1001	.1137	.1456
		Trad. Style Pocket	1.250 x D	.625 x D	72	.0285	.0380	.0475	.0570	.0666	.0760	.0950	.1045	.1187	.1520
	Nickel-based super alloys Hastalloy, Waspalloy 15-30 HRC	Peripheral -Rough	1.500 x D	.250 x D	72	.0205	.0274	.0342	.0410	.0479	.0547	.0684	.0752	.0855	.1094
		Peripheral -Finish	3.000 x D	.015 x D	90	.0204	.0272	.0340	.0408	.0477	.0544	.0680	.0748	.0850	.1088
		Peripheral -HEM	3.000 x D	.070 x D	65	.0718	.0958	.1197	.1436	.1678	.1915	.2394	.2633	.2992	.3830
		Slotting -Traditional	.450 x D	1.000 x D	67	.0222	.0296	.0370	.0445	.0519	.0593	.0741	.0815	.0926	.1186
		Rough Facing	.300 x D	.700 x D	80	.0190	.0253	.0316	.0379	.0443	.0505	.0632	.0695	.0790	.1011
		Finish Facing	.020 x D	.700 x D	99	.0220	.0294	.0367	.0441	.0515	.0588	.0734	.0808	.0918	.1175
		Helical Entry	2.000 x D	12 deg	78	.0226	.0301	.0376	.0451	.0527	.0602	.0752	.0828	.0940	.1204
		Straight Line Ramp	.450 x D	12 deg	68	.0207	.0277	.0346	.0415	.0485	.0553	.0692	.0761	.0864	.1107
		Trad. Style Pocket	.450 x D	.550 x D	65	.0217	.0289	.0361	.0433	.0506	.0578	.0722	.0794	.0902	.1155
	Nickel Chromium-based super alloys Inconel 718, Rene 88 10-25 HRC	Peripheral -Rough	1.250 x D	.225 x D	22	.0182	.0243	.0304	.0365	.0426	.0486	.0608	.0669	.0760	.0973
		Peripheral -Finish	3.000 x D	.015 x D	28	.0420	.0560	.0700	.0840	.0981	.1120	.1400	.1540	.1750	.2240
		Peripheral -HEM	2.000 x D	.060 x D	26	.0969	.1292	.1615	.1938	.2264	.2584	.3230	.3553	.4037	.5168
		Slotting -Traditional	.300 x D	1.000 x D	18	.0129	.0172	.0214	.0257	.0301	.0343	.0429	.0472	.0536	.0686
		Rough Facing	.280 x D	.700 x D	24	.0168	.0225	.0281	.0337	.0394	.0449	.0562	.0618	.0702	.0899
		Finish Facing	.020 x D	.650 x D	28	.0344	.0459	.0574	.0689	.0805	.0918	.1148	.1263	.1435	.1837
		Helical Entry	1.000 x D	8 deg	22	.0198	.0264	.0330	.0396	.0463	.0528	.0660	.0726	.0825	.1056
		Straight Line Ramp	.250 x D	8 deg	18	.0129	.0172	.0214	.0257	.0301	.0343	.0429	.0472	.0536	.0686
		Trad. Style Pocket	.300 x D	.500 x D	17	.0125	.0167	.0209	.0251	.0293	.0334	.0418	.0460	.0522	.0669
N	Aluminum alloys O-T6 2024, 6061, 7075	Peripheral -Rough	2.250 x D	.600 x D	229	.0720	.0960	.1200	.1440	.1682	.1920	.2400	.2640	.3000	.3840
		Peripheral -Finish	3.000 x D	.020 x D	274	.0456	.0608	.0760	.0912	.1065	.1216	.1520	.1672	.1900	.2432
		Peripheral -HEM	3.000 x D	.250 x D	274	.1080	.1440	.1800	.2160	.2523	.2880	.3600	.3960	.4500	.5760
		Slotting -Traditional	1.750 x D	1.000 x D	213	.0444	.0592	.0740	.0888	.1037	.1184	.1480	.1628	.1850	.2368
		Rough Facing	.375 x D	.700 x D	251	.0597	.0796	.0994	.1193	.1394	.1591	.1989	.2188	.2486	.3182
		Finish Facing	.020 x D	.700 x D	287	.0368	.0491	.0614	.0736	.0860	.0982	.1227	.1350	.1534	.1964
		Helical Entry	3.000 x D	25 deg	277	.0355	.0474	.0592	.0710	.0830	.0947	.1184	.1302	.1480	.1894
		Straight Line Ramp	1.750 x D	25 deg	267	.0347	.0462	.0578	.0693	.0810	.0924	.1155	.1271	.1444	.1848
		Trad. Style Pocket	1.750 x D	.450 x D	213	.0444	.0592	.0740	.0888	.1037	.1184	.1480	.1628	.1850	.2368

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)									
						6.0	8.0	10.0	12.0	14.0	16.0	20.0	22.0	25.0	32.0
N	High-silicon aluminum alloys A380, A390 45-75 Bhn	Peripheral -Rough	2.250 x D	.600 x D	226	.0720	.0960	.1200	.1440	.1682	.1920	.2400	.2640	.3000	.3840
		Peripheral -Finish	3.000 x D	.020 x D	244	.0432	.0576	.0720	.0864	.1009	.1152	.1440	.1584	.1800	.2304
		Peripheral -HEM	3.000 x D	.250 x D	229	.0780	.1040	.1300	.1560	.1822	.2080	.2600	.2860	.3250	.4160
		Slotting -Traditional	1.750 x D	1.000 x D	188	.0376	.0502	.0627	.0752	.0879	.1003	.1254	.1379	.1567	.2006
		Rough Facing	.375 x D	.700 x D	248	.0597	.0796	.0994	.1193	.1394	.1591	.1989	.2188	.2486	.3182
		Finish Facing	.020 x D	.700 x D	255	.0349	.0465	.0581	.0698	.0815	.0930	.1163	.1279	.1453	.1860
		Helical Entry	3.000 x D	20 deg	258	.0317	.0422	.0528	.0634	.0740	.0845	.1056	.1162	.1320	.1690
		Straight Line Ramp	1.750 x D	20 deg	238	.0312	.0416	.0520	.0624	.0728	.0832	.1039	.1143	.1299	.1663
		Trad. Style Pocket	1.750 x D	.450 x D	198	.0396	.0528	.0660	.0792	.0925	.1056	.1320	.1452	.1650	.2112
	Magnesium alloys 47-140 Bhn	Peripheral -Rough	2.250 x D	.600 x D	229	.0720	.0960	.1200	.1440	.1682	.1920	.2400	.2640	.3000	.3840
		Peripheral -Finish	3.000 x D	.020 x D	274	.0456	.0608	.0760	.0912	.1065	.1216	.1520	.1672	.1900	.2432
		Peripheral -HEM	3.000 x D	.250 x D	261	.1026	.1368	.1710	.2052	.2397	.2736	.3420	.3762	.4275	.5472
		Slotting -Traditional	1.750 x D	1.000 x D	213	.0444	.0592	.0740	.0888	.1037	.1184	.1480	.1628	.1850	.2368
		Rough Facing	.375 x D	.700 x D	251	.0597	.0796	.0994	.1193	.1394	.1591	.1989	.2188	.2486	.3182
		Finish Facing	.020 x D	.700 x D	287	.0368	.0491	.0614	.0736	.0860	.0982	.1227	.1350	.1534	.1964
		Helical Entry	3.000 x D	25 deg	277	.0355	.0474	.0592	.0710	.0830	.0947	.1184	.1302	.1480	.1894
		Straight Line Ramp	1.750 x D	25 deg	267	.0347	.0462	.0578	.0693	.0810	.0924	.1155	.1271	.1444	.1848
		Trad. Style Pocket	1.750 x D	.450 x D	213	.0444	.0592	.0740	.0888	.1037	.1184	.1480	.1628	.1850	.2368
	Copper, brass 111-170 Bhn	Peripheral -Rough	2.250 x D	.600 x D	130	.0399	.0532	.0665	.0798	.0932	.1064	.1330	.1463	.1662	.2128
		Peripheral -Finish	3.000 x D	.015 x D	174	.0388	.0517	.0646	.0775	.0905	.1034	.1292	.1421	.1615	.2067
		Peripheral -HEM	3.000 x D	.100 x D	152	.0832	.1110	.1387	.1664	.1944	.2219	.2774	.3051	.3467	.4438
		Slotting -Traditional	1.500 x D	1.000 x D	109	.0399	.0532	.0665	.0798	.0932	.1064	.1330	.1463	.1662	.2128
		Rough Facing	.375 x D	.700 x D	151	.0377	.0502	.0628	.0753	.0880	.1005	.1256	.1381	.1570	.2009
		Finish Facing	.020 x D	.700 x D	201	.0358	.0477	.0597	.0716	.0836	.0955	.1193	.1313	.1492	.1909
		Helical Entry	3.000 x D	20 deg	130	.0399	.0532	.0665	.0798	.0932	.1064	.1330	.1463	.1662	.2128
		Straight Line Ramp	1.500 x D	20 deg	118	.0369	.0491	.0614	.0737	.0861	.0983	.1228	.1351	.1536	.1966
		Trad. Style Pocket	1.500 x D	.625 x D	114	.0420	.0560	.0700	.0840	.0981	.1120	.1400	.1540	.1750	.2240
	Bronze 111-201 Bhn	Peripheral -Rough	2.000 x D	.450 x D	127	.0365	.0486	.0608	.0730	.0852	.0973	.1216	.1338	.1520	.1946
		Peripheral -Finish	3.000 x D	.012 x D	166	.0353	.0471	.0589	.0707	.0826	.0942	.1178	.1296	.1472	.1885
		Peripheral -HEM	3.000 x D	.080 x D	153	.0842	.1123	.1404	.1685	.1968	.2246	.2808	.3089	.3510	.4493
		Slotting -Traditional	1.500 x D	1.000 x D	106	.0353	.0471	.0589	.0707	.0826	.0942	.1178	.1296	.1472	.1885
		Rough Facing	.375 x D	.700 x D	148	.0356	.0474	.0593	.0711	.0831	.0948	.1186	.1304	.1482	.1897
		Finish Facing	.020 x D	.700 x D	193	.0334	.0445	.0556	.0667	.0779	.0890	.1112	.1224	.1390	.1780
		Helical Entry	3.000 x D	20 deg	134	.0353	.0471	.0589	.0707	.0826	.0942	.1178	.1296	.1472	.1885
		Straight Line Ramp	1.500 x D	20 deg	114	.0326	.0435	.0544	.0653	.0763	.0870	.1088	.1197	.1360	.1741
		Trad. Style Pocket	1.500 x D	.625 x D	111	.0372	.0496	.0620	.0744	.0869	.0992	.1240	.1364	.1550	.1984
	Composites, plastics, fiberglass	Peripheral -Rough	2.250 x D	.450 x D	188	.0684	.0912	.1140	.1368	.1598	.1824	.2280	.2508	.2850	.3648
		Peripheral -Finish	3.000 x D	.020 x D	195	.0513	.0684	.0855	.1026	.1198	.1368	.1710	.1881	.2137	.2736
		Peripheral -HEM	3.000 x D	.100 x D	208	.1003	.1338	.1672	.2006	.2343	.2675	.3344	.3678	.4180	.5350
		Slotting -Traditional	1.750 x D	1.000 x D	174	.0365	.0486	.0608	.0730	.0852	.0973	.1216	.1338	.1520	.1946
		Rough Facing	.375 x D	.700 x D	218	.0548	.0730	.0913	.1095	.1279	.1460	.1825	.2008	.2281	.2920
		Finish Facing	.020 x D	.700 x D	226	.0484	.0646	.0807	.0969	.1131	.1292	.1615	.1776	.2018	.2583
		Helical Entry	3.000 x D	25 deg	219	.0365	.0486	.0608	.0730	.0852	.0973	.1216	.1338	.1520	.1946
		Straight Line Ramp	1.750 x D	25 deg	192	.0337	.0449	.0562	.0674	.0787	.0899	.1123	.1236	.1404	.1797
		Trad. Style Pocket	1.750 x D	.625 x D	183	.0384	.0512	.0640	.0768	.0897	.1024	.1280	.1408	.1600	.2048