

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	9/16	5/8	3/4	1	1-1/4
K	Cast iron- Gray ASTM-A48 Class 20, 25,30, 35 & 40	Peripheral -Rough	1.300 x D	.450 x D	390	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -Finish	2.000 x D	.015 x D	375	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -HEM	2.000 x D	.100 x D	380	.0019	.0028	.0038	.0047	.0056	.0066	.0075	.0084	.0094	.0113	.0150	.0188
		Slotting -Traditional	1.500 x D	1.000 x D	340	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0048	.0060
		Rough Facing	.375 x D	.700 x D	468	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0030	.0034	.0041	.0054	.0068
		Finish Facing	.020 x D	.700 x D	408	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0030	.0034	.0041	.0054	.0068
		Helical Entry	2.000 x D	15 deg	359	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0020	.0023	.0027	.0036	.0045
		Straight Line Ramp	1.500 x D	15 deg	340	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0024	.0027	.0032	.0043	.0054
		Trad. Style Pocket	1.500 x D	.625 x D	340	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0048	.0060
	Cast iron- Ductile 15-25 HRC	Peripheral -Rough	1.300 x D	.450 x D	360	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
		Peripheral -Finish	2.000 x D	.015 x D	360	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
		Peripheral -HEM	2.000 x D	.070 x D	395	.0021	.0032	.0043	.0053	.0064	.0074	.0085	.0096	.0106	.0128	.0170	.0213
		Slotting -Traditional	1.500 x D	1.000 x D	330	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
		Rough Facing	.375 x D	.700 x D	432	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0028	.0032	.0038	.0050	.0063
		Finish Facing	.020 x D	.700 x D	391	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0031	.0034	.0041	.0055	.0068
		Helical Entry	2.000 x D	18 deg	368	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0021	.0023	.0028	.0037	.0047
		Straight Line Ramp	1.500 x D	16 deg	330	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0022	.0025	.0030	.0040	.0050
		Trad. Style Pocket	1.500 x D	.625 x D	330	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
	Cast iron- Malleable 15-25 HRC	Peripheral -Rough	1.300 x D	.450 x D	340	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0030	.0034	.0041	.0054	.0068
		Peripheral -Finish	3.000 x D	.015 x D	360	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0030	.0034	.0041	.0054	.0068
		Peripheral -HEM	2.000 x D	.070 x D	395	.0021	.0031	.0042	.0052	.0062	.0073	.0083	.0093	.0104	.0125	.0166	.0208
		Slotting -Traditional	1.500 x D	1.000 x D	335	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
		Rough Facing	.375 x D	.700 x D	408	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0049	.0061
		Finish Facing	.020 x D	.700 x D	391	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0030	.0033	.0039	.0053	.0066
		Helical Entry	2.000 x D	18 deg	374	.0005	.0007	.0009	.0012	.0014	.0016	.0019	.0021	.0023	.0028	.0037	.0047
		Straight Line Ramp	1.500 x D	16 deg	335	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0022	.0025	.0030	.0040	.0050
		Trad. Style Pocket	1.500 x D	.625 x D	335	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
P	Low carbon steel ≤38 HRC 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	1.500 x D	.400 x D	425	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0037	.0041	.0050	.0066	.0083
		Peripheral -Finish	2.000 x D	.015 x D	434	.0010	.0015	.0019	.0024	.0029	.0034	.0039	.0044	.0048	.0058	.0078	.0097
		Peripheral -HEM	2.000 x D	.080 x D	435	.0030	.0045	.0060	.0075	.0090	.0105	.0120	.0135	.0150	.0180	.0240	.0300
		Slotting -Traditional	1.500 x D	1.000 x D	375	.0005	.0008	.0011	.0013	.0016	.0018	.0021	.0024	.0026	.0032	.0042	.0053
		Rough Facing	.375 x D	.700 x D	502	.0007	.0011	.0015	.0019	.0022	.0026	.0030	.0033	.0037	.0045	.0059	.0074
		Finish Facing	.020 x D	.700 x D	446	.0009	.0014	.0018	.0023	.0027	.0032	.0036	.0041	.0045	.0054	.0073	.0091
		Helical Entry	2.000 x D	18 deg	405	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0021	.0026	.0034	.0043
		Straight Line Ramp	1.500 x D	15 deg	413	.0003	.0005	.0007	.0008	.0010	.0011	.0013	.0015	.0016	.0020	.0026	.0033
		Trad. Style Pocket	1.500 x D	.625 x D	375	.0005	.0008	.0011	.0013	.0016	.0018	.0021	.0024	.0026	.0032	.0042	.0053
	Medium carbon Steel ≤40 HRC 1045, 4140, 4340, 5140	Peripheral -Rough	1.500 x D	.350 x D	420	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -Finish	2.000 x D	.015 x D	400	.0009	.0013	.0018	.0022	.0026	.0031	.0035	.0039	.0044	.0053	.0070	.0088
		Peripheral -HEM	2.000 x D	.080 x D	415	.0027	.0040	.0054	.0067	.0080	.0094	.0107	.0120	.0134	.0161	.0214	.0268
		Slotting -Traditional	1.500 x D	1.000 x D	370	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0023	.0025	.0030	.0040	.0050
		Rough Facing	.375 x D	.700 x D	496	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0030	.0034	.0041	.0054	.0068
		Finish Facing	.020 x D	.700 x D	420	.0008	.0012	.0017	.0021	.0025	.0029	.0033	.0037	.0042	.0050	.0067	.0083
		Helical Entry	2.000 x D	18 deg	410	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0021	.0026	.0034	.0043
		Straight Line Ramp	1.500 x D	15 deg	407	.0003	.0005	.0007	.0008	.0010	.0011	.0013	.0015	.0016	.0020	.0026	.0033
		Trad. Style Pocket	1.500 x D	.625 x D	370	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0023	.0025	.0030	.0040	.0050

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						1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	1	1-1/4
P	Tool & die steels ≤34 HRc A2, D2, O1, S7, P20, H13	Peripheral -Rough	1.500 x D	.325 x D	380	.0007	.0010	.0014	.0017	.0020	.0024	.0027	.0030	.0034	.0041	.0054	.0068
		Peripheral -Finish	2.000 x D	.015 x D	375	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -HEM	2.000 x D	.080 x D	395	.0022	.0033	.0044	.0055	.0066	.0077	.0088	.0099	.0110	.0132	.0176	.0220
		Slotting -Traditional	1.250 x D	1.000 x D	360	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0020	.0023	.0027	.0036	.0045
		Rough Facing	.375 x D	.700 x D	448	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0049	.0061
		Finish Facing	.020 x D	.700 x D	394	.0007	.0011	.0014	.0018	.0021	.0025	.0029	.0032	.0036	.0043	.0057	.0071
		Helical Entry	2.000 x D	16 deg	392	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0018	.0020	.0024	.0032	.0040
		Straight Line Ramp	1.250 x D	14 deg	396	.0003	.0004	.0006	.0007	.0009	.0010	.0012	.0013	.0015	.0018	.0024	.0030
		Trad. Style Pocket	1.250 x D	.625 x D	360	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0020	.0023	.0027	.0036	.0045
H	Tool & die steels 40-48- HRc	Peripheral -Rough	1.250 x D	.250 x D	325	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0026	.0029	.0035	.0046	.0058
		Peripheral -Finish	2.000 x D	.012 x D	310	.0006	.0009	.0012	.0014	.0017	.0020	.0023	.0026	.0029	.0035	.0046	.0058
		Peripheral -HEM	2.000 x D	.060 x D	350	.0021	.0031	.0041	.0051	.0062	.0072	.0082	.0092	.0103	.0123	.0164	.0205
		Slotting -Traditional	.750 x D	1.000 x D	300	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0021	.0026	.0034	.0043
		Rough Facing	.350 x D	.700 x D	358	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0025	.0027	.0033	.0044	.0055
		Finish Facing	.020 x D	.650 x D	324	.0005	.0008	.0011	.0014	.0016	.0019	.0022	.0025	.0027	.0033	.0044	.0055
		Helical Entry	1.000 x D	12 deg	300	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0017	.0019	.0023	.0030	.0038
		Straight Line Ramp	.750 x D	6 deg	324	.0002	.0004	.0005	.0006	.0007	.0008	.0010	.0011	.0012	.0015	.0019	.0024
		Trad. Style Pocket	.750 x D	.400 x D	300	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0021	.0026	.0034	.0043
M	Martensitic & ferritic stainless steels 15-29 HRc 410, 416, 440	Peripheral -Rough	1.250 x D	.350 x D	380	.0009	.0013	.0017	.0021	.0026	.0030	.0034	.0038	.0043	.0051	.0068	.0085
		Peripheral -Finish	2.000 x D	.015 x D	385	.0009	.0013	.0018	.0022	.0026	.0031	.0035	.0040	.0044	.0053	.0070	.0088
		Peripheral -HEM	2.000 x D	.070 x D	415	.0026	.0039	.0053	.0066	.0079	.0092	.0105	.0118	.0131	.0158	.0210	.0263
		Slotting -Traditional	1.500 x D	1.000 x D	315	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
		Rough Facing	.375 x D	.700 x D	456	.0008	.0011	.0015	.0019	.0023	.0027	.0031	.0034	.0038	.0046	.0061	.0077
		Finish Facing	.020 x D	.700 x D	404	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0036	.0040	.0048	.0064	.0081
		Helical Entry	2.000 x D	14 deg	408	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0015	.0017	.0021	.0027	.0034
		Straight Line Ramp	1.500 x D	14 deg	315	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0024	.0026	.0031	.0042	.0052
		Trad. Style Pocket	1.500 x D	.625 x D	315	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
	Austenitic stainless steels 15-29 HRc FeNi alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	1.250 x D	.350 x D	365	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0036	.0040	.0048	.0064	.0080
		Peripheral -Finish	2.000 x D	.015 x D	365	.0008	.0012	.0016	.0020	.0024	.0028	.0032	.0036	.0040	.0048	.0064	.0080
		Peripheral -HEM	2.000 x D	.070 x D	395	.0025	.0038	.0050	.0063	.0075	.0088	.0100	.0113	.0125	.0150	.0200	.0250
		Slotting -Traditional	1.500 x D	1.000 x D	305	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
		Rough Facing	.375 x D	.700 x D	438	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0032	.0036	.0043	.0058	.0072
		Finish Facing	.020 x D	.700 x D	383	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
		Helical Entry	2.000 x D	14 deg	408	.0003	.0005	.0007	.0009	.0010	.0012	.0014	.0015	.0017	.0021	.0027	.0034
		Straight Line Ramp	1.500 x D	14 deg	305	.0005	.0008	.0010	.0013	.0016	.0018	.0021	.0024	.0026	.0031	.0042	.0052
		Trad. Style Pocket	1.500 x D	.625 x D	305	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
	Precipitation hardening stainless steel 15-38 HRc 17-4, 15-5, 13-8	Peripheral -Rough	1.250 x D	.375 x D	350	.0007	.0011	.0015	.0018	.0022	.0025	.0029	.0033	.0036	.0044	.0058	.0073
		Peripheral -Finish	2.000 x D	.012 x D	321	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0029	.0033	.0039	.0052	.0065
		Peripheral -HEM	2.000 x D	.070 x D	365	.0020	.0030	.0041	.0051	.0061	.0071	.0081	.0091	.0101	.0122	.0162	.0203
		Slotting -Traditional	1.000 x D	1.000 x D	295	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0023	.0025	.0030	.0040	.0050
		Rough Facing	.375 x D	.700 x D	420	.0007	.0010	.0013	.0016	.0020	.0023	.0026	.0029	.0033	.0039	.0052	.0065
		Finish Facing	.020 x D	.700 x D	357	.0006	.0009	.0012	.0016	.0019	.0022	.0025	.0028	.0031	.0037	.0050	.0062
		Helical Entry	2.000 x D	12 deg	354	.0003	.0005	.0006	.0008	.0010	.0011	.0013	.0014	.0016	.0019	.0026	.0032
		Straight Line Ramp	1.000 x D	12 deg	295	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0021	.0024	.0029	.0038	.0048
		Trad. Style Pocket	1.000 x D	.625 x D	295	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0023	.0025	.0030	.0040	.0050

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						1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	1	1-1/4
S	Titanium alloys 6AL-4V, 6-2-4 18-31 HRC	Peripheral -Rough	1.500 x D	.400 x D	355	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
		Peripheral -Finish	2.000 x D	.020 x D	385	.0005	.0008	.0011	.0013	.0016	.0018	.0021	.0024	.0026	.0032	.0042	.0053
		Peripheral -HEM	2.000 x D	.080 x D	400	.0016	.0024	.0033	.0041	.0049	.0057	.0065	.0073	.0081	.0098	.0130	.0163
		Slotting -Traditional	1.500 x D	1.000 x D	300	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
		Rough Facing	.375 x D	.700 x D	391	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0028	.0032	.0038	.0050	.0063
		Finish Facing	.020 x D	.700 x D	402	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0021	.0023	.0028	.0037	.0046
		Helical Entry	2.000 x D	16 deg	425	.0004	.0006	.0008	.0011	.0013	.0015	.0017	.0019	.0021	.0025	.0034	.0042
		Straight Line Ramp	1.500 x D	15 deg	315	.0005	.0007	.0010	.0012	.0015	.0017	.0020	.0022	.0025	.0030	.0040	.0050
		Trad. Style Pocket	1.500 x D	.625 x D	300	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
	Difficult-to-machine titanium alloys 10-2-3 18-31 HRC	Peripheral -Rough	1.500 x D	.375 x D	295	.0005	.0008	.0010	.0013	.0015	.0018	.0020	.0023	.0025	.0030	.0040	.0050
		Peripheral -Finish	2.000 x D	.010 x D	300	.0005	.0008	.0011	.0013	.0016	.0018	.0021	.0024	.0026	.0032	.0042	.0053
		Peripheral -HEM	2.000 x D	.075 x D	375	.0014	.0021	.0028	.0034	.0041	.0048	.0055	.0062	.0069	.0083	.0110	.0138
		Slotting -Traditional	1.250 x D	1.000 x D	275	.0005	.0008	.0011	.0013	.0016	.0018	.0021	.0024	.0026	.0032	.0042	.0053
		Rough Facing	.300 x D	.700 x D	325	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0020	.0023	.0027	.0036	.0045
		Finish Facing	.020 x D	.700 x D	314	.0005	.0007	.0009	.0012	.0014	.0017	.0019	.0021	.0024	.0028	.0038	.0047
		Helical Entry	2.000 x D	15 deg	440	.0004	.0006	.0008	.0010	.0012	.0014	.0016	.0018	.0020	.0024	.0032	.0039
		Straight Line Ramp	1.500 x D	14 deg	289	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0021	.0024	.0029	.0038	.0048
		Trad. Style Pocket	1.250 x D	.625 x D	275	.0005	.0008	.0011	.0013	.0016	.0018	.0021	.0024	.0026	.0032	.0042	.0053
	Nickel-based super alloys Hastalloy, Waspalloy 15-30 HRC	Peripheral -Rough	1.500 x D	.200 x D	270	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0021	.0026	.0034	.0043
		Peripheral -Finish	2.000 x D	.015 x D	280	.0005	.0007	.0009	.0011	.0014	.0016	.0018	.0020	.0023	.0027	.0036	.0045
		Peripheral -HEM	2.000 x D	.070 x D	300	.0016	.0024	.0032	.0039	.0047	.0055	.0063	.0071	.0079	.0095	.0126	.0158
		Slotting -Traditional	.500 x D	1.000 x D	225	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0021	.0024	.0029	.0038	.0048
		Rough Facing	.300 x D	.700 x D	297	.0004	.0006	.0008	.0010	.0011	.0013	.0015	.0017	.0019	.0023	.0031	.0038
		Finish Facing	.020 x D	.700 x D	293	.0005	.0007	.0010	.0012	.0015	.0017	.0019	.0022	.0024	.0029	.0039	.0049
		Helical Entry	2.000 x D	10 deg	270	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0021	.0026	.0034	.0043
		Straight Line Ramp	.500 x D	13 deg	236	.0004	.0006	.0009	.0011	.0013	.0015	.0017	.0019	.0022	.0026	.0035	.0043
		Trad. Style Pocket	.500 x D	.550 x D	225	.0005	.0007	.0010	.0012	.0014	.0017	.0019	.0021	.0024	.0029	.0038	.0048
	Nickel Chromium- based super alloys Inconel 718, Rene 88 10-25 HRC	Peripheral -Rough	1.250 x D	.200 x D	80	.0004	.0005	.0007	.0009	.0011	.0012	.0014	.0016	.0018	.0021	.0028	.0035
		Peripheral -Finish	2.000 x D	.015 x D	95	.0009	.0013	.0018	.0022	.0026	.0031	.0035	.0039	.0044	.0053	.0070	.0088
		Peripheral -HEM	2.000 x D	.060 x D	95	.0023	.0035	.0047	.0058	.0070	.0081	.0093	.0105	.0116	.0140	.0186	.0233
		Slotting -Traditional	.500 x D	1.000 x D	85	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0017	.0019	.0023	.0030	.0038
		Rough Facing	.300 x D	.700 x D	88	.0003	.0005	.0006	.0008	.0009	.0011	.0013	.0014	.0016	.0019	.0025	.0032
		Finish Facing	.020 x D	.650 x D	92	.0007	.0011	.0014	.0018	.0022	.0025	.0029	.0032	.0036	.0043	.0057	.0072
		Helical Entry	1.000 x D	8 deg	106	.0004	.0005	.0007	.0009	.0011	.0012	.0014	.0016	.0018	.0021	.0028	.0035
		Straight Line Ramp	.375 x D	6 deg	88	.0004	.0005	.0007	.0009	.0011	.0013	.0015	.0016	.0018	.0022	.0029	.0037
		Trad. Style Pocket	.500 x D	.500 x D	85	.0004	.0006	.0008	.0009	.0011	.0013	.0015	.0017	.0019	.0023	.0030	.0038
N	Aluminum alloys O-T6 2024, 6061, 7075	Peripheral -Rough	2.000 x D	.490 x D	750	.0015	.0023	.0030	.0038	.0045	.0053	.0060	.0068	.0075	.0090	.0120	.0150
		Peripheral -Finish	3.000 x D	.020 x D	800	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -HEM	2.000 x D	.250 x D	750	.0020	.0030	.0040	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0160	.0200
		Slotting -Traditional	1.750 x D	1.000 x D	700	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Rough Facing	.375 x D	.700 x D	825	.0013	.0019	.0026	.0032	.0038	.0045	.0051	.0057	.0064	.0077	.0102	.0128
		Finish Facing	.020 x D	.700 x D	880	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0029	.0032	.0038	.0051	.0064
		Helical Entry	2.000 x D	25 deg	850	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0048	.0060
		Straight Line Ramp	1.750 x D	18 deg	875	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0047	.0059
		Trad. Style Pocket	1.750 x D	.450 x D	700	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075

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	9/16	5/8	3/4	1	1-1/4
N	High-silicon aluminum alloys A380, A390 45-75 Bhn	Peripheral -Rough	2.000 x D	.490 x D	730	.0013	.0019	.0025	.0031	.0038	.0044	.0050	.0056	.0063	.0075	.0100	.0125
		Peripheral -Finish	2.000 x D	.020 x D	775	.0007	.0011	.0015	.0018	.0022	.0025	.0029	.0033	.0036	.0044	.0058	.0073
		Peripheral -HEM	2.000 x D	.250 x D	730	.0018	.0026	.0035	.0044	.0053	.0061	.0070	.0079	.0088	.0105	.0140	.0175
		Slotting -Traditional	1.750 x D	1.000 x D	650	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
		Rough Facing	.375 x D	.700 x D	803	.0011	.0016	.0021	.0027	.0032	.0037	.0043	.0048	.0053	.0064	.0085	.0106
		Finish Facing	.020 x D	.700 x D	853	.0006	.0009	.0012	.0015	.0018	.0022	.0025	.0028	.0031	.0037	.0049	.0062
		Helical Entry	2.000 x D	20 deg	845	.0006	.0008	.0011	.0014	.0017	.0020	.0022	.0025	.0028	.0034	.0045	.0056
		Straight Line Ramp	1.750 x D	18 deg	748	.0006	.0009	.0011	.0014	.0017	.0020	.0023	.0026	.0028	.0034	.0045	.0057
		Trad. Style Pocket	1.750 x D	.450 x D	650	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
	Magnesium alloys 47-140 Bhn	Peripheral -Rough	2.000 x D	.490 x D	750	.0015	.0023	.0030	.0038	.0045	.0053	.0060	.0068	.0075	.0090	.0120	.0150
		Peripheral -Finish	2.000 x D	.020 x D	800	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -HEM	2.000 x D	.250 x D	750	.0020	.0030	.0040	.0050	.0060	.0070	.0080	.0090	.0100	.0120	.0160	.0200
		Slotting -Traditional	1.750 x D	1.000 x D	700	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Rough Facing	.375 x D	.700 x D	825	.0013	.0019	.0026	.0032	.0038	.0045	.0051	.0057	.0064	.0077	.0102	.0128
		Finish Facing	.020 x D	.700 x D	880	.0006	.0010	.0013	.0016	.0019	.0022	.0026	.0029	.0032	.0038	.0051	.0064
		Helical Entry	2.000 x D	25 deg	910	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0048	.0060
		Straight Line Ramp	1.750 x D	18 deg	875	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0047	.0059
		Trad. Style Pocket	1.750 x D	.450 x D	700	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
	Copper, brass 111-170 Bhn	Peripheral -Rough	2.000 x D	.350 x D	400	.0008	.0011	.0015	.0019	.0023	.0026	.0030	.0034	.0038	.0045	.0060	.0075
		Peripheral -Finish	2.000 x D	.015 x D	400	.0006	.0009	.0013	.0016	.0019	.0022	.0025	.0028	.0031	.0038	.0050	.0063
		Peripheral -HEM	2.000 x D	.250 x D	600	.0013	.0019	.0025	.0031	.0038	.0044	.0050	.0056	.0063	.0075	.0100	.0125
		Slotting -Traditional	1.500 x D	1.000 x D	375	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
		Rough Facing	.375 x D	.700 x D	440	.0007	.0010	.0014	.0017	.0021	.0024	.0028	.0031	.0035	.0041	.0055	.0069
		Finish Facing	.020 x D	.700 x D	440	.0006	.0008	.0011	.0014	.0017	.0020	.0023	.0025	.0028	.0034	.0045	.0056
		Helical Entry	2.000 x D	18 deg	450	.0008	.0012	.0015	.0019	.0023	.0027	.0031	.0035	.0038	.0046	.0061	.0077
		Straight Line Ramp	1.500 x D	16 deg	388	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0033	.0037	.0044	.0059	.0074
		Trad. Style Pocket	1.500 x D	.625 x D	375	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
	Bronze 111-201 Bhn	Peripheral -Rough	2.000 x D	.350 x D	390	.0007	.0011	.0014	.0018	.0021	.0025	.0028	.0032	.0035	.0042	.0056	.0070
		Peripheral -Finish	2.000 x D	.015 x D	395	.0006	.0009	.0012	.0015	.0018	.0021	.0024	.0027	.0030	.0036	.0048	.0060
		Peripheral -HEM	2.000 x D	.200 x D	490	.0012	.0018	.0024	.0030	.0036	.0042	.0048	.0054	.0060	.0072	.0096	.0120
		Slotting -Traditional	1.500 x D	1.000 x D	365	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
		Rough Facing	.375 x D	.700 x D	429	.0007	.0010	.0013	.0017	.0020	.0023	.0027	.0030	.0033	.0040	.0053	.0067
		Finish Facing	.020 x D	.700 x D	435	.0006	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033	.0044	.0055
		Helical Entry	2.000 x D	18 deg	438	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
		Straight Line Ramp	1.500 x D	16 deg	374	.0007	.0011	.0015	.0018	.0022	.0026	.0029	.0033	.0037	.0044	.0059	.0074
		Trad. Style Pocket	1.500 x D	.625 x D	365	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
	Composites, plastics, fiberglass	Peripheral -Rough	2.000 x D	.490 x D	650	.0010	.0015	.0020	.0025	.0030	.0035	.0040	.0045	.0050	.0060	.0080	.0100
		Peripheral -Finish	2.000 x D	.020 x D	500	.0008	.0012	.0016	.0019	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
		Peripheral -HEM	2.000 x D	.250 x D	700	.0013	.0020	.0026	.0033	.0039	.0046	.0052	.0059	.0065	.0078	.0104	.0130
		Slotting -Traditional	1.750 x D	1.000 x D	655	.0010	.0015	.0020	.0025	.0030	.0035	.0040	.0045	.0050	.0060	.0080	.0100
		Rough Facing	.375 x D	.700 x D	715	.0008	.0012	.0016	.0020	.0023	.0027	.0031	.0035	.0039	.0047	.0062	.0078
		Finish Facing	.020 x D	.700 x D	550	.0007	.0011	.0014	.0018	.0021	.0025	.0029	.0032	.0036	.0043	.0057	.0071
		Helical Entry	2.000 x D	20 deg	786	.0010	.0015	.0020	.0025	.0030	.0035	.0040	.0045	.0050	.0060	.0080	.0100
		Straight Line Ramp	1.750 x D	18 deg	671	.0010	.0014	.0019	.0024	.0029	.0033	.0038	.0043	.0048	.0057	.0076	.0095
		Trad. Style Pocket	1.750 x D	.625 x D	655	.0010	.0015	.0020	.0025	.0030	.0035	.0040	.0045	.0050	.0060	.0080	.0100