

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)														
						3.0	3.5	4.0	4.5	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	32.0
K	Cast iron- Gray ASTM-A48 Class 20, 25,30, 35 & 40	Peripheral -Rough	1.300 x D	.450 x D	119	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -Finish	2.000 x D	.015 x D	114	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -HEM	2.000 x D	.100 x D	116	.0450	.0525	.0600	.0675	.0750	.0900	.1200	.1500	.1800	.2102	.2400	.2700	.3000	.3750	.4800
		Slotting -Traditional	1.500 x D	1.000 x D	104	.0144	.0168	.0192	.0216	.0240	.0288	.0384	.0480	.0576	.0673	.0768	.0864	.0960	.1200	.1536
		Rough Facing	.375 x D	.700 x D	143	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Finish Facing	.020 x D	.700 x D	124	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Helical Entry	2.000 x D	15 deg	110	.0108	.0126	.0144	.0162	.0180	.0216	.0288	.0360	.0432	.0505	.0576	.0648	.0720	.0900	.1152
		Straight Line Ramp	1.500 x D	15 deg	104	.0130	.0151	.0173	.0194	.0216	.0259	.0346	.0432	.0518	.0605	.0691	.0778	.0864	.1080	.1382
		Trad. Style Pocket	1.500 x D	.625 x D	104	.0144	.0168	.0192	.0216	.0240	.0288	.0384	.0480	.0576	.0673	.0768	.0864	.0960	.1200	.1536
	Cast iron- Ductile 15-25 HRc	Peripheral -Rough	1.300 x D	.450 x D	110	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
		Peripheral -Finish	3.000 x D	.015 x D	110	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
		Peripheral -HEM	2.000 x D	.070 x D	120	.0510	.0595	.0680	.0765	.0850	.1020	.1360	.1700	.2040	.2383	.2720	.3060	.3400	.4250	.5440
		Slotting -Traditional	1.500 x D	1.000 x D	101	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
		Rough Facing	.375 x D	.700 x D	132	.0151	.0176	.0202	.0227	.0252	.0302	.0403	.0504	.0605	.0706	.0806	.0907	.1008	.1260	.1613
		Finish Facing	.020 x D	.700 x D	119	.0164	.0191	.0218	.0246	.0273	.0328	.0437	.0546	.0655	.0765	.0874	.0983	.1092	.1365	.1747
		Helical Entry	2.000 x D	18 deg	112	.0112	.0131	.0150	.0168	.0187	.0224	.0299	.0374	.0449	.0524	.0598	.0673	.0748	.0935	.1197
		Straight Line Ramp	1.500 x D	16 deg	101	.0119	.0139	.0158	.0178	.0198	.0238	.0317	.0396	.0475	.0555	.0634	.0713	.0792	.0990	.1267
		Trad. Style Pocket	1.500 x D	.625 x D	101	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
	Cast iron- Malleable 15-25 HRc	Peripheral -Rough	1.300 x D	.450 x D	104	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Peripheral -Finish	3.000 x D	.015 x D	110	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Peripheral -HEM	2.000 x D	.070 x D	120	.0498	.0581	.0664	.0747	.0830	.0996	.1328	.1660	.1992	.2327	.2656	.2988	.3320	.4150	.5312
		Slotting -Traditional	1.500 x D	1.000 x D	102	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
		Rough Facing	.375 x D	.700 x D	124	.0146	.0170	.0194	.0219	.0243	.0292	.0389	.0486	.0583	.0681	.0778	.0875	.0972	.1215	.1555
		Finish Facing	.020 x D	.700 x D	119	.0158	.0184	.0211	.0237	.0263	.0316	.0421	.0526	.0632	.0738	.0842	.0948	.1053	.1316	.1685
		Helical Entry	2.000 x D	18 deg	114	.0112	.0131	.0150	.0168	.0187	.0224	.0299	.0374	.0449	.0524	.0598	.0673	.0748	.0935	.1197
		Straight Line Ramp	1.500 x D	16 deg	102	.0119	.0139	.0158	.0178	.0198	.0238	.0317	.0396	.0475	.0555	.0634	.0713	.0792	.0990	.1267
		Trad. Style Pocket	1.500 x D	.625 x D	102	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
P	Low carbon steel ≤38 HRc 1018, 1020, 12L14, 5120, 8620	Peripheral -Rough	1.500 x D	.400 x D	130	.0198	.0231	.0264	.0297	.0330	.0396	.0528	.0660	.0792	.0925	.1056	.1188	.1320	.1650	.2112
		Peripheral -Finish	2.000 x D	.015 x D	132	.0233	.0271	.0310	.0349	.0388	.0465	.0620	.0775	.0930	.1086	.1240	.1395	.1550	.1938	.2481
		Peripheral -HEM	2.000 x D	.080 x D	133	.0720	.0840	.0960	.1080	.1200	.1440	.1920	.2400	.2880	.3364	.3840	.4320	.4800	.6000	.7680
		Slotting -Traditional	1.500 x D	1.000 x D	114	.0126	.0147	.0168	.0189	.0210	.0252	.0336	.0420	.0504	.0589	.0672	.0756	.0840	.1050	.1344
		Rough Facing	.375 x D	.700 x D	153	.0178	.0208	.0238	.0267	.0297	.0356	.0475	.0594	.0713	.0833	.0950	.1069	.1188	.1485	.1901
		Finish Facing	.020 x D	.700 x D	136	.0218	.0254	.0290	.0327	.0363	.0435	.0581	.0726	.0871	.1017	.1161	.1306	.1452	.1814	.2323
		Helical Entry	2.000 x D	18 deg	123	.0102	.0119	.0136	.0153	.0170	.0204	.0272	.0340	.0408	.0477	.0544	.0612	.0680	.0850	.1088
		Straight Line Ramp	1.500 x D	15 deg	126	.0079	.0092	.0105	.0118	.0131	.0157	.0210	.0262	.0315	.0368	.0420	.0472	.0525	.0656	.0840
		Trad. Style Pocket	1.500 x D	.625 x D	114	.0126	.0147	.0168	.0189	.0210	.0252	.0336	.0420	.0504	.0589	.0672	.0756	.0840	.1050	.1344
	Medium carbon Steel ≤40 HRc 1045, 4140, 4340, 5140	Peripheral -Rough	1.500 x D	.350 x D	128	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -Finish	2.000 x D	.015 x D	122	.0210	.0245	.0280	.0315	.0350	.0420	.0560	.0700	.0840	.0981	.1120	.1260	.1400	.1750	.2240
		Peripheral -HEM	2.000 x D	.080 x D	126	.0642	.0749	.0856	.0963	.1070	.1284	.1712	.2140	.2568	.2999	.3424	.3852	.4280	.5350	.6848
		Slotting -Traditional	1.500 x D	1.000 x D	113	.0120	.0140	.0160	.0180	.0200	.0240	.0320	.0400	.0480	.0561	.0640	.0720	.0800	.1000	.1280
		Rough Facing	.375 x D	.700 x D	151	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Finish Facing	.020 x D	.700 x D	128	.0199	.0233	.0266	.0299	.0332	.0399	.0532	.0665	.0798	.0932	.1064	.1197	.1330	.1662	.2128
		Helical Entry	2.000 x D	18 deg	125	.0102	.0119	.0136	.0153	.0170	.0204	.0272	.0340	.0408	.0477	.0544	.0612	.0680	.0850	.1088
		Straight Line Ramp	1.500 x D	15 deg	124	.0078	.0091	.0104	.0117	.0130	.0156	.0208	.0260	.0312	.0364	.0416	.0468	.0520	.0650	.0832
		Trad. Style Pocket	1.500 x D	.625 x D	113	.0120	.0140	.0160	.0180	.0200	.0240	.0320	.0400	.0480	.0561	.0640	.0720	.0800	.1000	.1280

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)														
						3.0	3.5	4.0	4.5	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	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	116	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Peripheral -Finish	2.000 x D	.015 x D	114	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -HEM	2.000 x D	.080 x D	120	.0528	.0616	.0704	.0792	.0880	.1056	.1408	.1760	.2112	.2467	.2816	.3168	.3520	.4400	.5632
		Slotting -Traditional	1.250 x D	1.000 x D	110	.0108	.0126	.0144	.0162	.0180	.0216	.0288	.0360	.0432	.0505	.0576	.0648	.0720	.0900	.1152
		Rough Facing	.375 x D	.700 x D	137	.0146	.0170	.0194	.0219	.0243	.0292	.0389	.0486	.0583	.0681	.0778	.0875	.0972	.1215	.1555
		Finish Facing	.020 x D	.700 x D	120	.0171	.0199	.0228	.0256	.0285	.0342	.0456	.0570	.0684	.0799	.0912	.1026	.1140	.1425	.1824
		Helical Entry	2.000 x D	16 deg	120	.0096	.0112	.0128	.0144	.0160	.0192	.0256	.0320	.0384	.0449	.0512	.0576	.0640	.0800	.1024
		Straight Line Ramp	1.250 x D	14 deg	121	.0071	.0083	.0095	.0107	.0119	.0143	.0190	.0238	.0285	.0333	.0380	.0428	.0475	.0594	.0760
		Trad. Style Pocket	1.250 x D	.625 x D	110	.0108	.0126	.0144	.0162	.0180	.0216	.0288	.0360	.0432	.0505	.0576	.0648	.0720	.0900	.1152
H	Tool & die steels 40-48- HRC	Peripheral -Rough	1.250 x D	.250 x D	99	.0138	.0161	.0184	.0207	.0230	.0276	.0368	.0460	.0552	.0645	.0736	.0828	.0920	.1150	.1472
		Peripheral -Finish	2.000 x D	.012 x D	94	.0138	.0161	.0184	.0207	.0230	.0276	.0368	.0460	.0552	.0645	.0736	.0828	.0920	.1150	.1472
		Peripheral -HEM	2.000 x D	.060 x D	107	.0492	.0574	.0656	.0738	.0820	.0984	.1312	.1640	.1968	.2299	.2624	.2952	.3280	.4100	.5248
		Slotting -Traditional	.750 x D	1.000 x D	91	.0102	.0119	.0136	.0153	.0170	.0204	.0272	.0340	.0408	.0477	.0544	.0612	.0680	.0850	.1088
		Rough Facing	.350 x D	.700 x D	109	.0131	.0153	.0175	.0197	.0218	.0262	.0350	.0437	.0524	.0612	.0699	.0787	.0874	.1092	.1398
		Finish Facing	.020 x D	.650 x D	99	.0131	.0153	.0175	.0197	.0218	.0262	.0350	.0437	.0524	.0612	.0699	.0787	.0874	.1092	.1398
		Helical Entry	1.000 x D	12 deg	91	.0090	.0105	.0120	.0135	.0150	.0180	.0240	.0300	.0360	.0420	.0480	.0540	.0600	.0750	.0960
		Straight Line Ramp	.750 x D	6 deg	99	.0058	.0068	.0078	.0087	.0097	.0116	.0155	.0194	.0233	.0272	.0310	.0349	.0388	.0484	.0620
		Trad. Style Pocket	.750 x D	.400 x D	91	.0102	.0119	.0136	.0153	.0170	.0204	.0272	.0340	.0408	.0477	.0544	.0612	.0680	.0850	.1088
M	Martensitic & ferritic stainless steels 15-29 HRC 410, 416, 440	Peripheral -Rough	1.250 x D	.350 x D	116	.0204	.0238	.0272	.0306	.0340	.0408	.0544	.0680	.0816	.0953	.1088	.1224	.1360	.1700	.2176
		Peripheral -Finish	2.000 x D	.015 x D	117	.0211	.0246	.0281	.0317	.0352	.0422	.0563	.0703	.0844	.0986	.1126	.1266	.1407	.1759	.2251
		Peripheral -HEM	2.000 x D	.070 x D	126	.0630	.0735	.0840	.0945	.1050	.1260	.1680	.2100	.2520	.2943	.3360	.3780	.4200	.5250	.6720
		Slotting -Traditional	1.500 x D	1.000 x D	96	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
		Rough Facing	.375 x D	.700 x D	139	.0184	.0214	.0245	.0275	.0306	.0367	.0490	.0612	.0734	.0858	.0979	.1102	.1224	.1530	.1958
		Finish Facing	.020 x D	.700 x D	123	.0193	.0225	.0258	.0290	.0322	.0386	.0515	.0644	.0773	.0903	.1030	.1159	.1288	.1610	.2061
		Helical Entry	2.000 x D	14 deg	124	.0082	.0096	.0109	.0123	.0137	.0164	.0219	.0273	.0328	.0383	.0438	.0492	.0547	.0684	.0875
		Straight Line Ramp	1.500 x D	14 deg	96	.0125	.0146	.0167	.0188	.0209	.0251	.0334	.0418	.0502	.0586	.0669	.0752	.0836	.1045	.1338
		Trad. Style Pocket	1.500 x D	.625 x D	96	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
	Austenitic stainless steels 15-29 HRC FeNi alloys 303, 304, 316, Invar, Kovar	Peripheral -Rough	1.250 x D	.350 x D	111	.0192	.0224	.0256	.0288	.0320	.0384	.0512	.0640	.0768	.0897	.1024	.1152	.1280	.1600	.2048
		Peripheral -Finish	2.000 x D	.015 x D	111	.0192	.0224	.0256	.0288	.0320	.0384	.0512	.0640	.0768	.0897	.1024	.1152	.1280	.1600	.2048
		Peripheral -HEM	2.000 x D	.070 x D	120	.0600	.0700	.0800	.0900	.1000	.1200	.1600	.2000	.2400	.2803	.3200	.3600	.4000	.5000	.6400
		Slotting -Traditional	1.500 x D	1.000 x D	93	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
		Rough Facing	.375 x D	.700 x D	134	.0173	.0202	.0230	.0259	.0288	.0346	.0461	.0576	.0691	.0807	.0922	.1037	.1152	.1440	.1843
		Finish Facing	.020 x D	.700 x D	117	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
		Helical Entry	2.000 x D	14 deg	120	.0082	.0096	.0109	.0123	.0137	.0164	.0219	.0273	.0328	.0383	.0438	.0492	.0547	.0684	.0875
		Straight Line Ramp	1.500 x D	14 deg	93	.0125	.0146	.0167	.0188	.0209	.0251	.0334	.0418	.0502	.0586	.0669	.0752	.0836	.1045	.1338
		Trad. Style Pocket	1.500 x D	.625 x D	93	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
	Precipitation hardening stainless steel 15-38 HRC 17-4, 15-5, 13-8	Peripheral -Rough	1.250 x D	.375 x D	107	.0174	.0203	.0232	.0261	.0290	.0348	.0464	.0580	.0696	.0813	.0928	.1044	.1160	.1450	.1856
		Peripheral -Finish	2.000 x D	.015 x D	104	.0162	.0189	.0216	.0243	.0270	.0324	.0432	.0540	.0648	.0757	.0864	.0972	.1080	.1350	.1728
		Peripheral -HEM	2.000 x D	.070 x D	111	.0486	.0567	.0648	.0729	.0810	.0972	.1296	.1620	.1944	.2271	.2592	.2916	.3240	.4050	.5184
		Slotting -Traditional	1.000 x D	1.000 x D	90	.0120	.0140	.0160	.0180	.0200	.0240	.0320	.0400	.0480	.0561	.0640	.0720	.0800	.1000	.1280
		Rough Facing	.375 x D	.700 x D	128	.0157	.0183	.0209	.0235	.0261	.0313	.0418	.0522	.0626	.0732	.0835	.0940	.1044	.1305	.1670
		Finish Facing	.020 x D	.700 x D	109	.0149	.0174	.0199	.0224	.0248	.0298	.0397	.0497	.0596	.0696	.0795	.0894	.0994	.1242	.1590
		Helical Entry	2.000 x D	12 deg	108	.0077	.0090	.0102	.0115	.0128	.0154	.0205	.0256	.0307	.0359	.0410	.0461	.0512	.0640	.0819
		Straight Line Ramp	1.000 x D	12 deg	90	.0114	.0133	.0152	.0171	.0190	.0228	.0304	.0380	.0456	.0533	.0608	.0684	.0760	.0950	.1216
		Trad. Style Pocket	1.000 x D	.625 x D	90	.0120	.0140	.0160	.0180	.0200	.0240	.0320	.0400	.0480	.0561	.0640	.0720	.0800	.1000	.1280

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)														
						3.0	3.5	4.0	4.5	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	32.0
S	Titanium alloys 6AL-4V, 6-2-4 18-31 HRC	Peripheral -Rough	1.500 x D	.400 x D	108	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
		Peripheral -Finish	2.000 x D	.020 x D	117	.0126	.0147	.0168	.0189	.0210	.0252	.0336	.0420	.0504	.0589	.0672	.0756	.0840	.1050	.1344
		Peripheral -HEM	2.000 x D	.080 x D	122	.0390	.0455	.0520	.0585	.0650	.0780	.1040	.1300	.1560	.1822	.2080	.2340	.2600	.3250	.4160
		Slotting -Traditional	1.500 x D	1.000 x D	91	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
		Rough Facing	.375 x D	.700 x D	119	.0151	.0176	.0202	.0227	.0252	.0302	.0403	.0504	.0605	.0706	.0806	.0907	.1008	.1260	.1613
		Finish Facing	.020 x D	.700 x D	123	.0110	.0129	.0147	.0165	.0184	.0220	.0294	.0367	.0441	.0515	.0588	.0661	.0735	.0919	.1176
		Helical Entry	2.000 x D	16 deg	129	.0101	.0118	.0135	.0152	.0168	.0202	.0269	.0337	.0404	.0472	.0539	.0606	.0674	.0842	.1078
		Straight Line Ramp	1.500 x D	15 deg	96	.0119	.0139	.0158	.0178	.0198	.0238	.0317	.0396	.0475	.0555	.0634	.0713	.0792	.0990	.1267
		Trad. Style Pocket	1.500 x D	.625 x D	91	.0132	.0154	.0176	.0198	.0220	.0264	.0352	.0440	.0528	.0617	.0704	.0792	.0880	.1100	.1408
	Difficult-to-machine titanium alloys 10-2-3 18-31 HRC	Peripheral -Rough	1.500 x D	.375 x D	90	.0120	.0140	.0160	.0180	.0200	.0240	.0320	.0400	.0480	.0561	.0640	.0720	.0800	.1000	.1280
		Peripheral -Finish	2.000 x D	.010 x D	91	.0126	.0147	.0168	.0189	.0210	.0252	.0336	.0420	.0504	.0589	.0672	.0756	.0840	.1050	.1344
		Peripheral -HEM	2.000 x D	.075 x D	114	.0330	.0385	.0440	.0495	.0550	.0660	.0880	.1100	.1320	.1542	.1760	.1980	.2200	.2750	.3520
		Slotting -Traditional	1.250 x D	1.000 x D	84	.0126	.0147	.0168	.0189	.0210	.0252	.0336	.0420	.0504	.0589	.0672	.0756	.0840	.1050	.1344
		Rough Facing	.300 x D	.700 x D	99	.0108	.0126	.0144	.0162	.0180	.0216	.0288	.0360	.0432	.0505	.0576	.0648	.0720	.0900	.1152
		Finish Facing	.020 x D	.700 x D	96	.0113	.0132	.0151	.0170	.0189	.0227	.0302	.0378	.0454	.0530	.0605	.0680	.0756	.0945	.1210
		Helical Entry	2.000 x D	15 deg	134	.0094	.0110	.0126	.0142	.0157	.0189	.0252	.0315	.0378	.0441	.0504	.0567	.0630	.0787	.1008
		Straight Line Ramp	1.500 x D	14 deg	88	.0115	.0134	.0153	.0172	.0191	.0229	.0306	.0382	.0459	.0536	.0612	.0688	.0764	.0955	.1223
		Trad. Style Pocket	1.250 x D	.625 x D	84	.0126	.0147	.0168	.0189	.0210	.0252	.0336	.0420	.0504	.0589	.0672	.0756	.0840	.1050	.1344
	Nickel-based super alloys Hastalloy, Waspalloy 15-30 HRC	Peripheral -Rough	1.500 x D	.200 x D	82	.0102	.0119	.0136	.0153	.0170	.0204	.0272	.0340	.0408	.0477	.0544	.0612	.0680	.0850	.1088
		Peripheral -Finish	2.000 x D	.015 x D	85	.0108	.0126	.0144	.0162	.0180	.0216	.0288	.0360	.0432	.0505	.0576	.0648	.0720	.0900	.1152
		Peripheral -HEM	2.000 x D	.070 x D	91	.0378	.0441	.0504	.0567	.0630	.0756	.1008	.1260	.1512	.1766	.2016	.2268	.2520	.3150	.4032
		Slotting -Traditional	.500 x D	1.000 x D	69	.0114	.0133	.0152	.0171	.0190	.0228	.0304	.0380	.0456	.0533	.0608	.0684	.0760	.0950	.1216
		Rough Facing	.300 x D	.700 x D	91	.0092	.0107	.0122	.0138	.0153	.0184	.0245	.0306	.0367	.0429	.0490	.0551	.0612	.0765	.0979
		Finish Facing	.020 x D	.700 x D	89	.0117	.0136	.0156	.0175	.0194	.0233	.0311	.0389	.0467	.0545	.0622	.0700	.0778	.0972	.1244
		Helical Entry	2.000 x D	10 deg	82	.0103	.0120	.0137	.0154	.0171	.0205	.0274	.0342	.0410	.0479	.0547	.0616	.0684	.0855	.1094
		Straight Line Ramp	.500 x D	13 deg	72	.0104	.0121	.0138	.0156	.0173	.0207	.0277	.0346	.0415	.0485	.0553	.0622	.0692	.0864	.1107
		Trad. Style Pocket	#REF!	.550 x D	69	.0114	.0133	.0152	.0171	.0190	.0228	.0304	.0380	.0456	.0533	.0608	.0684	.0760	.0950	.1216
	Nickel Chromium-based super alloys Inconel 718, Rene 88 10-25 HRC	Peripheral -Rough	1.250 x D	.200 x D	24	.0084	.0098	.0112	.0126	.0140	.0168	.0224	.0280	.0336	.0392	.0448	.0504	.0560	.0700	.0896
		Peripheral -Finish	2.000 x D	.015 x D	29	.0210	.0245	.0280	.0315	.0350	.0420	.0560	.0700	.0840	.0981	.1120	.1260	.1400	.1750	.2240
		Peripheral -HEM	2.000 x D	.060 x D	29	.0558	.0651	.0744	.0837	.0930	.1116	.1488	.1860	.2232	.2607	.2976	.3348	.3720	.4650	.5952
		Slotting -Traditional	.500 x D	1.000 x D	26	.0090	.0105	.0120	.0135	.0150	.0180	.0240	.0300	.0360	.0420	.0480	.0540	.0600	.0750	.0960
		Rough Facing	.300 x D	.700 x D	27	.0076	.0088	.0101	.0113	.0126	.0151	.0202	.0252	.0302	.0353	.0403	.0454	.0504	.0630	.0806
		Finish Facing	.020 x D	.650 x D	28	.0172	.0201	.0230	.0258	.0287	.0344	.0459	.0574	.0689	.0805	.0918	.1033	.1148	.1435	.1837
		Helical Entry	1.000 x D	8 deg	32	.0084	.0098	.0112	.0127	.0141	.0169	.0225	.0281	.0337	.0394	.0450	.0506	.0562	.0703	.0900
		Straight Line Ramp	.375 x D	6 deg	27	.0088	.0102	.0117	.0132	.0146	.0175	.0234	.0292	.0351	.0410	.0468	.0526	.0585	.0731	.0936
		Trad. Style Pocket	.500 x D	.500 x D	26	.0090	.0105	.0120	.0135	.0150	.0180	.0240	.0300	.0360	.0420	.0480	.0540	.0600	.0750	.0960
N	Aluminum alloys O-T6 2024, 6061, 7075	Peripheral -Rough	2.000 x D	.490 x D	229	.0360	.0420	.0480	.0540	.0600	.0720	.0960	.1200	.1440	.1682	.1920	.2160	.2400	.3000	.3840
		Peripheral -Finish	2.000 x D	.020 x D	244	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -HEM	2.000 x D	.250 x D	229	.0480	.0560	.0640	.0720	.0800	.0960	.1280	.1600	.1920	.2243	.2560	.2880	.3200	.4000	.5120
		Slotting -Traditional	1.750 x D	1.000 x D	213	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Rough Facing	.375 x D	.700 x D	251	.0306	.0357	.0408	.0459	.0510	.0612	.0816	.1020	.1224	.1430	.1632	.1836	.2040	.2550	.3264
		Finish Facing	.020 x D	.700 x D	268	.0153	.0178	.0204	.0229	.0255	.0306	.0408	.0510	.0612	.0715	.0816	.0918	.1020	.1275	.1632
		Helical Entry	2.000 x D	25 deg	259	.0144	.0168	.0192	.0216	.0240	.0288	.0384	.0480	.0576	.0673	.0768	.0864	.0960	.1200	.1536
		Straight Line Ramp	1.750 x D	18 deg	267	.0142	.0166	.0189	.0213	.0237	.0284	.0379	.0474	.0568	.0664	.0758	.0853	.0947	.1184	.1516
		Trad. Style Pocket	1.750 x D	.450 x D	213	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Speed (SFM)	Feed Rate Per Tooth (mm per Tooth)														
						3.0	3.5	4.0	4.5	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	32.0
N	High-silicon aluminum alloys A380, A390 45-75 Bhn	Peripheral -Rough	2.000 x D	.490 x D	223	.0300	.0350	.0400	.0450	.0500	.0600	.0800	.1000	.1200	.1402	.1600	.1800	.2000	.2500	.3200
		Peripheral -Finish	2.000 x D	.020 x D	236	.0174	.0203	.0232	.0261	.0290	.0348	.0464	.0580	.0696	.0813	.0928	.1044	.1160	.1450	.1856
		Peripheral -HEM	2.000 x D	.250 x D	223	.0420	.0490	.0560	.0630	.0700	.0840	.1120	.1400	.1680	.1962	.2240	.2520	.2800	.3500	.4480
		Slotting -Traditional	1.750 x D	1.000 x D	198	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
		Rough Facing	.375 x D	.700 x D	245	.0255	.0297	.0340	.0382	.0425	.0510	.0680	.0850	.1020	.1191	.1360	.1530	.1700	.2125	.2720
		Finish Facing	.020 x D	.700 x D	260	.0148	.0173	.0197	.0222	.0246	.0296	.0394	.0493	.0592	.0691	.0789	.0887	.0986	.1232	.1578
		Helical Entry	2.000 x D	20 deg	258	.0134	.0157	.0179	.0202	.0224	.0269	.0358	.0448	.0538	.0628	.0717	.0806	.0896	.1120	.1434
		Straight Line Ramp	1.750 x D	18 deg	228	.0136	.0159	.0181	.0204	.0227	.0272	.0363	.0454	.0544	.0636	.0726	.0816	.0907	.1134	.1452
		Trad. Style Pocket	1.750 x D	.450 x D	198	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
	Magnesium alloys 47-140 Bhn	Peripheral -Rough	2.000 x D	.490 x D	229	.0360	.0420	.0480	.0540	.0600	.0720	.0960	.1200	.1440	.1682	.1920	.2160	.2400	.3000	.3840
		Peripheral -Finish	2.000 x D	.020 x D	244	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -HEM	2.000 x D	.250 x D	229	.0480	.0560	.0640	.0720	.0800	.0960	.1280	.1600	.1920	.2243	.2560	.2880	.3200	.4000	.5120
		Slotting -Traditional	1.750 x D	1.000 x D	213	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Rough Facing	.375 x D	.700 x D	251	.0306	.0357	.0408	.0459	.0510	.0612	.0816	.1020	.1224	.1430	.1632	.1836	.2040	.2550	.3264
		Finish Facing	.020 x D	.700 x D	268	.0153	.0178	.0204	.0229	.0255	.0306	.0408	.0510	.0612	.0715	.0816	.0918	.1020	.1275	.1632
		Helical Entry	2.000 x D	25 deg	277	.0144	.0168	.0192	.0216	.0240	.0288	.0384	.0480	.0576	.0673	.0768	.0864	.0960	.1200	.1536
		Straight Line Ramp	1.750 x D	18 deg	267	.0142	.0166	.0189	.0213	.0237	.0284	.0379	.0474	.0568	.0664	.0758	.0853	.0947	.1184	.1516
		Trad. Style Pocket	1.750 x D	.450 x D	213	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
	Copper, brass 111-170 Bhn	Peripheral -Rough	2.000 x D	.350 x D	122	.0180	.0210	.0240	.0270	.0300	.0360	.0480	.0600	.0720	.0841	.0960	.1080	.1200	.1500	.1920
		Peripheral -Finish	2.000 x D	.015 x D	122	.0150	.0175	.0200	.0225	.0250	.0300	.0400	.0500	.0600	.0701	.0800	.0900	.1000	.1250	.1600
		Peripheral -HEM	2.000 x D	.250 x D	183	.0300	.0350	.0400	.0450	.0500	.0600	.0800	.1000	.1200	.1402	.1600	.1800	.2000	.2500	.3200
		Slotting -Traditional	1.500 x D	1.000 x D	114	.0186	.0217	.0248	.0279	.0310	.0372	.0496	.0620	.0744	.0869	.0992	.1116	.1240	.1550	.1984
		Rough Facing	.375 x D	.700 x D	134	.0166	.0193	.0221	.0248	.0276	.0331	.0442	.0552	.0662	.0774	.0883	.0994	.1104	.1380	.1766
		Finish Facing	.020 x D	.700 x D	134	.0135	.0157	.0180	.0202	.0225	.0270	.0360	.0450	.0540	.0631	.0720	.0810	.0900	.1125	.1440
		Helical Entry	2.000 x D	18 deg	137	.0184	.0215	.0246	.0276	.0307	.0368	.0491	.0614	.0737	.0860	.0982	.1105	.1228	.1534	.1964
		Straight Line Ramp	1.500 x D	16 deg	118	.0177	.0206	.0236	.0265	.0295	.0354	.0472	.0589	.0707	.0826	.0943	.1061	.1179	.1473	.1886
		Trad. Style Pocket	1.500 x D	.625 x D	114	.0186	.0217	.0248	.0279	.0310	.0372	.0496	.0620	.0744	.0869	.0992	.1116	.1240	.1550	.1984
	Bronze 111-201 Bhn	Peripheral -Rough	2.000 x D	.350 x D	119	.0168	.0196	.0224	.0252	.0280	.0336	.0448	.0560	.0672	.0785	.0896	.1008	.1120	.1400	.1792
		Peripheral -Finish	2.000 x D	.015 x D	120	.0144	.0168	.0192	.0216	.0240	.0288	.0384	.0480	.0576	.0673	.0768	.0864	.0960	.1200	.1536
		Peripheral -HEM	2.000 x D	.200 x D	149	.0288	.0336	.0384	.0432	.0480	.0576	.0768	.0960	.1152	.1346	.1536	.1728	.1920	.2400	.3072
		Slotting -Traditional	1.500 x D	1.000 x D	111	.0186	.0217	.0248	.0279	.0310	.0372	.0496	.0620	.0744	.0869	.0992	.1116	.1240	.1550	.1984
		Rough Facing	.375 x D	.700 x D	131	.0160	.0186	.0213	.0239	.0266	.0319	.0426	.0532	.0638	.0746	.0851	.0958	.1064	.1330	.1702
		Finish Facing	.020 x D	.700 x D	132	.0132	.0155	.0177	.0199	.0221	.0265	.0353	.0442	.0530	.0619	.0707	.0795	.0883	.1104	.1413
		Helical Entry	2.000 x D	18 deg	134	.0186	.0217	.0248	.0279	.0310	.0372	.0496	.0620	.0744	.0869	.0992	.1116	.1240	.1550	.1984
		Straight Line Ramp	1.500 x D	16 deg	114	.0177	.0206	.0236	.0265	.0295	.0354	.0472	.0589	.0707	.0826	.0943	.1061	.1179	.1473	.1886
		Trad. Style Pocket	1.500 x D	.625 x D	111	.0186	.0217	.0248	.0279	.0310	.0372	.0496	.0620	.0744	.0869	.0992	.1116	.1240	.1550	.1984
	Composites, plastics, fiberglass	Peripheral -Rough	2.000 x D	.490 x D	198	.0240	.0280	.0320	.0360	.0400	.0480	.0640	.0800	.0960	.1121	.1280	.1440	.1600	.2000	.2560
		Peripheral -Finish	2.000 x D	.020 x D	152	.0186	.0217	.0248	.0279	.0310	.0372	.0496	.0620	.0744	.0869	.0992	.1116	.1240	.1550	.1984
		Peripheral -HEM	2.000 x D	.250 x D	213	.0312	.0364	.0416	.0468	.0520	.0624	.0832	.1040	.1248	.1458	.1664	.1872	.2080	.2600	.3328
		Slotting -Traditional	1.750 x D	1.000 x D	200	.0240	.0280	.0320	.0360	.0400	.0480	.0640	.0800	.0960	.1121	.1280	.1440	.1600	.2000	.2560
		Rough Facing	.375 x D	.700 x D	218	.0187	.0218	.0250	.0281	.0312	.0374	.0499	.0624	.0749	.0875	.0998	.1123	.1248	.1560	.1997
		Finish Facing	.020 x D	.700 x D	168	.0171	.0200	.0228	.0257	.0285	.0342	.0456	.0570	.0684	.0799	.0913	.1027	.1141	.1426	.1825
		Helical Entry	2.000 x D	20 deg	240	.0240	.0280	.0320	.0360	.0400	.0480	.0640	.0800	.0960	.1121	.1280	.1440	.1600	.2000	.2560
		Straight Line Ramp	1.750 x D	18 deg	205	.0228	.0266	.0304	.0342	.0380	.0456	.0608	.0760	.0913	.1066	.1217	.1369	.1521	.1901	.2434
		Trad. Style Pocket	1.750 x D	.625 x D	200	.0240	.0280	.0320	.0360	.0400	.0480	.0640	.0800	.0960	.1121	.1280	.1440	.1600	.2000	.2560