GENERAL PURPOSE END MILLS - CARBIDE - ROUGHING
Technical Information

Carbide Fine Pitch Roughers									
Material Guide		SFM	Feed Per Tooth						
			1/8" - 1/4"	1/4" - 5/16"	5/16" - 3/8"	3/8" - 1/2"	1/2" - 5/8"	5/8" - 3/4"	3/4" - 1"
COBALT BASE ALLOYS	Stellite, HS - 21, Haynes 25/188, X - 40, L - 605	85 - 120	.0002 - .0004 .0002 - .0005	.0004 - .0006 .0005 - .0007	.0006 - .0008 .0008 - .0009	.0008 - .0012 .0009 - .0014	.0012 - .0015 .0014 - .0018	.0015 - .0018 .0018 - .0022	.0018 - .0025 .0022 - .0029
NICKEL BASE ALLOYS	Inconel - 625/718, Waspalloy, Rene, Hastelloy	60 - 85	.0001 - .0003 .0003 - .0004	.0003 - .0005 .0004 - .0006	.0005 - .0006 .0006 - .0007	.0006 - .0010 .0007 - .0011	.0010 - .0012 .0011 - .0014	.0012 - .0015 .0014 - .0017	.0015 - .0020 .0017 - .0023
IRON BASE ALLOYS	Incoloy 800 - 802, Multimet N - 155, Timkin 16 - 25 - 6, Carpeneter 22 - b3	70 - 100	.0002 - .0004 .0002 - .0005	.0004 - .0006 .0005 - .0007	.0006 - .0008 .0008 - .0009	.0008 - .0012 .0009 - .0014	.0012 - .0015 .0014 - .0018	.0015 - .0018 .0018 - .0022	.0018 - .0025 .0022 - .0029
STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17 - 4	175 - 245	.0006 - .0011 .0009 - .0015	.0011 - .0013 .0015 - .0016	.0013 - .0016 .0016 - .0022	.0016 - .0022 .0022 - .0030	.0022 - .0028 .0030 - .0039	.0028 - .0034 .0039 - .0047	.0034 - .0046 .0047 - .0063
STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 304L, 316, 316L	225 - 315	.0007 - .0013 .0010 - .0018	.0013 - .0017 .0018 - .0023	.0017 - .0020 .0023 - .0028	.0020 - .0027 .0028 - .0037	.0027 - .0034 .0037 - .0047	.0034 - .0041 .0047 - .0056	.0041 - .0055 .0056 - .0075
STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440	200 - 280	.0009 - .0014 .0014 - .0019	.0014 - .0018 .0019 - .0023	.0018 - .0021 .0023 - .0029	.0021 - .0029 .0029 - .0040	.0029 - .0036 .0040 - .0050	.0036 - .0043 .0050 - .0060	.0043 - .0059 .0060 - .0081
HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, 01	225 - 315	.0007 - .0013 .0010 - .0018	.0013 - .0017 .0018 - .0023	.0017 - .0020 .0023 - .0028	.0020 - .0027 .0028 - .0037	.0027 - .0034 .0037 - .0047	.0034 - .0041 .0047 - .0056	.0041 - .0055 .0056 - .0075
MEDIUM ALLOY STEELS	200, 250, 300	250 - 350	.0007 - .0013 .0010 - .0018	.0013 - .0017 .0018 - .0023	.0017 - .0020 .0023 - .0028	.0020 - .0027 .0028 - .0037	.0027 - .0034 .0037 - .0047	.0034 - .0041 .0047 - .0056	.0041 - .0055 .0056 - .0075
CARBON STEELS	1000's, 1100's, 1300's	265 - 370	.0007 - .0013 .0010 - .0018	.0013 - .0017 .0018 - .0023	.0017 - .0020 .0023 - .0028	.0020 - .0027 .0028 - .0037	.0027 - .0034 .0037 - .0047	.0034 - .0041 .0047 - .0056	.0041 - .0055 .0056 - .0075

Slotting @ ≤ .5 x D
Profiling @ 2 X D Axial / ≤ .5D Radial