

NOTE: These are all suggestions, so use your good judgment or ask for help to determine if it is right for your operation.

MILL

COMMON MILLING SPEEDS (RPM)

Stock Material Cutter Diameter (in)	Aluminum		Plain Carbon Steel				Stainless Steel			
	H.S.S 2 Flute		H.S.S 4 Flute		Carbide 4 Flute		H.S.S 4 Flute		Carbide 4 Flute	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
0.125 [1/8]	2500	5	2500	5	2500	5	1680	3	2500	5
0.250 [1/4]	2500	10	1910	6	2500	10	840	3	2500	9
0.375 [3/8]	2500	13	1270	4	1870	11	560	2	1490	9
0.500 [1/2]	2500	15	950	4	1400	11	420	2	1120	9
0.625 [5/8]	2000	15	760	5	1120	11	340	2	890	9
0.750 [3/4]	1770	12	640	5	940	11	280	2	750	9
0.875 [7/8]	1520	12	550	4	800	11	240	2	640	9
1.000	1330	11	480	6	700	11	210	3	560	9
Face Mill	1800		175				300			

Helpful Speed Factors

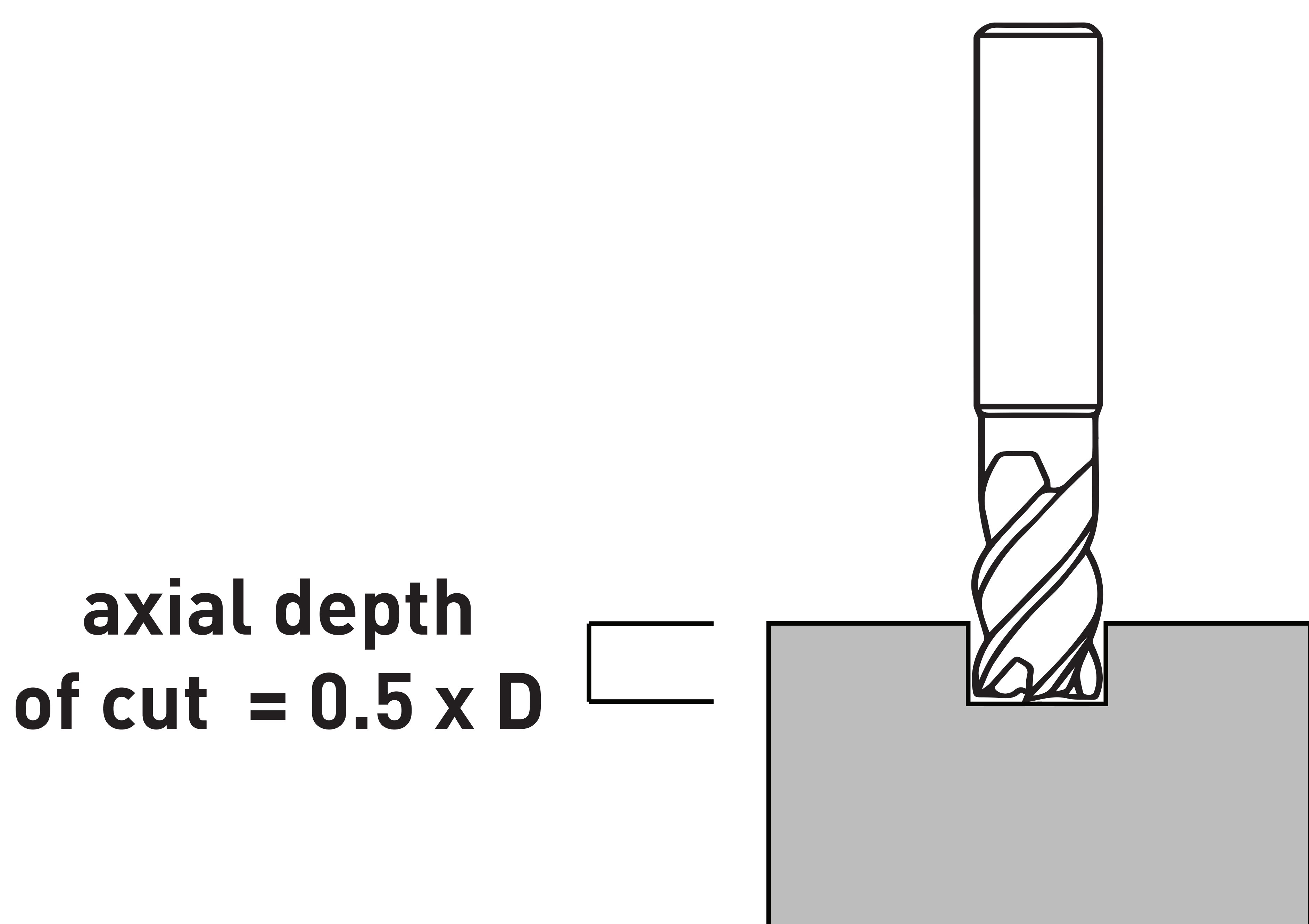
Operation	Drill	Reamer	Counter Bore/Sink
Speed Factor	0.75	0.25	0.50

* Multiply the speed factor by the calculated/common milling speed

Max Depth of Cut for Feed



SLOT



PROFILE

