

SPEED & FEED INFORMATION

Notes

Note: All technical data provided are suggested starting points. They may be increase or decreased depending on machine condition, depth of cut, finish required, coolant, etc. Call our TECHNICAL SERVICE Team with questions

SPEED & FEEDS FOR SERIES: Z4TRW/T4TRW ALTiN

DESCRIPTION: MULTI FLUTE - FINE PROFILE ROUGHING END MILL



Material Guide		Condition	SFM	CHIP PER TOOTH									
				3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"		
ISO-M	Precipitation	13-8, 15-5, 17-4PH	175	Slotting @ $\leq .5 \times D$		0.0008	0.0011	0.0013	0.0016	0.0022	0.0028	0.0034	0.0046
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0012	0.0015	0.0016	0.0022	0.0030	0.0039	0.0047	0.0063
	Austenitic	302, 303, 304L, 316L	225	Slotting @ $\leq .5 \times D$		0.0009	0.0013	0.0017	0.0020	0.0027	0.0034	0.0041	0.0055
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0013	0.0018	0.0023	0.0028	0.0037	0.0047	0.0056	0.0075
	Martensitic	403, 410, 416	200	Slotting @ $\leq .5 \times D$		0.0011	0.0014	0.0018	0.0021	0.0029	0.0036	0.0043	0.0059
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0015	0.0019	0.0023	0.0029	0.0040	0.0050	0.0060	0.0081
ISO-S	Cobalt Base	Stellite, Haynes 25, 188, X-40, L-605	85	Slotting @ $\leq .5 \times D$		0.0004	0.0005	0.0006	0.0008	0.0012	0.0015	0.0018	0.0025
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0004	0.0048	0.0007	0.0007	0.0014	0.0018	0.0022	0.0029
	Nickel Base	Inconel 600, 625, 718, Nickel 200, 270, Invar, Monel 400, 405, K-Monel, Permannickel 300, Inconel 600	60	Slotting @ $\leq .5 \times D$		0.0002	0.0007	0.0008	0.0011	0.0019	0.0018	0.0029	0.0029
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0004	0.0007	0.0009	0.0012	0.0020	0.0020	0.0025	0.0025
	Iron Base	Incoloy 800-802, Multimet N-155, Timken 16-26-6	70	Slotting @ $\leq .5 \times D$		0.0005	0.0009	0.0013	0.0015	0.0021	0.0026	0.0032	0.0042
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0005	0.0011	0.0013	0.0018	0.0023	0.0029	0.0035	0.0048
ISO-P	High Strength Steels	4140, 4340, 52100	225	Slotting @ $\leq .5 \times D$		0.0009	0.0014	0.0013	0.0021	0.0029	0.0036	0.0043	0.0059
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0014	0.0019	0.0021	0.0029	0.0040	0.0050	0.0060	0.0081
	High Alloy Steels Mold & Die	A-2, P20, 01, 02, D2, H-13	200	Slotting @ $\leq .5 \times D$		0.0008	0.0012	0.0014	0.0018	0.0025	0.0030	0.0036	0.0049
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0012	0.0016	0.0021	0.0025	0.0033	0.0042	0.0050	0.0068
	Medium Alloy Steels	200, 250, 300	250	Slotting @ $\leq .5 \times D$		0.0005	0.0013	0.0018	0.0022	0.0028	0.0040	0.0046	0.0057
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0005	0.0016	0.0022	0.0027	0.0034	0.0046	0.0057	0.0069
	Low Alloy Steels-Maraging	10XX, 11XX, 13XX	265	Slotting @ $\leq .5 \times D$		0.0011	0.0015	0.0023	0.0023	0.0032	0.0040	0.0048	0.0064
				Profiling @ $2 \times D$ Axial / $\leq .5 D$ Radial		0.0016	0.0021	0.0029	0.0033	0.0043	0.0055	0.0066	0.0088