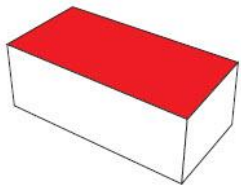
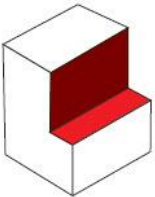
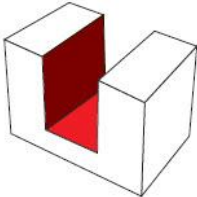
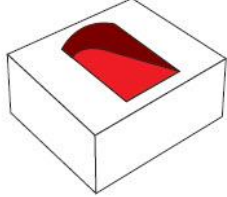
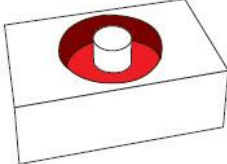


Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Start with the middle range of the recommended smm (vc) and feed (mm/rev)
-Adjust the smm and/or feed rate based on your cutting conditions.

Facing	Shouldering	Slotting	Ramping	Helical Cutting
				

Workpiece Material	ISO	Recommended Grade	ADKT 1706xx PESR-MM / ML			
			vc	(face/shoulder mill) fz	(groove, ramp, helical) fz	(maximum) ap
P-Steels	P30-P40	HU30	150 - 240 smm	0.05 - 0.30 mmpt	0.05 - 0.30 mmpt	16.48 mm
	P25-P35	HP25	130 - 210 smm	0.05 - 0.30 mmpt	0.05 - 0.30 mmpt	
	P30-P40	MKP30	250 - 350 smm	0.05 - 0.30 mmpt	0.05 - 0.30 mmpt	
	P40-P50	HKP30	150 - 250 smm	0.05 - 0.30 mmpt	0.05 - 0.30 mmpt	
M-Stainless Steels	M20-M30	HU30	90 - 150 smm	0.05 - 0.25 mmpt	0.05 - 0.15 mmpt	
K-Cast Iron	K20-K30	HU30	120 - 250 smm	0.08 - 0.36 mmpt	0.08 - 0.20 mmpt	
	K20-K30	MKP30	200 - 300 smm	0.08 - 0.36 mmpt	0.08 - 0.20 mmpt	
	K30-K40	HKP40	150 - 250 smm	0.08 - 0.36 mmpt	0.08 - 0.20 mmpt	

* When surface and shoulder milling, the data refers to general cutting conditions and can be adjustable up to 350 SMM and .040 MMPT depending on user environment.

* In deep grooving, set the AP under 5.00 millimeters and use coolant + air.

