

# Speeds and Feeds Solid Carbide Chamfer Mills



Solid carbide chamfer mills are designed for for deburring and chamfering in tight areas. The parameters listed for tool series that are based on an uncoated tools. Coated tools speed can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously increase incrementally to achieve optimum performance.

Speed given in Surface Feet per Minute (SFM)

Feed given in Inch Per Tooth (IPT)

	Wood	Composites	Plastics	High Si Aluminum ( >10%) (2.0)	Low Si Aluminum ( <10%) (3.0)	Brass & Copper	Graphite
SFM (ft/min)	500-800	300-600	500-800	500-800	1100-1500	400-600	500-800
Axial Depth	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)
1/8"	0.0018	0.0035	0.0018	0.0011	0.0012	0.0011	0.0020
3/8"	0.0043	0.0085	0.0043	0.0050	0.0048	0.0021	0.0060
3/4"	0.0073	0.0145	0.0073	0.0090	0.0085	0.0035	0.0100
Radial Width	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D
1/4"	0.0033	0.0065	0.0033	0.0032	0.0034	0.0015	0.0040
1/2"	0.0053	0.0105	0.0053	0.0065	0.0063	0.0028	0.0080
1"	0.0093	0.0185	0.0093	0.0110	0.0114	0.0040	0.0150
	Cast Iron	Hardened Steels > 48 RC (.75)	Steels	Stainless Steels	Super Alloys (Nickel based, Inconel)	Titanium	
SFM (ft/min)	250-400	80-130	230-350	130-280	80-120	120-200	
Axial Depth	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	< (2xD)	
Radial Width	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	(.05-.08)x D	
1/8"	0.0012	0.0009	0.0008	0.0008	0.0004	0.0004	
1/4"	0.0015	0.0016	0.0014	0.0014	0.0010	0.0007	
3/8"	0.0022	0.0022	0.0022	0.0022	0.0015	0.0011	
1/2"	0.0030	0.0025	0.0025	0.0023	0.0020	0.0014	
3/4"	0.0035	0.0030	0.0028	0.0025	0.0025	0.0018	
1"	0.0045	0.0035	0.0035	0.0027	0.0030	0.0025	

