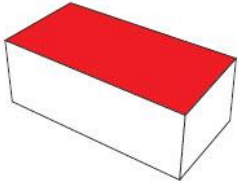
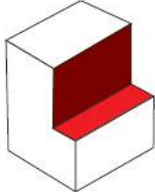
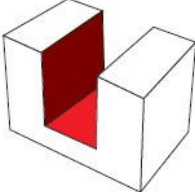
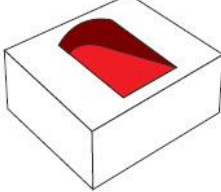
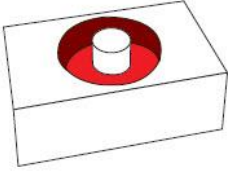


Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Start with the middle range of the recommended sfm (vc) and feed (inch/rev)
 - Adjust the sfm 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
Steels	P30-P40	HU30	492 - 787 sfm	0.002 - 0.012 ipt	0.002 - 0.012 ipt	0.649
	P25-P35	HP25	426 - 688 sfm	0.002 - 0.012 ipt	0.002 - 0.012 ipt	
	P30-P40	MKP30	820 - 1148 sfm	0.002 - 0.012 ipt	0.002 - 0.012 ipt	
M Stainless Steels	M20-M30	HU30	295 - 492 sfm	0.002 - 0.010 ipt	0.002 - 0.006 ipt	
K Cast Iron	K20-K30	HU30	393 - 820 sfm	0.003 - 0.014 ipt	0.003 - 0.008 ipt	
	K20-K30	MKP30	656 - 984 sfm	0.003 - 0.014 ipt	0.003 - 0.008 ipt	

* When surface and shoulder milling, the data refers to general cutting conditions and can be adjustable up to 1150 SFM and .016 IPT depending on user environment.

* In deep grooving, set the AP under .197 inch and use coolant + air.

