

Material	Cutting Speed M/Min	Feed Per Tooth (mm/rev)			
		Ø 0.8-1.5	Ø1.5-2	Ø2-2.5	Ø 2.5-3
Low Alloy Steel <25Hrc	40-100	0.02-0.07	0.04-0.10	0.07-0.12	0.08-0.15
High Alloy Steel >25Hrc	30-85	0.02-0.07	0.04-0.10	0.07-0.12	0.08-0.15
Hardened Steel 50-60Hrc	10-20	0.01-0.02	0.01-0.02	0.02-0.03	0.02-0.03
Stainless Steel	20-35	0.02-0.07	0.05-0.10	0.07-0.12	0.08-0.15
Cast Iron (GGG)	40-95	0.02-0.07	0.05-0.10	0.07-0.12	0.08-0.15
Cast Iron (GG)	40-70	0.02-0.07	0.05-0.10	0.07-0.12	0.08-0.15
Titanium	10-20	0.02-0.04	0.03-0.06	0.03-0.06	0.04-0.06
Inconel	10-20	0.02-0.03	0.03-0.05	0.03-0.06	0.04-0.06
Aluminium	80-150	0.03-0.10	0.05-0.12	0.07-0.15	0.07-0.15