

MATERIAL	INSERT SELECTION AND SFM (V) FT/MIN (M/MIN)				DEPTH OF CUT INCH (MM)	IPT (SZ) INCH/TOOTH (MM/INSERT)		
	25P & 27P	55P & 57P	25PC, 27PC	55PC, 57PC		MM & MFS CUTTERS	HP & MFC CUTTERS	HD CUTTERS
TOOL STEELS								
HIGH SPEED		300-400 (90-125)		400-600 (125-185)	.020-.050 (0.50-1.25)	.005-.007 (.10-.18)	.005-.012 (.10-.30)	.006-.025 (.15-.65)
		200-300 (60-90)		300-500 (90-150)	.050-.100 (1.25-2.50)	.005-.007 (.10-.18)	.005-.012 (.10-.30)	.006-.025 (.15-.65)
				200-400 (60-125)	.100-.250 (2.50-6.50)			.005-.020 (.10-.50)
HOT & COLD WORK		300-500 (90-150)		500-700 (150-215)	.020-.050 (0.50-1.25)	.005-.007 (.10-.18)	.005-.012 (.10-.30)	.006-.025 (.15-.65)
		200-400 (60-125)		400-600 (125-185)	.050-.100 (1.25-2.50)	.005-.007 (.10-.18)	.005-.012 (.10-.30)	.006-.025 (.15-.65)
				300-500 (90-150)	.100-.250 (2.50-6.50)			.005-.020 (.10-.50)
MOLD		400-700 (125-215)		700-1000 (215-305)	.020-.050 (0.50-1.25)	.005-.007 (.10-.18)	.005-.012 (.10-.30)	.006-.025 (.15-.65)
		300-600 (60-185)		600-900 (185-275)	.050-.100 (1.25-2.50)	.005-.007 (.10-.18)	.005-.012 (.10-.30)	.006-.025 (.15-.65)
				500-800 (150-245)	.100-.250 (2.50-6.50)			.005-.020 (.10-.50)