

Material	Insert	Cutter Diameter Less than 10" / 250mm		Cutter Diameter 10" / 250mm Or greater		Remarks
		Speed / sfm (M/Min)	Feed / IPT (MM/Tooth)	Speed / sfm (M/Min)	Feed / IPT (MM/Tooth)	
Alloy Steels	MU-23CK	1000 – 1400 (300 – 425)	.005-.009 (0.13-0.23)	700-1000 (210-300)	.005-.009 (0.13-0.23)	Higher speed possible if conditions indicate.
Low Carbon Steel	MU-23CK	1000 – 1400 (300 – 425)	.006-.010 (0.15-0.25)	700-1000 (210-300)	.006-.010 (0.15-0.25)	
Die Steel	MU-23CK	800-1200 (240-365)	.004-.008 (0.10-0.20)	550-850 (165-260)	.004-.008 (0.10-0.20)	Shallow depths of cut if possible.
Stainless Steel	MU-23CK	500-700 (150-210)	.005-.007 (0.13-0.18)	350-500 (100-150)	.005-.007 (0.13-0.18)	
Cast Iron	MU-1000	1500-4000 (450-1200)	.008-.020 (0.20-0.50)	1050-3000 (320-910)	.006-.018 (0.15-0.46)	Has been run faster under certain conditions. No coolant required.
Non-ferrous Aluminum	MU-23	2000-3000 (610-915)	.005-.010 (0.13-0.25)	2000-3000 (610-915)	.005-.010 (0.13-0.25)	On gummier grades, start at 3000-3500 sfm (915-1065m/min)
Titanium	MU-23	60-100 (18-30)	.005-.008 (0.13-0.20)	35-70 (10-20)	.005-.008 (0.13-.020)	Flood coolant