

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
ALLOY STEELS								
LOW & MED CARBON		500-600 (150-185)		800-900 (245-275)	.020-.050 (0.50-1.25)	.005-.008 (.10-.20)	.006-.015 (.15-.38)	.007-.030 (.18-.75)
		400-500 (125-150)		700-800 (215-245)	.050-.100 (1.25-2.50)	.005-.008 (.10-.20)	.006-.015 (.15-.38)	.007-.030 (.18-.75)
				600-700 (185-215)	.100-.250 (2.50-6.50)			.007-.025 (.18-.65)
HIGH CARBON		400-600 (125-185)		700-800 (215-245)	.020-.050 (0.50-1.25)	.005-.008 (.10-.20)	.006-.015 (.15-.38)	.007-.030 (.18-.75)
		300-500 (90-150)		600-700 (185-215)	.050-.100 (1.25-2.50)	.005-.008 (.10-.20)	.006-.015 (.15-.38)	.007-.030 (.18-.75)
				500-600 (150-185)	.100-.250 (2.50-6.50)			.007-.025 (.18-.65)