

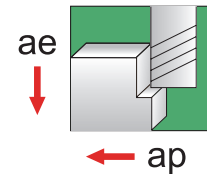
# Speed and Feed Recommendations for Diamond Coated End Mills

## Fractional

DIAMETER	RPM	CHIPLOAD PER TOOTH (Fz)
1/32" - 1/16"	15,000 - 35,000	.0005" - .0010"
1/16" - 1/8"	8000 - 31,000	.0008" - .0015"
1/8" - 3/16"	8000 - 31,000	.0010" - .0020"
3/16" - 1/4"	8000 - 25,000	.0010" - .0020"
1/4" - 5/16"	6000 - 23,000	.0020" - .0040"
5/16" - 3/8"	6000 - 20,000	.0020" - .0040"
3/8" - 1/2"	6000 - 20,000	.0030" - .0050"
1/2" - 5/8"	4500 - 15,000	.0050" - .0060"
5/8" - 3/4"	4500 - 12,000	.0060" - .0070"
3/4" - 1"	4500 - 12,000	.0070" - .0080"

Generally, tools will run at maximum RPM in relation to the corresponding parameters below:

	SLOTTING	PROFILING
Axial (ae)	0,05xD	1,0xD
Radial (ap)	1,0xD	0,1xD



## Metric

DIAMETER	RPM	CHIPLOAD PER TOOTH (Fz)
1,0 - 3,0	15,000 - 35,000	0,015 - 0,030
3,0 - 6,0	8000 - 31,000	0,030 - 0,050
6,0 - 10,0	6000 - 31,000	0,050 - 0,100
10,0 - 12,0	6000 - 25,000	0,080 - 0,130
16,0 - 20,0	4500 - 15,000	0,130 - 0,150
20,0 - 25,0	4500 - 12,000	0,150 - 0,200

**These recommendations are suggested for use primarily in graphite cutting applications. Rigid work holding, machine stability and part integrity are critical!**

**NOTE - ABOVE ARE STARTING PARAMETERS ONLY. HIGHER RESULTS MAY BE ACHIEVED WITH OPTIMUM CONDITIONS.**