



MILLING APPLICATION	3-FLUTE	4-FLUTE	5-FLUTE
PROFILE MILLING (SEMI ROUGH) (RECOMMENDED)	Radial Depth = .25 * Dia.	Radial Depth = .25 * Dia.	Radial Depth = .25 * Dia.
	Axial Depth = 1.25 * Dia.	Axial Depth = 1.25 * Dia.	Axial Depth = 1.25 * Dia.
* PROFILE MILLING (ROUGH)	Radial Depth = .5 * Dia.	Radial Depth = .5 * Dia.	SEMI ROUGHING ONLY
	Axial Depth = 1.25 * Dia.	Axial Depth = 1.25 * Dia.	SEMI ROUGHING ONLY
SLOT MILLING (ROUGH)	Radial Depth = 1 * Dia.	Radial Depth = 1 * Dia.	Radial Depth = 1 * Dia.
	Axial Depth = 1 * Dia.	Axial Depth = 1 * Dia.	Axial Depth = .25(max) * Dia.



END MILL (Whisper-Kut) SPEED & FEED RECOMMENDATIONS

Phone: 262.363.2600

Mobile: 262.470.5150

Fax: 262.378.4818

Email: pfranklin3@wi.rr.com

MATERIAL	SPEED [SFM]	END MILL DIAMETER/FEED PER TOOTH [inches]							
		1/8"	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	1"
Stainless Steels (303, 304, 316)	550	.0003	.0005	.001	.0015	.0023	.0027	.003	.0035
Stainless Steels (304L, 316L, 13-8, 15-5, 17-4)	550	.0003	.0005	.001	.0015	.0023	.0027	.003	.0035
Stainless Steels (410, 420)	350	.0003	.0005	.001	.0015	.0023	.0027	.003	.0035
Kovar, Invar	225	.0003	.0005	.001	.0015	.0023	.0027	.003	.0035
Hi Temp Alloys (718 Inco, A-286, Waspaloy)	90	.0002	.0004	.0006	.001	.0015	.002	.0025	.003
Soft Steels (1018, 1020, 1045, 1060)	600	.0004	.0006	.0015	.0025	.003	.0035	.004	.0045
Steels >35 Rc	500	.0002	.0005	.001	.002	.0025	.003	.0035	.004
Alloy Steels (4130, 4140, 4150)	450	.0002	.0005	.001	.002	.0025	.003	.0035	.004
Alloy Steels (4330, 4340)	450	.0002	.0005	.001	.002	.0025	.003	.0035	.004
Mold and Die Steels (P20, H-13)	400	.0002	.0005	.001	.002	.001	.003	.0035	.002
Tool Steels (A2, D2, S7)	350	.0002	.0005	.001	.002	.0025	.003	.0035	.004
Cast Iron (Gray)	550	.0005	.001	.0015	.002	.0025	.003	.0035	.004
Cast Iron (Ductile)	400	.0005	.001	.0015	.002	.0025	.003	.0035	.004
Titanium Alloys (6AMV)	400	.00025	.0005	.001	.0015	.002	.0025	.003	.0035

FORMULAS

Cutting Speed: SFM: Dia. x .26 x RPM

Feed Per Tooth: IPM: IPT x # of Teeth x RPM

Spindle Speed: RPM: SFM x 3.82 / Tool Dia.

Table Feed: IPT: IPM / # of Teeth / RPM

Note: The speed and feed rates shown are suggested starting parameter only and may be increased or decreased depending on factors such as material hardness, equipment and other cutting conditions.