

# M924 Application Guide – Speed & Feed (inch)

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Number of Flutes	Speed (SFM)	Feed (Inches per Tooth)											
							1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
<b>K</b>	Cast Iron Gray	Slotting	1 x D	1 x D	4	325	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0048
		Peripheral - Rough	1.25 x D	.5 x D	4	400	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0038	.0045	.0060
			Finish	1.5 x D	.015 x D	4	475	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0041	.0050
	Cast Iron Ductile	Slotting	1 x D	1 x D	4	300	.0006	.0007	.0008	.0010	.0011	.0014	.0017	.0019	.0022	.0028	.0033	.0044
		Peripheral - Rough	1.25 x D	.5 x D	4	375	.0007	.0008	.0010	.0012	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0054
			Finish	1.5 x D	.015 x D	4	450	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0038	.0045
	Cast Iron Malleable	Slotting	.75 x D	1 x D	4	250	.0006	.0007	.0008	.0010	.0011	.0014	.0017	.0019	.0022	.0028	.0033	.0044
		Peripheral - Rough	1.25 x D	.5 x D	4	325	.0007	.0008	.0010	.0012	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0054
			Finish	1.5 x D	.015 x D	4	400	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0038	.0045
<b>P</b>	Low Carbon Steels 1018, 12L14, 8620	Slotting	1 x D	1 x D	4	350	.0007	.0008	.0010	.0011	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0052
		Peripheral - Rough	1.25 x D	.5 x D	4	425	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0064
			Finish	1.5 x D	.015 x D	4	500	.0009	.0011	.0014	.0016	.0018	.0023	.0027	.0032	.0036	.0045	.0054
	Medium Carbon Steels 4140, 4340	Slotting	1 x D	1 x D	4	300	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0048
		Peripheral - Rough	1.25 x D	.5 x D	4	375	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0038	.0045	.0060
			Finish	1.5 x D	.015 x D	4	450	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0041	.0050
	Tool & Die Steels <48 Rc A2, D2, H13, P20	Slotting	.75 x D	1 x D	4	300	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0048
		Peripheral - Rough	1.25 x D	.3 x D	4	375	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0025	.0029	.0036	.0044	.0058
			Finish	1.5 x D	.015 x D	4	450	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0038	.0045
<b>M</b>	Martensitic Stainless Steels 416, 410, 440C	Slotting	.75 x D	1 x D	4	300	.0006	.0008	.0009	.0011	.0012	.0015	.0018	.0021	.0024	.0030	.0036	.0048
		Peripheral - Rough	1.25 x D	.3 x D	4	375	.0007	.0009	.0011	.0013	.0015	.0018	.0022	.0025	.0029	.0036	.0044	.0058
			Finish	1.5 x D	.015 x D	4	450	.0008	.0009	.0011	.0013	.0015	.0019	.0023	.0026	.0030	.0038	.0045
	Austenitic Stainless Steels 303, 304, 316	Slotting	.75 x D	1 x D	4	275	.0007	.0008	.0010	.0011	.0013	.0016	.0020	.0023	.0026	.0033	.0039	.0052
		Peripheral - Rough	1.25 x D	.3 x D	4	325	.0008	.0010	.0012	.0014	.0016	.0020	.0024	.0028	.0032	.0040	.0048	.0064
			Finish	1.5 x D	.015 x D	4	400	.0008	.0010	.0012	.0014	.0017	.0021	.0025	.0029	.0033	.0041	.0050
	Precipitation Hardening Stainless Steels 17-4, 15-5, 13-8	Slotting	.5 x D	1 x D	4	250	.0005	.0006	.0008	.0009	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0040
		Peripheral - Rough	1.25 x D	.3 x D	4	300	.0006	.0008	.0009	.0011	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0050
			Finish	1.5 x D	.015 x D	4	375	.0007	.0008	.0010	.0011	.0013	.0016	.0020	.0023	.0026	.0033	.0039
<b>S</b>	Titanium Alloys 6AL - 4V	Slotting	.5 x D	1 x D	4	250	.0005	.0006	.0008	.0009	.0010	.0013	.0015	.0018	.0020	.0025	.0030	.0040
		Peripheral - Rough	1.25 x D	.3 x D	4	300	.0006	.0008	.0009	.0011	.0013	.0016	.0019	.0022	.0025	.0031	.0038	.0050
			Finish	1.5 x D	.015 x D	4	375	.0007	.0008	.0010	.0011	.0013	.0016	.0020	.0023	.0026	.0033	.0039
	High Temperature Alloys Inconel, Haynes, Stellite, Hastalloy	Slotting	.25 x D	1 x D	4	60	.0005	.0007	.0008	.0009	.0011	.0013	.0016	.0018	.0021	.0026	.0032	.0042
		Peripheral - Rough	1.25 x D	.25 x D	4	90	.0007	.0008	.0010	.0012	.0014	.0017	.0020	.0024	.0027	.0034	.0041	.0054
			Finish	1.5 x D	.01 x D	4	125	.0008	.0010	.0012	.0014	.0016	.0019	.0023	.0027	.0031	.0039	.0047

D = Tool Diameter

≈ Approximately Equals < Less Than  
 ≤ Less Than or Equal To > Greater Than  
 ≥ Greater Than or Equal To = Equals  
 × Multiply

## Common Machining Formulas

$$RPM = \frac{SFM \times 3.82}{D}$$

$$SFM = RPM \times D \times .262$$

$$IPM = RPM \times IPT \times Z$$

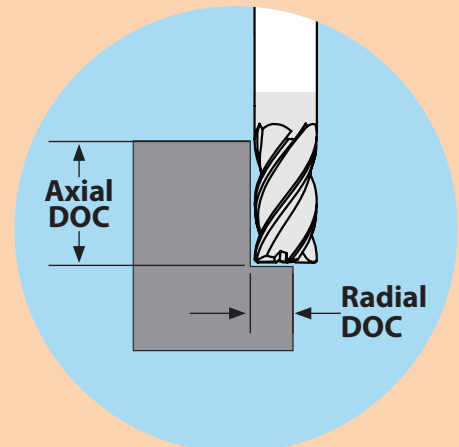
$$MRR = RDOC \times ADOC \times IPM$$

$$RPM = \frac{M/min \times 318.3}{D}$$

$$M/min = RPM \times D \times .00314$$

$$MMPM = RPM \times MMPT \times Z$$

$$MRR = RDOC \times ADOC \times MMPM$$



# M924 Application Guide – Speed & Feed (metric)

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	Number of Flutes	Speed (M/min)	Feed (MM per Tooth)										
							3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0
<b>K</b>	Cast Iron Gray	Slotting	1 x D	1 x D	4	99	.0144	.0192	.0240	.0288	.0384	.0478	.0576	.0672	.0766	.0956	.1198
		Peripheral - Rough	1.25 x D	.5 x D	4	122	.0180	.0240	.0300	.0360	.0480	.0598	.0720	.0840	.0958	.1195	.1497
			1.5 x D	.015 x D	4	145	.0198	.0264	.0330	.0396	.0528	.0657	.0792	.0924	.1053	.1315	.1647
	Cast Iron Ductile	Slotting	1 x D	1 x D	4	91	.0132	.0176	.0220	.0264	.0352	.0438	.0528	.0616	.0702	.0876	.1098
		Peripheral - Rough	1.25 x D	.5 x D	4	114	.0162	.0216	.0270	.0324	.0432	.0538	.0648	.0756	.0862	.1076	.1348
			1.5 x D	.015 x D	4	137	.0180	.0240	.0300	.0360	.0480	.0598	.0720	.0840	.0958	.1195	.1497
	Cast Iron Malleable	Slotting	.75 x D	1 x D	4	76	.0132	.0176	.0220	.0264	.0352	.0438	.0528	.0616	.0702	.0876	.1098
		Peripheral - Rough	1.25 x D	.5 x D	4	99	.0162	.0216	.0270	.0324	.0432	.0538	.0648	.0756	.0862	.1076	.1348
			1.5 x D	.015 x D	4	122	.0180	.0240	.0300	.0360	.0480	.0598	.0720	.0840	.0958	.1195	.1497
<b>P</b>	Low Carbon Steels 1018, 12L14, 8620	Slotting	1 x D	1 x D	4	107	.0156	.0208	.0260	.0312	.0416	.0518	.0624	.0728	.0830	.1036	.1298
		Peripheral - Rough	1.25 x D	.5 x D	4	130	.0192	.0256	.0320	.0384	.0512	.0637	.0768	.0896	.1021	.1275	.1597
			1.5 x D	.015 x D	4	152	.0216	.0288	.0360	.0432	.0576	.0717	.0864	.1008	.1149	.1434	.1797
	Medium Carbon Steels 4140, 4340	Slotting	1 x D	1 x D	4	91	.0144	.0192	.0240	.0288	.0384	.0478	.0576	.0672	.0766	.0956	.1198
		Peripheral - Rough	1.25 x D	.5 x D	4	114	.0180	.0240	.0300	.0360	.0480	.0598	.0720	.0840	.0958	.1195	.1497
			1.5 x D	.015 x D	4	137	.0198	.0264	.0330	.0396	.0528	.0657	.0792	.0924	.1053	.1315	.1647
	Tool & Die Steels <48 Rc A2, D2, H13, P20	Slotting	.75 x D	1 x D	4	91	.0144	.0192	.0240	.0288	.0384	.0478	.0576	.0672	.0766	.0956	.1198
		Peripheral - Rough	1.25 x D	.3 x D	4	114	.0174	.0232	.0290	.0348	.0464	.0578	.0696	.0812	.0926	.1155	.1448
			1.5 x D	.015 x D	4	137	.0180	.0240	.0300	.0360	.0480	.0598	.0720	.0840	.0958	.1195	.1497
<b>M</b>	Martensitic Stainless Steels 416, 410, 440C	Slotting	.75 x D	1 x D	4	91	.0144	.0192	.0240	.0288	.0384	.0478	.0576	.0672	.0766	.0956	.1198
		Peripheral - Rough	1.25 x D	.3 x D	4	114	.0174	.0232	.0290	.0348	.0464	.0578	.0696	.0812	.0926	.1155	.1448
			1.5 x D	.015 x D	4	137	.0180	.0240	.0300	.0360	.0480	.0598	.0720	.0840	.0958	.1195	.1497
	Austenitic Stainless Steels 303, 304, 316	Slotting	.75 x D	1 x D	4	84	.0156	.0208	.0260	.0312	.0416	.0518	.0624	.0728	.0830	.1036	.1298
		Peripheral - Rough	1.25 x D	.3 x D	4	99	.0192	.0256	.0320	.0384	.0512	.0637	.0768	.0896	.1021	.1275	.1597
			1.5 x D	.015 x D	4	122	.0198	.0264	.0330	.0396	.0528	.0657	.0792	.0924	.1053	.1315	.1647
	Precipitation Hardening Stainless Steels 17-4, 15-5, 13-8	Slotting	.5 x D	1 x D	4	76	.0120	.0160	.0200	.0240	.0320	.0398	.0480	.0560	.0638	.0797	.0998
		Peripheral - Rough	1.25 x D	.3 x D	4	91	.0150	.0200	.0250	.0300	.0400	.0498	.0600	.0700	.0798	.0996	.1248
			1.5 x D	.015 x D	4	114	.0156	.0208	.0260	.0312	.0416	.0518	.0624	.0728	.0830	.1036	.1298
<b>S</b>	Titanium Alloys 6AL-4V	Slotting	.5 x D	1 x D	4	76	.0120	.0160	.0200	.0240	.0320	.0398	.0480	.0560	.0638	.0797	.0998
		Peripheral - Rough	1.25 x D	.3 x D	4	91	.0150	.0200	.0250	.0300	.0400	.0498	.0600	.0700	.0798	.0996	.1248
			1.5 x D	.015 x D	4	114	.0156	.0208	.0260	.0312	.0416	.0518	.0624	.0728	.0830	.1036	.1298
	High Temperature Alloys Inconel, Haynes, Stellite, Hastalloy	Slotting	.25 x D	1 x D	4	18	.0126	.0168	.0210	.0252	.0336	.0418	.0504	.0588	.0670	.0837	.1048
		Peripheral - Rough	1.25 x D	.25 x D	4	27	.0162	.0216	.0270	.0324	.0432	.0538	.0648	.0756	.0862	.1076	.1348
			1.5 x D	.01 x D	4	38	.0186	.0248	.0310	.0372	.0496	.0617	.0744	.0868	.0989	.1235	.1547

D = Tool Diameter

- D** Tool Diameter
- Z** Number of Flutes
- RPM** Revolutions per Minute
- SFM** Surface Feet per Minute
- M/min** Surface Meters per Minute
- IPM** Inches per Minute
- MMPM** Millimeters per Minute
- IPT** Inch per Tooth
- MMPT** Millimeters per Tooth
- MRR** Metal Removal Rate
- RDOC** Radial Depth of Cut
- ADOC** Axial Depth of Cut

## Technical Resources

Information on tips and adjustments for the following milling operations can be found in our Technical Resources section beginning on page 125.

- HEM slotting
- Face milling
- Helical entry ramping
- Straight line ramping
- Long tool projection adjustments
- Ball nose milling adjustments
- Other helpful tips and calculations