



- List 7040:** Inch, Stub Length, 4 Flute
- List 7041:** Long Length, 4 Flute
- List 7042:** Stub Length, 4 Flute, Long Shank
- List 7072:** Inch, Stub Length, 4 Flute, Long Shank, Corner Radius
- List 7030:** Ball End, Regular Length, 4 Flute
- List 7031:** Ball End, Long Length, 4 Flute
- List 7032:** Inch, Ball End, Stub Length, 4 Flute, Long Shank
- List 7173:** Metric, Ball End, Stub Length, 4 Flute, Long Shank
- List 7132:** Metric, Stub Length, 4 Flute, Long Shank, Corner Radius
- List 7140:** Metric, Stub Length, 4 Flute

**Standard**

Work Material	Graphite		Green Ceramic Thermoset Plastic		Fiber Filler Plastics		Aluminum Alloys		Metal Matrix Composite (MMC, AISiC)		Copper Alloys																			
Cutting Speed	160-300 SFM		80-140 SFM		130-800 SFM		160-800 SFM		100-750 SFM		328-649 SFM																			
Depth of Cut	<table border="1"> <tr><th>Dia</th><th>a<sub>a</sub></th><th>a<sub>r</sub></th></tr> <tr><td>D ≤ 1/8</td><td>0.02D</td><td>0.05D</td></tr> <tr><td>D &gt; 1/8</td><td>0.10D</td><td>0.20D</td></tr> </table>			Dia	a <sub>a</sub>	a <sub>r</sub>	D ≤ 1/8	0.02D	0.05D	D > 1/8	0.10D	0.20D				<table border="1"> <tr><th>Dia</th><th>a<sub>a</sub></th><th>a<sub>r</sub></th></tr> <tr><td>D ≤ 1/8</td><td>0.5D</td><td>0.05D</td></tr> <tr><td>D &gt; 1/8</td><td>1D</td><td>0.1D</td></tr> </table>			Dia	a <sub>a</sub>	a <sub>r</sub>	D ≤ 1/8	0.5D	0.05D	D > 1/8	1D	0.1D			
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Mill Dia.	Speed RPM	Feed in/tooth	Speed RPM	Feed in/tooth	Speed RPM	Feed in/tooth	Speed RPM	Feed in/tooth	Speed RPM	Feed in/tooth	Speed RPM	Feed in/tooth																		
1/32	25,000	0.0005-0.0010	13,450	0.0005-0.0010	25,000	0.0004-0.0008	25,000	0.0004-0.0008	25,000	0.0004-0.0008	25,000	0.0004-0.0008																		
1/16	14,060	0.0010-0.0020	6,720	0.0010-0.0020	25,000	0.0010-0.0020	25,000	0.0010-0.0020	25,000	0.0010-0.0020	25,000	0.0010-0.0020																		
3/32	9,370	0.0010-0.0020	4,480	0.0010-0.0020	19,560	0.0010-0.0020	19,560	0.0010-0.0020	17,320	0.0010-0.0020	19,890	0.0010-0.0020																		
1/8	7,030	0.0010-0.0020	3,360	0.0010-0.0020	14,670	0.0010-0.0020	14,670	0.0010-0.0020	12,990	0.0010-0.0020	14,910	0.0010-0.0020																		
3/16	4,690	0.0010-0.0020	2,240	0.0010-0.0020	9,780	0.0010-0.0020	9,780	0.0010-0.0020	8,660	0.0010-0.0020	9,940	0.0010-0.0020																		
1/4	3,510	0.0020-0.0040	1,680	0.0020-0.0040	7,330	0.0015-0.0030	7,330	0.0015-0.0030	6,500	0.0015-0.0030	7,460	0.0015-0.0030																		
5/16	2,810	0.0020-0.0040	1,350	0.0020-0.0040	5,870	0.0020-0.0040	5,870	0.0020-0.0040	5,200	0.0020-0.0040	5,960	0.0020-0.0040																		
3/8	2,340	0.0030-0.0050	1,120	0.0030-0.0050	4,890	0.0030-0.0050	4,890	0.0030-0.0050	4,330	0.0030-0.0050	4,970	0.0030-0.0050																		
1/2	1,760	0.0030-0.0050	840	0.0030-0.0050	3,670	0.0030-0.0050	3,670	0.0030-0.0050	3,250	0.0030-0.0050	3,730	0.0030-0.0050																		

1. Please reduce speed and feed by 20% when L/D > 3D.
2. Please reduce speed and feed by 30% when slotting > 0.5D.
3. Please reduce depth of cut if running at elevated speed and feed.

