

SPEED & FEED GUIDE



Optimum Performance

Series 240, 243

2FLUTES CHAMFER MILLS

Material	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
		RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
P	Low Carbon Steel 1018	180	5501	5	2750	3	1834	6	1375	5	1100	6	917	5
		225	6876	8	3438	4	2292	9	1719	7	1375	9	1146	8
		270	8251	16	4126	8	2750	19	2063	14	1650	19	1375	16
	Med Alloy Steel <375, 1045, 1050	100	3056	3	1528	1	1019	3	764	2	611	3	509	3
		125	3820	4	1910	2	1273	5	955	4	764	5	637	4
		162	4966	9	2483	4	1655	11	1242	8	993	11	828	9
	Tool Steel <375, 4140, P20	155	4737	4	2368	2	1579	5	1184	4	947	5	789	4
		180	5501	6	2750	3	1834	7	1375	5	1100	7	917	6
		216	6601	11	3300	6	2200	14	1650	10	1320	14	1100	11
M	Stainless Steel 303, 304, 420	80	2445	2	1222	1	815	2	611	2	489	2	407	2
		90	2750	2	1375	1	917	3	688	2	550	3	458	2
		125	3820	6	1910	3	1273	7	955	5	764	7	637	6
	Stainless Steel 316L, 404	180	5501	4	2750	2	1834	5	1375	4	1100	5	917	4
		225	6876	6	3438	3	2292	7	1719	5	1375	7	1146	6
		270	8251	12	4126	6	2750	14	2063	10	1650	14	1375	12
K	Cast Iron- Gray <220, GG-10, G1800	140	4278	3	2139	2	1426	4	1070	3	856	4	713	4
		185	5654	6	2827	3	1885	7	1413	5	1131	7	942	6
		230	7039	11	3519	6	2346	14	1760	10	1408	14	1173	12
	Ductile Cast GGG-40	115	3514	3	1757	1	1171	3	879	2	703	3	586	3
		180	5501	5	2750	3	1834	6	1375	5	1100	6	917	5
		250	7640	12	3820	6	2547	14	1910	11	1528	14	1273	12
N	Cast Aluminum Casting	350	10696	22	5348	23	3565	26	2674	28	2139	27	1783	27
		420	12835	33	6418	34	4278	38	3209	40	2567	39	2139	39
		500	15280	73	7640	75	5093	77	3820	81	3056	78	2547	78
	Aluminum Alloy 6061, 7075	300	9168	18	4584	18	3056	22	2292	23	1834	22	1528	22
		360	11002	26	5501	27	3667	32	2750	33	2200	32	1834	32
		500	15280	59	7640	60	5093	66	3820	69	3056	67	2547	67