

SPEED & FEED GUIDE



Optimum Performance

Series 241, 244 4 FLUTES 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	10	2750	5	1834	7	1375	9	1100	11	917	12
		225	6876	16	3438	8	2292	10	1719	14	1375	16	1146	17
		270	8251	31	4126	16	2750	21	2063	28	1650	32	1375	35
	Med Alloy Steel <375, 1045, 1050	100	3056	6	1528	3	1019	4	764	5	611	6	509	6
		125	3820	8	1910	4	1273	6	955	7	764	8	637	9
		162	4966	18	2483	9	1655	12	1242	16	993	18	828	20
	Tool Steel <375, 4140, P20	155	4737	8	2368	4	1579	5	1184	7	947	8	789	9
		180	5501	11	2750	6	1834	8	1375	10	1100	11	917	13
		216	6601	23	3300	11	2200	15	1650	20	1320	23	1100	25
M	Stainless Steel 303, 304, 420	70	2139	3	1070	2	713	2	535	3	428	3	357	3
		80	2445	4	1222	2	815	3	611	4	489	4	407	5
		125	3820	11	1910	6	1273	7	955	10	764	11	637	12
	Stainless Steel 316L, 404	180	5501	88	2750	44	1834	59	1375	79	1100	89	917	98
		225	6876	12	3438	6	2292	8	1719	10	1375	12	1146	13
		270	8251	23	4126	12	2750	15	2063	21	1650	23	1375	26
K	Cast Iron- Gray <220,GG-10, G1800	140	4278	7	2139	3	1426	5	1070	6	856	7	713	8
		185	5654	11	2827	6	1885	7	1413	10	1131	11	942	12
		230	7039	23	3519	11	2346	15	1760	21	1408	23	1173	25
	Ductile Cast GGG-40	115	3514	5	1757	3	1171	4	879	5	703	5	586	6
		180	5501	10	2750	5	1834	7	1375	9	1100	10	917	11
		250	7640	24	3820	12	2547	16	1910	21	1528	24	1273	26
N	Cast Aluminum Casting	350	10696	28	5348	28	3565	33	2674	35	2139	33	1783	33
		420	12835	41	6418	42	4278	48	3209	50	2567	48	2139	48
		500	15280	92	7640	94	5093	96	3820	101	3056	97	2547	97
	Aluminum Alloy 6061, 7075	300	9168	23	4584	23	3056	28	2292	29	1834	28	1528	28
		360	11002	33	5501	34	3667	40	2750	42	2200	40	1834	40
		500	15280	73	7640	75	5093	83	3820	87	3056	83	2547	83