

Speed & Feed Guide

Series 209, 209D

GP | Chamfer Mills | 2 - 4 FL | 60° - 90°

Material		SFM	1/4 – 5/16"	3/8 – 1/2"
P	Free Machining & Low/Med/High Carbon, Tool & Die Steels	25-175	0.0010	0.0020
M	Easy/Moderate/Difficult to Machine	50-150	0.0007	0.0015
S	High Temp, Nimonics, Inconel, Monel, Hastelloy, Titanium	25-125	0.0010	0.0015
H	55 Rc	25-100	0.0010	0.0015
K	Gray, Ductile & Malleable	50-250	0.0014	0.0021
N	Aluminum	50-1000	0.0025	0.0035
	Composites	100-200	0.0060	0.0090
	Copper	400-800	0.0020	0.0030
	Magnesium	400-700	0.0025	0.0035
	Plastics	150-300	0.0030	0.0040