

Speed & Feed Guide

Series 280, 285

840 | Multi Flute | Square & Radius | Titanium

Material		Axial ↓	Radial →	SFM	1/2		5/8		3/4	
					RPM	IPM	RPM	IPM	RPM	IPM
P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	.5 x D	220	1681	32	1345	31	1121	35
		1.25 x D	.3 x D	264	2017	46	1614	45	1345	51
		1.5 X D	.1 x D	343	2622	100	2098	96	1748	110
		1.5 x D	.07 x D	378	2884	155	2307	148	1923	170
M	SS 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	.5 x D	140	1070	18	856	17	713	19
		1.25 x D	.3 x D	185	1413	28	1131	27	942	31
		1.5 x D	.1 x D	230	1760	43	1408	41	1173	47
		1.5 x D	.07 x D	276	2112	68	1689	65	1408	75
S	High Temp Alloys Ti-6Al4V Grades (5-38)	.75 x D	.5 x D	180	1375	28	1100	27	917	30
		1.25 x D	.3 x D	225	1719	42	1375	40	1146	46
		1.5 x D	.1 x D	275	2101	85	1681	81	1401	93
		1.5 x D	.07 x D	303	2311	130	1849	125	1541	144