Countersink Solid Carbide Chamfering End-Mills (MC_DA60), (MC_DA90)

MATERIAL GROUP	MATERIAL TO BE MACHINED	CUTTING SPEED m/min
P	Low & Medium Carbon Steels	120 - 240
	High Carbon Steels	80 - 180
	Alloy Steels, Treated Steels	50 - 120
M	Stainless Steel - Free Cutting	70 - 100
	Stainless Steel - Austentic	60 - 140
	Cast Steels	70 - 100
K	Cast Iron	80 - 160
N	Alluminium ≤6%, Copper	150 - 500
	Alluminium ≥6%	100 - 250
	Synthetics, Duroplastics, Thermoplastcs	80 - 200
S	Nickel Alloys, Titanium Alloys	30 - 90
H	Hardened Steel, 45-50 HRc	60 - 70
	Hardened Steel, 51-58HRc	50 - 60

d	FEED fz mm/tooth
Ø3 - Ø4	0.04 - 0.06
Ø5 - Ø6	0.05 - 0.07
Ø8	0.06 - 0.08
Ø10	0.07 - 0.10
Ø12	0.08 - 0.015

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
z	No. of teeth

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * \varnothing}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * \varnothing}{1000}$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.