

Cutting Speed and Feed Recommendations for the SD-SP T-Slot Milling Heads

| Workpiece material | | | | | Cutting speed Vc (SFM) | Feed for SP11& SP13 Fz (IPT) | Feed for SP15 Fz (IPT) | Feed for SP17 Fz (IPT) | |
|--------------------------|-------------------------|----------------------|------------------------|------------------|---------------------------|------------------------------------|------------------------------|------------------------------|-----------------|
| ISO class DIN/ISO 513 | Description | ISCAR mat. group* | Typical Representative | | | | | | Hardness, HB |
| | | | AISI/SAE/ASTM | DIN W.-Nr. | | | | | |
| P | Non-alloy steel | 1 | 1020 | 1.0402 | 130-180 | 425-655 | .0024-.0048 | .0040-.0080 | .0024-.0048 |
| | Low alloy steel | 8 | 4340 | 1.6582 | 260-300 | 395-560 | .0024-.0048 | .0040-.0080 | .0024-.0048 |
| | Low alloy steel | 9 | 3135 | 1.5710 | HRC 35-40* | 260-395 | .0012-.0024 | .0020-.0040 | .0015-.0030 |
| | High alloy steel | 10 | H13 | 1.2344 | 200-220 | 330-460 | .0012-.0030 | .0020-.0050 | .0015-.0037 |
| | Martensitic s.s. | 12 | 420 | 1.4021 | 200 | 330-460 | .0012-.0024 | .0020-.0040 | .0015-.0030 |
| M | Austenitic s.s. | 14 | 304L | 1.4306 | 200 | 260-395 | .0012-.0024 | .0020-.0040 | .0015-.0030 |
| K | Grey cast iron | 16 | Class 40 | 0.6025 (GG25) | 250 | 525-655 | .0018-.0048 | .0030-.0080 | .0022-.0060 |
| | Nodular cast iron | 17 | Class 65-45-12 | 0.7050 (GGG50) | 200 | 460-590 | .0018-.0042 | .0030-.0070 | .0022-.0052 |
| S | High temperature alloys | 34 | Inconel 718 | 2.4668 | HRC 36-40 | 65-100 | .0006-.0024 | .0010-.0040 | .0008-.0030 |
| | | 37 | AMS R56400 | 3.7165 (Ti6Al4V) | HRC 40-45 | 115-150 | .0006-.0024 | .0010-.0040 | .0008-.0030 |

* ISCAR material group in accordance with VDI 3323 standard

** Quenched and tempered