

M725/M726 Series Application Guide – Speed & Feed (inch and metric)

INCH										METRIC						
ISO Code	No. of Flutes	Type of Cut	Tool Dia.	Axial Max	Radial Max	Speed (SFM)	RPM	IPT	IPM	Tool Dia.	Axial Max	Radial Max	Speed (M/Min)	RPM	MMPT	MM/Min
H 51 HRC- 63 HRC	5	Rough	1/8	.1250	.0075	350	10,696	.00035	18.7	3.0	3.0	.18	106	11,318	.0089	5039
		Rough < 10,000		.1250	.0075	325	9,932	.00035	17.4		3.0	.18	94	9,973	.0089	443
		Finish		.2500	.001	300	9,168	.00030	13.7		6.0	.025	91	9,701	.0075	363
	5	Rough	3/16	.1875	.0130	250	5,093	.00070	17.8	4.0	4.0	.275	64	5,093	.0180	458
		Finish		.3750	.0015	300	6,112	.00040	12.2		8.0	.032	91	7,241	.0097	351
	6	Rough	1/4	.2500	.0150	400	6,112	.00100	36.6	5.0	5.0	.345	80	5,093	.0200	509
		Finish		.5000	.0020	300	4,584	.00050	13.8		10.0	.050	91	5,793	.0107	309
	6	Rough	5/16	.3125	.0220	400	4,890	.00125	36.6	6.0	6.0	.380	122	6,472	.0254	986
		Finish		.6250	.0020	300	3,667	.00060	13.2		12.0	.050	91	4,828	.0127	367
	6	Rough	3/8	.3750	.0300	400	4,074	.00150	36.6	8.0	8.0	.558	121	4,814	.0330	953
Finish		.7500		.0030	300	3,056	.00070	12.8	16.0		.050	91	3,621	.0152	330	
6	Rough	1/2	.5000	.0400	400	3,056	.00200	36.6	10.0	10.0	.800	121	3,851	.0400	924	
	Finish		.000	.0030	300	2,292	.00100	13.7		20.0	.076	91	2,897	.0200	347	
6	Rough	5/8	.6250	.0500	400	2,445	.00250	36.6	12.0	12.0	.960	121	3,210	.0480	924	
	Finish		.250	.0050	300	1,833	.00130	14.3		24.0	.076	91	2,414	.0240	347	
6	Rough	3/4	.750	.0600	400	2,037	.00300	36.6	16.0	16.0	1.270	121	2,407	.0635	917	
	Finish		1.500	.0050	300	1,528	.00150	13.7		32.0	.127	91	1,810	.0330	358	
6	Rough	1	1.000	.0800	400	1,528	.00400	36.6	20.0	20.0	1.524	121	1,926	.0760	878	
	Finish		2.000	.0080	300	1,146	.00200	13.7		40.0	.127	91	1,448	.0380	330	
K H 43 HRC- 50 HRC	5	Rough	1/8	.1250	.010	500	15,280	.0006	45.8	3.0	3.0	.254	152	16,127	.0152	1225
		Rough < 10,000		.1250	.010	325	9,932	.0006	29.8		3.0	.254	94	9,973	.0152	758
		Finish		.2500	.001	400	12,224	.0003	18.3		6.0	.025	121	12,838	.0076	487
		Finish < 10,000		.2500	.001	325	9,932	.0003	14.9		6.0	.025	94	9,973	.0076	379
	5	Rough	3/16	.1875	.015	500	10,186	.0009	45.8	4.0	4.0	.320	152	12,095	.0192	1161
		Finish		.3750	.0015	400	9,780	.0009	44.0		8.0	.025	121	9,947	.0192	954
	6	Rough	1/4	.2500	.020	500	7,640	.0012	55.0	5.0	5.0	.400	152	9,676	.0239	1156
		Finish		.5000	.003	400	6,112	.0007	25.7		10.0	.040	121	7,703	.0132	508
	6	Rough	5/16	.3125	.025	500	6,112	.0014	51.3	6.0	6.0	.480	152	8,064	.0305	1475
		Finish		.6250	.003	400	4,889	.0007	20.5		12.0	.075	121	6,419	.0170	654
6	Rough	3/8	.7500	.030	500	5,093	.0017	52.0	8.0	8.0	.640	152	6,048	.0355	1288	
	Finish		.7500	.005	400	4,074	.0010	24.4		16.0	.080	121	4,814	.0175	505	
6	Rough	1/2	.5000	.040	500	3,820	.0023	52.7	10.0	10.0	.800	152	4,838	.0453	1315	
	Finish		1.0000	.007	400	3,056	.0014	25.6		20.0	.130	121	3,851	.0266	614	
6	Rough	5/8	.6250	.050	500	3,056	.0029	53.2	12.0	12.0	.970	152	4,032	.0552	1335	
	Finish		1.2500	.008	400	2,445	.0018	26.4		24.0	.180	121	3,210	.0336	647	
6	Rough	3/4	.7500	.060	500	2,547	.0034	52.0	16.0	16.0	1.280	152	3,024	.0736	1335	
	Finish		1.5000	.009	400	2,037	.0020	24.4		32.0	.200	121	2,407	.0455	657	
6	Rough	1	1.0000	.080	500	1,910	.0046	52.7	20.0	20.0	1.600	152	2,419	.0863	1252	
	Finish		2.0000	.010	400	1,528	.0023	21.0		40.0	.230	121	1,926	.0508	587	
P M 36 HRC- 42 HRC	5	Rough	1/8	.1250	.0100	600	18,336	.0010	91.7	3.0	3.0	.240	182	19,310	.0254	2452
		Rough < 10,000		.1250	.0100	325	9,932	.0010	49.6		3.0	.240	94	9,973	.0254	1266
		Finish		.2500	.0015	450	13,752	.0005	34.4		6.0	.038	137	14,536	.0127	923
		Finish < 10,000		.2500	.0015	325	9,932	.0005	24.8		6.0	.038	94	9,973	.0127	633
	5	Rough	3/16	.1875	.0150	600	12,224	.0013	79.5	4.0	4.0	.320	182	14,483	.0280	2027
		Finish		.3750	.0020	450	9,677	.0013	63.0		8.0	.043	125	9,947	.0280	1392
	6	Rough	1/4	.2500	.0250	600	9,168	.0020	110.0	5.0	5.0	.400	182	11,586	.0345	1998
		Finish		-	-	-	-	-	-		5.0	.400	157	9,995	.0345	1724
	6	Rough	5/16	.3125	.0310	600	7,334	.0025	110.0	6.0	6.0	.600	183	9,708	.0510	2970
		Finish		.6250	.0030	500	6,112	.0013	47.6		12.0	.076	152	8,064	.0254	1228
	6	Rough	3/8	.3750	.0370	600	6,112	.0030	110.0	8.0	8.0	.800	183	7,281	.0635	2774
		Finish		.7500	.0030	500	5,093	.0015	45.8		16.0	.076	152	6,048	.0330	1197
	6	Rough	1/2	.5000	.0500	600	4,584	.0040	110.0	10.0	10.0	1.000	183	5,825	.0800	2795
		Finish		1.0000	.0050	500	3,820	.0020	45.8		20.0	.076	152	4,838	.0400	1161
	6	Rough	5/8	.6250	.0625	600	3,667	.0050	110.0	12.0	12.0	1.200	183	4,854	.0960	2795
		Finish		1.2500	.0050	500	3,056	.0025	45.8		24.0	120	152	4,032	.0480	1161
6	Rough	3/4	.7500	.0750	600	3,056	.0060	110.0	16.0	16.0	1.600	183	3,641	.1270	2774	
	Finish		1.5000	.0050	500	2,546	.0030	45.8		32.0	.127	152	3,024	.0635	1152	
6	Rough	1	1.0000	.1000	600	2,292	.0080	110.0	20.0	20.0	2.000	183	2,912	.1524	2663	
	Finish		2.0000	.0070	500	1,910	.0040	45.8		40.0	.127	152	2,419	.0762	1106	