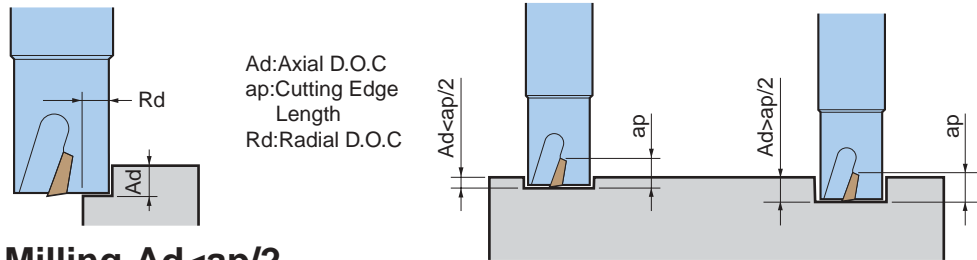


FCM Application Guide



Finish or Light Milling-Ad<ap/2

Material	Diameter D	Insert Grade	Speed SFM	Feed, IPT	
				Full Slot	Rd<1/2D
Low or Medium Carbon Steel, Unalloyed or Low Alloy Steel 1020,A36,8620,4140	.500- .625	ACZ350	300-620	.002- .004	.003- .005
	.750-1.000		300-690	.002- .005	.003- .006
	1.250-1.500		330-820	.003- .007	.004- .008
	2.000			.003- .008	.004- .010
High Carbon Steel, High Alloy Tool Steel 01,H13,D2,A2,M2,P20	.500- .625	ACZ350	300-620	.002- .004	.003- .005
	.750-1.000		300-650	.002- .005	.003- .006
	1.250-1.500		330-760	.002- .007	.003- .008
	2.000			.002- .008	.003- .009
Stainless Steel 303,304,316,420	.500- .625	ACZ350S	230-580	.003- .006	.003- .007
	.750-1.000		230-650	.004- .007	.004- .008
	1.250-1.500		330-650	.004- .008	.004- .009
	2.000				.004- .010
Cast Iron	.500- .625	ACZ310	300-580	.002- .005	.003- .006
	.750-1.000		300-620	.002- .006	.003- .007
	1.250-1.500		330-700	.003- .007	.003- .008
	2.000		330-720	.003- .008	.003- .010
Aluminum	.500- .625	DC20	660-5000	.003- .008	.004- .010
	.750-1.000			.004- .010	.004- .012
	1.250-1.500			.004- .012	.004- .014
	2.000			.004- .014	.004- .016

Medium to Heavy milling-Ad>ap/2

Material	Diameter D	Insert Grade	Speed SFM	Feed, IPT	
				Full Slot	Rd<1/2D
Low or Medium Carbon Steel, Unalloyed or Low Alloy Steel 1020,A36,8620,4140	.500- .625	ACZ350	260-590	.002- .003	.002- .004
	.750-1.000		300-620	.002- .004	.002- .005
	1.250-1.500		330-660	.003- .006	.004- .007
	2.000		330-760	.003- .008	.004- .010
High Carbon Steel, High Alloy Tool Steel 01,H13,D2,A2,M2,P20	.500- .625	ACZ350	260-580	.002- .004	.002- .005
	.750-1.000		260-620	.002- .005	.003- .006
	1.250-1.500		330-740	.002- .006	.003- .007
	2.000		330-760		.003- .008
Stainless Steel 303,304,316,420	.500- .625	ACZ350S	230-580	.003- .006	.003- .006
	.750-1.000		230-600	.004- .008	.004- .007
	1.250-1.500		330-600		.004- .008
	2.000				
Cast Iron	.500- .625	ACZ310	300-580	.002- .004	.002- .005
	.750-1.000		300-620	.002- .005	.003- .006
	1.250-1.500		330-700	.003- .007	.003- .008
	2.000		330-720	.003- .008	.003- .010
Aluminum	.500- .625	DC20	660-5000	.003- .006	.004- .008
	.750-1.000			.004- .008	.004- .010
	1.250-1.500			.004- .010	.004- .012
	2.000			.004- .012	.004- .014

*Formulas: RPM=SFmX3.82/D
 IPM=IPTxRPMxNo. of teeth