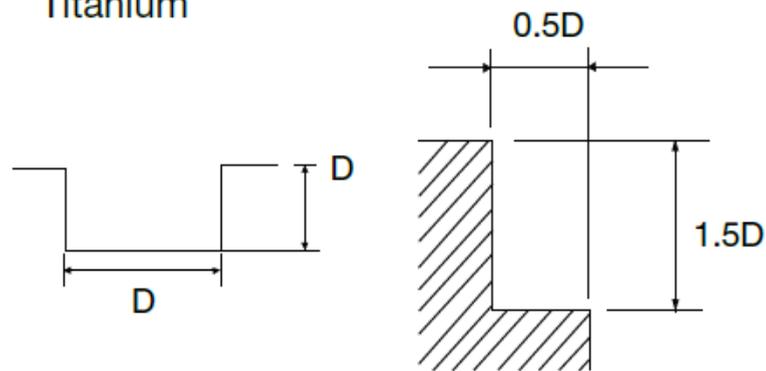


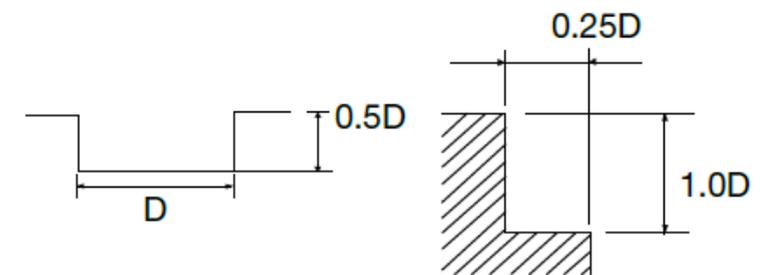
PREMIUM V-MILL SPEED & FEED CHARTS

Material Hardness	Alloy Steels Cast Iron <230 Bhn		Stainless Steels 300 Series		Stainless Steels 400 Series		Titanium		Inconel	
	Diameter	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM
3	13475	275	8700	190	10400	240	8700	190	3080	43
4	10105	330	6525	250	7800	310	6525	250	2305	56
5	8085	370	5220	305	6240	380	5220	305	1850	68
6	6735	435	4355	355	5170	440	4355	355	1540	80
8	5050	555	3265	460	3900	570	3260	455	1155	103
10	4455	690	2665	515	2880	555	2665	515	890	69
12	3710	695	2230	520	2335	544	2230	520	745	69
14	3180	620	1910	480	2000	505	1910	480	640	64
16	2785	590	1670	440	1750	460	1670	440	555	59
18	2475	585	1485	437	1555	460	1485	440	495	58
20	2225	580	1340	435	1400	455	1340	435	445	58
25	1780	450	1070	350	1120	370	1070	350	355	47

Alloy Steels, Cast Iron,
Stainless Steels 300 Series, 400 Series,
Titanium



Inconel



Tolerance

Metric		Inch	
Mill Diameter	Shank Diameter	Mill Diameter	Shank Diameter
0 ~ - 0.03	h6	0 ~ - .0012	h6