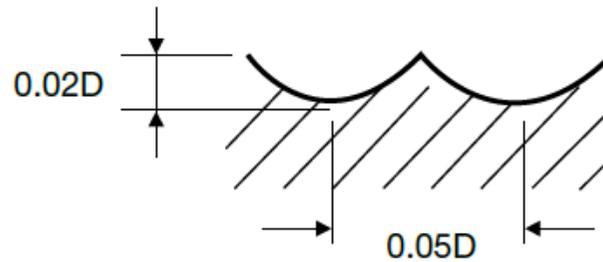


# ROYAL CARBIDE MILL SPEED & FEED CHARTS

## 2-Flute - Stub Length - Ball Nose End Mills

Material Hardness	Carbon Steels Alloy Steels Tool Steels 285-380 Bhn		Hardened Steels 380-495 Bhn		Hardened Steels 495-555 Bhn		Hardened Steels 555-625 Bhn		Hardened Steels 625-710 Bhn		Hardened Steels 285-380 Bhn	
	Diameter	RPM	IMP	RPM								
R1/64 × 1/32	50000	188.98	50000	165.35	45000	149.61	40000	118.11	35000	102.36	35000	90.55
R1/32 × 1/16	49700	224.41	47800	188.98	40000	157.48	35000	124.02	32000	110.24	28500	90.55
R3/64 × 3/32	49700	224.41	47800	188.98	40000	157.48	35000	124.02	32000	110.24	28500	90.55
R1/16 × 1/8	33100	236.22	31800	208.66	26500	157.48	23500	124.02	21000	110.24	19000	90.55
R3/32 × 3/16	18600	228.35	17800	192.91	15000	147.64	13500	120.08	11500	100.39	10500	82.68
R1/8 × 1/14	13900	190.94	13400	161.42	11000	122.05	10000	98.43	8800	84.65	8000	68.90
R5/32 × 5/16	11100	165.35	10700	137.80	9000	106.30	8000	84.65	7000	72.83	6500	61.02
R3/16 × 3/8	9300	145.67	8900	122.05	7500	94.49	6600	74.80	5800	64.96	5300	54.33
R1/4 × 1/2	6950	116.14	6680	98.43	5600	74.80	5000	61.02	4400	49.21	4000	41.34



The Feed, in long and extra long types, should be reduced by around 50%.