

1/2" Series Recommended Cutting Parameters

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Style	Edge	Grade	Coating	Speed / Feed	Low-Carbon Steel	Alloy Steel	Tool Steels	Medium Hardened Steel (36-48 Rc)	Hardened Steel (> 48 Rc)	Austenitic Stainless	Ferritic / Martensitic Stainless	Tough PH Stainless	Gray Cast Iron	Ductile / Malleable	Ni Co-Based Alloys	9 Series Inconel	Titanium	Copper Alloys	Aluminum / Non-Ferrous		
OPMH-442	D	DMK30	TCI	Speed	500-800	400-700	250-450				300-500	400-800	250-450	500-800	400-700				400-900		
				Feed	.003-.014	.003-.013	.003-.010			.003-.012	.003-.014	.003-.010	.003-.014	.003-.013						.003-.010	
			GLH	Speed	700-1000	500-900	250-550			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180			400-900	
				Feed	.003-.014	.003-.013	.003-.010			.003-.012	.003-.014	.003-.010	.003-.014	.003-.013	.002-.007	.002-.006	.003-.008			.003-.010	
			HM	Speed	700-1000	500-900	250-550			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180				
				Feed	.003-.014	.003-.013	.003-.010			.003-.012	.003-.014	.003-.010	.003-.014	.003-.013	.002-.007	.002-.006	.003-.008				
		DMK25	GLH	Speed	700-1000	500-900	250-650			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180			400-900	
				Feed	.003-.012	.003-.010	.003-.010			.003-.010	.003-.012	.003-.009	.003-.013	.003-.012	.002-.007	.002-.006	.003-.008			.003-.013	
			HM	Speed	700-1000	500-900	250-650			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180				
				Feed	.003-.012	.003-.010	.003-.010			.003-.010	.003-.012	.003-.009	.003-.013	.003-.012	.002-.007	.002-.006	.003-.008				
			DMP25	TCI	Speed	500-900	400-800	350-550	300-450						600-900	500-800					
					Feed	.003-.013	.003-.012	.003-.010	.003-.009							.003-.013	.003-.012				
	GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900							
		Feed	.003-.013	.003-.012	.003-.010	.003-.009							.003-.013	.003-.012							
	N	DMK25	GLH	Speed	700-1000	500-900	250-650						500-900	250-500	600-1000	500-900					
				Feed	.003-.012	.003-.010	.003-.010							.003-.012	.003-.009	.003-.013	.003-.012				
			TCI	Speed	500-900	400-800	350-550	300-450							600-900	500-800					
				Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015					
			GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900					
				Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015					
		HM	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900						
			Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015						
		DMP25	TCI	Speed	500-900	400-800	350-550	300-450							600-900	500-800					
				Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015					
GLH			Speed	700-1200	500-900	350-650	300-500							600-1000	500-900						
			Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015						
HM	Speed		700-1200	500-900	350-650	300-500							600-1000	500-900							
	Feed		.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015							
T	DMP25	TCI	Speed	500-900	400-800	350-550	300-450						600-900	500-800							
			Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015						
	GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900							
		Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015							
	DMK15	GLH	Speed	700-1200	500-900	350-650	300-500	250-450						700-1200	600-900						
			Feed	.004-.014	.004-.013	.004-.012	.003-.010	.003-.008							.005-.015	.005-.015					
HM	Speed	700-1200	500-900	350-650	300-500	250-450							700-1200	600-900							
	Feed	.004-.014	.004-.013	.004-.012	.003-.010	.003-.008							.005-.015	.005-.015							

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- › The parameters provided are suggested starting operating parameters.
- › See page IM-155 for insert grade and coating selection.

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Style	Edge	Grade	Coating	Speed / Feed	Low-Carbon Steel	Alloy Steel	Tool Steels	Medium Hardened Steel (36-48 Rc)	Hardened Steel (> 48 Rc)	Austenitic Stainless	Ferritic / Martensitic Stainless	Tough PH Stainless	Gray Cast Iron	Ductile / Malleable	Ni Co-Based Alloys	9 Series Inconel	Titanium	Copper Alloys	Aluminum / Non-Ferrous			
RPMH-44	D	DMK30	TCI	Speed	500-800	400-700	250-450			300-500	400-800	250-450	500-800	400-700					400-900			
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015							.004-.015	
			GLH	Speed	700-1000	500-800	250-600			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180				400-900	
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015	.002-.006	.002-.005	.003-.007				.004-.015	
			DMK25	TCI	Speed	500-900	400-800	350-550					600-900	500-800							400-900	
					Feed	.007-.020	.005-.015	.005-.012						.004-.020	.003-.015							.004-.015
		GLH	Speed	700-1200	500-900	350-650						600-1000	500-900						120-180	400-900		
			Feed	.007-.020	.005-.015	.005-.012						.004-.020	.003-.015						.003-.007	.004-.015		
		DMP25	TCI	Speed	500-900	400-800	350-550								600-900	500-800						
				Feed	.007-.020	.005-.015	.005-.012									.004-.020	.003-.015					
			GLH	Speed	700-1200	500-900	350-650									600-1000	500-900					
				Feed	.007-.020	.005-.015	.005-.012									.004-.020	.003-.015					
	HM		Speed	700-1200	500-900	350-650									600-1000	500-900						
			Feed	.007-.020	.005-.015	.005-.012									.004-.020	.003-.015						
	N	DMK30	TCI	Speed	500-800	400-700	250-600					400-800	250-450	500-800	400-700							
				Feed	.007-.020	.007-.020	.005-.015						.005-.020	.003-.012	.007-.020	.006-.020						
			GLH	Speed	700-1000	500-800	250-600						500-900	250-500	600-1000	500-900						
				Feed	.007-.020	.007-.020	.005-.015						.005-.020	.003-.012	.007-.020	.006-.020						
			HM	Speed	700-1000	500-800	250-600						500-900	250-500	600-1000	500-900						
				Feed	.007-.020	.007-.020	.005-.015						.005-.020	.003-.012	.007-.020	.006-.020						
		DMK25	GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900						
				Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020					
			DMP25	TCI	Speed	500-900	400-800	350-550	300-450							600-900	500-800					
					Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020				
GLH			Speed	700-1200	500-900	350-650	300-500								600-1000	500-900						
			Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020						
HM	Speed	700-1200	500-900	350-650	300-500								600-1000	500-900								
	Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020								
DMK15	GLH	Speed	700-1200	500-900	350-650	300-500							700-1200	600-900								
		Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.015							
T	DMK30	TCI	Speed	500-800	400-700	250-600								500-800	400-700							
			Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020						
		GLH	Speed	700-1000	500-800	250-600									600-1000	500-900						
			Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020						
		HM	Speed	700-1000	500-800	250-600									600-1000	500-900						
			Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020						
	DMP25	TCI	Speed	500-900	400-800	350-550	300-450							600-900	500-800							
			Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020						
		GLH	Speed	700-1200	500-900	350-650	300-500								600-1000	500-900						
			Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020						
		HM	Speed	700-1200	500-900	350-650	300-500								600-1000	500-900						
			Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020						
	DMK15	TCI	Speed	500-900	400-800	350-550	300-450							600-1000	600-900							
			Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020						
		GLH	Speed	700-1200	500-900	350-650	300-500	250-450							700-1200	600-900						
			Feed	.007-.020	.007-.020	.005-.015	.004-.012	.003-.012							.007-.020	.006-.020						
		HM	Speed	700-1200	500-900	350-650	300-500	250-450							700-1200	600-900						
			Feed	.007-.020	.007-.020	.005-.015	.004-.012	.003-.012							.007-.020	.006-.020						

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HIGH-FEED

SQUARE SHOULDER

BUTTON / FACE

BALL NOSE / BACK DRAFT

SUPPORTING TOOLS & INFO

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RDCH-43	D	DMK30	TCI	Speed	500-800	400-700	250-450			300-500	400-800	250-450	500-800	400-700								
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015								
			GLH	Speed	700-1000	500-800	250-600			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180	400-900	1200+ (Cast)			
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015	.002-.006	.002-.005	.003-.007	.003-.012	.007-.020			
			Uncoated	Speed																		1500+
				Feed																		.010-.020
	T	DMP25	TCI	Speed	500-900	400-800	350-550	300-450						600-900	500-800							
				Feed	.007-.020	.007-.020	.005-.015	.004-.012							.007-.020	.006-.020						
			GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900						
				Feed	.007-.020	.007-.020	.005-.015	.004-.012							.007-.020	.006-.020						

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