

10mm Series Recommended Parameters

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Style	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 Alloys / Non-Ferrous	
APET	DMP35	TCI	Speed	500-800	400-700	250-550						500-800	400-700						
			Feed	.004-.008	.004-.008	.004-.007								.004-.009	.004-.008				
		GLH	Speed	700-1000	500-800	250-550								600-1000	500-900				
			Feed	.004-.008	.004-.008	.004-.007								.004-.009	.004-.008				
		HM	Speed	700-1000	500-800	250-550								600-1000	500-900				
			Feed	.004-.008	.004-.008	.004-.007								.004-.009	.004-.008				
	DMP30	TCI	Speed	500-900	400-800	350-550	300-450						600-900	500-800					
			Feed	.004-.008	.004-.008	.004-.007	.003-.006							.004-.009	.004-.008				
		GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900				
			Feed	.004-.008	.004-.008	.004-.007	.003-.006							.004-.009	.004-.008				
		HM	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900				
			Feed	.004-.008	.004-.008	.004-.007	.003-.006							.004-.009	.004-.008				
DMK25	TCI	Speed	500-900	400-800	350-550	300-450						600-1000	600-900						
		Feed	.004-.007	.004-.007	.004-.006	.003-.006							.004-.009	.004-.008					
	GLH	Speed	700-1200	500-900	350-650	300-500	250-450						700-1200	600-900					
		Feed	.004-.007	.004-.007	.004-.006	.003-.006	.002-.005						.004-.009	.004-.008					
	HM	Speed	700-1200	500-900	350-650	300-500	250-450						700-1200	600-900					
		Feed	.004-.007	.004-.007	.004-.006	.003-.006	.002-.005						.004-.009	.004-.008					

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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	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 Alloys / Non-Ferrous		
XPET	DMP35	TCI	Speed	500-800	400-700	250-450			300-500	400-800	250-450	500-800	400-700					400-900		
			Feed	.003-.008	.003-.007	.003-.006			.003-.007	.003-.007	.002-.005	.003-.008	.003-.007						.003-.008	
		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-.008	.003-.007	.003-.006			.003-.007	.003-.007	.002-.005	.003-.008	.003-.007	.002-.005	.002-.004	.003-.006			.003-.008	
		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-.008	.003-.007	.003-.006			.003-.007	.003-.007	.002-.005	.003-.008	.003-.007	.002-.005	.002-.004	.003-.006				
	DMK30	TCI	Speed	500-900	400-800	350-550			300-500	400-800	250-450	500-900	500-800						400-900	
			Feed	.002-.007	.002-.006	.002-.005			.003-.006	.003-.006	.002-.005	.003-.007	.003-.006						.003-.007	
		GLH	Speed	700-1000	500-900	250-650			300-600	500-900	250-500	600-1000	500-900						400-900	
			Feed	.002-.007	.002-.006	.002-.005			.003-.006	.003-.006	.002-.005	.003-.007	.003-.006						.003-.007	
		HM	Speed	700-1000	500-900	250-650			300-600	500-900	250-500	600-1000	500-900							
			Feed	.002-.007	.002-.006	.002-.005			.003-.006	.003-.006	.002-.005	.003-.007	.003-.006							
	DMP30	HP	Speed	500-900	400-800	350-550	300-450						500-900	500-800						
			Feed	.003-.008	.003-.007	.003-.006	.002-.005							.003-.008	.003-.007					
		TCI	Speed	500-900	400-800	350-550	300-450							500-900	500-800					
			Feed	.003-.008	.003-.007	.003-.006	.002-.005							.003-.008	.003-.007					
		GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900					
			Feed	.003-.008	.003-.007	.003-.006	.002-.005							.003-.008	.003-.007					
		HM	HP	700-1200	500-900	350-650	300-500							600-1000	500-900					
			Feed	.003-.008	.003-.007	.003-.006	.002-.005							.003-.008	.003-.007					
	DMK25	TCI	Speed										500-900	500-800					400-900	
			Feed											.003-.008	.003-.007				.003-.007	
		GLH	Speed											600-1000	500-900				400-900	1000+ (Cast)
			Feed											.003-.008	.003-.007				.003-.007	.007-.015
HM		Speed											600-1000	500-900						
		Feed											.003-.008	.003-.007						
XPET-ALU	DMK25	GLH	Speed																1500+	
			Feed																.010-.020	
	Uncoated	Speed																	1500+	
		Feed																	.010-.020	

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