

6mm Series Recommended Parameters

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Style	Edge	Grade	Coating	Speed / Feed / DOC	Low-Carbon Steel	Alloy Steel	Tool Steels	Medium Hardened Steel (36-48 Rc)	Hardened Steel (> 44 Rc)	Austenitic Stainless	Ferritic / Martensitic Stainless	Tough PH Stainless	Gray Cast Iron	Ductile / Malleable	Ni Co-Based Alloys	9 Series Inconel	Titanium				
DTM-06	D	DMM25	UHT	Speed	550-800	400-700	400-550	300-500			300-600	400-700	250-550	500-800	500-700	50-150	35-75	120-180			
				Feed*	.020-.040	.020-.040	.020-.035	.015-.030			.010-.030	.010-.030	.010-.025	.020-.040	.020-.040	.007-.018	.007-.015	.010-.025			
				DOC	< 3xD	.015-.030	.015-.030	.015-.030	.010-.030			.010-.030	.010-.030	.010-.030	.015-.030	.015-.030	.010-.020	.010-.020	.010-.025		
					> 3xD	.010-.020	.010-.020	.010-.020	.010-.020			.010-.020	.010-.020	.010-.020	.010-.020	.010-.020	.010-.015	.010-.015	.010-.015		
				T	DMK30	GLH	Speed	550-800	400-700	400-550							500-800	500-700			
							Feed*	.020-.040	.020-.040	.020-.035								.020-.040	.020-.040		
	DOC	< 3xD	.015-.030				.015-.030	.015-.030								.015-.030	.015-.030				
		> 3xD	.010-.025				.010-.025	.010-.020								.010-.025	.010-.025				
	DMK30	HM	Speed				550-800	450-750	400-600								500-800	500-700			
			Feed*				.020-.040	.020-.040	.020-.035								.020-.040	.020-.040			
			DOC		< 3xD	.015-.030	.015-.030	.015-.030								.015-.030	.015-.030				
					> 3xD	.010-.025	.010-.025	.010-.020								.010-.025	.010-.025				
			DMP25		GLH	Speed	550-800	400-700	400-550	300-500		250-400					500-800	500-700			
						Feed*	.020-.040	.020-.040	.020-.035	.015-.030		.015-.030					.020-.040	.020-.040			
	DOC	< 3xD				.015-.030	.015-.030	.015-.030	.010-.030		.010-.020					.015-.030	.015-.030				
		> 3xD				.010-.025	.010-.025	.010-.020	.010-.020		.010-.015					.010-.025	.010-.025				
	DMP25	HM				Speed	550-800	450-750	400-600	300-500		250-400					500-800	500-700			
						Feed*	.020-.040	.020-.040	.020-.035	.015-.030		.015-.030					.020-.040	.020-.040			
			DOC		< 3xD	.015-.030	.015-.030	.015-.030	.010-.030		.010-.020					.015-.030	.015-.030				
					> 3xD	.010-.025	.010-.025	.010-.020	.010-.020		.010-.015					.010-.025	.010-.025				
			DMK15		GLH	Speed	550-800	400-700	400-550	300-500		250-400					500-800	500-700			
						Feed*	.015-.035	.015-.035	.015-.030	.015-.030		.015-.030					.020-.040	.020-.040			
	DOC	< 3xD		.015-.030		.015-.030	.015-.030	.010-.030		.010-.020					.015-.030	.015-.030					
		> 3xD		.010-.025		.010-.025	.010-.020	.010-.020		.010-.015					.010-.025	.010-.025					
DMK15	HM	Speed		550-800		450-750	400-600	300-500		250-400					500-800	500-700					
		Feed*		.015-.035		.015-.035	.015-.030	.015-.030		.015-.030					.020-.040	.020-.040					
		DOC	< 3xD	.015-.030	.015-.030	.015-.030	.010-.030		.010-.020					.015-.030	.015-.030						
			> 3xD	.010-.025	.010-.025	.010-.020	.010-.020		.010-.015					.010-.025	.010-.025						

* Feed Rate Compensation for DOC:
 DOC < .030" Feed = 100%
 DOC > .030" Feed = 75%
 Max. DOC .040" Feed = 60%

- › **Bold text** indicates best choice for material shown.
- › The parameters provided are suggested starting operating parameters.
- › See page 10 for insert grade and coating selection.

Technical Considerations

- › Always use anti-seize compound on screws.
- › Change insert screw every 10 inserts.
- › Use the shortest-length tool holder (end mill holder) for maximum rigidity; the shank of the cutting tool should be up inside the machine spindle taper whenever possible.
- › Thoroughly clean pocket and screw at each insert change.
- › Use tool holders appropriate for roughing operations: end mill holders and power chucks recommended; collets are not recommended.

Feed per Tooth & Depth of Cut Comparison

(Typical parameters for Alloyed Steel)

Ap (DOC)

