

SPEED & FEED GUIDE

Optimum Performance



Series 225, 227

General Purpose End Mills 2 FLUTES

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
P	Low Carbon Steel 1018	.5 x D	1 x D	180	5501	5	2750	3	1834	6	1375	5	1100	6	917	5
		1.25 x D	.4 x D	225	6876	8	3438	4	2292	9	1719	7	1375	9	1146	8
		1.5 X D	.1 x D	270	8251	16	4126	8	2750	19	2063	14	1650	19	1375	16
	Med Alloy Steel <375 1045, 1050	.5 x D	1 x D	100	3056	3	1528	1	1019	3	764	2	611	3	509	3
		1.25 x D	.4 x D	125	3820	4	1910	2	1273	5	955	4	764	5	637	4
		1.5 X D	.1 x D	163	4966	9	2483	4	1655	11	1242	8	993	11	828	9
	Tool Steel <375 4140, P20	.5 x D	1 x D	155	4737	4	2368	2	1579	5	1184	4	947	5	789	4
		1.25 x D	.4 x D	180	5501	6	2750	3	1834	7	1375	5	1100	7	917	6
		1.5 X D	.1 x D	216	6601	11	3300	6	2200	14	1650	10	1320	14	1100	11
M	Stainless Steel 303, 304, 420	.5 x D	1 x D	80	2445	2	1222	1	815	2	611	2	489	2	407	2
		1.25 x D	.4 x D	90	2750	2	1375	1	917	3	688	2	550	3	458	2
		1.5 X D	.1 x D	125	3820	6	1910	3	1273	7	955	5	764	7	637	6
	Stainless Steel 316L, 404	.5 x D	1 x D	180	5501	4	2750	2	1834	5	1375	4	1100	5	917	4
		1.25 x D	.4 x D	225	6876	6	3438	3	2292	7	1719	5	1375	7	1146	6
		1.5 X D	.1 x D	270	8251	12	4126	6	2750	14	2063	10	1650	14	1375	12
K	Cast Iron- Gray <220 GG-10 G1800	.5 x D	1 x D	140	4278	3	2139	2	1426	4	1070	3	856	4	713	4
		1.25 x D	.4 x D	185	5654	6	2827	3	1885	7	1413	5	1131	7	942	6
		1.5 X D	.1 x D	230	7039	11	3519	6	2346	14	1760	10	1408	14	1173	12
	Ductile Cast GGG-40	.5 x D	1 x D	115	3514	3	1757	1	1171	3	879	2	703	3	586	3
		1.25 x D	.4 x D	180	5501	5	2750	3	1834	6	1375	5	1100	6	917	5
		1.5 X D	.1 x D	250	7640	12	3820	6	2547	14	1910	11	1528	14	1273	12
N	Cast Aluminum Casting	.5 x D	.5 x D	350	10696	22	5348	23	3565	26	2674	28	2139	27	1783	27
		1.25 x D	.3 x D	420	12835	33	6418	34	4278	38	3209	40	2567	39	2139	39
		1.5 X D	.1 x D	500	15280	73	7640	75	5093	77	3820	81	3056	78	2547	78
	Aluminum Alloy 6061, 7075	.5 x D	.5 x D	300	9168	18	4584	18	3056	22	2292	23	1834	22	1528	22
		1.25 x D	.3 x D	360	11002	26	5501	27	3667	32	2750	33	2200	32	1834	32
		1.5 X D	.1 x D	500	15280	59	7640	60	5093	66	3820	69	3056	67	2547	67