

SPEED & FEED GUIDE



Optimum Performance

Series 230, 237

General Purpose End Mills 4 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	10	2750	5	1834	7	1375	9	1100	11	917	12
		1.25 x D	.4 x D	225	6876	16	3438	8	2292	10	1719	14	1375	16	1146	17
		1.5 X D	.1 x D	270	8251	31	4126	16	2750	21	2063	28	1650	32	1375	35
	Med Alloy Steel <375, 1045, 1050	.5 x D	1 x D	100	3056	6	1528	3	1019	4	764	5	611	6	509	6
		1.25 x D	.4 x D	125	3820	8	1910	4	1273	6	955	7	764	8	637	9
		1.5 X D	.1 x D	163	4966	18	2483	9	1655	12	1242	16	993	18	828	20
	Tool Steel <375,4140, P20	.5 x D	1 x D	155	4737	8	2368	4	1579	5	1184	7	947	8	789	9
		1.25 x D	.4 x D	180	5501	11	2750	6	1834	8	1375	10	1100	11	917	13
		1.5 X D	.1 x D	216	6601	23	3300	11	2200	15	1650	20	1320	23	1100	25
M	Stainless Steel 303, 304, 420	.5 x D	1 x D	70	2139	3	1070	2	713	2	535	3	428	3	357	3
		1.25 x D	.4 x D	80	2445	4	1222	2	815	3	611	4	489	4	407	5
		1.5 X D	.1 x D	125	3820	11	1910	6	1273	7	955	10	764	11	637	12
	Stainless Steel 316L, 404	.5 x D	1 x D	180	5501	88	2750	44	1834	59	1375	79	1100	89	917	98
		1.25 x D	.4 x D	225	6876	12	3438	6	2292	8	1719	10	1375	12	1146	13
		1.5 X D	.1 x D	270	8251	23	4126	12	2750	15	2063	21	1650	23	1375	26
K	Cast Iron- Gray <220 GG-10, G1800	.5 x D	1 x D	140	4278	7	2139	3	1426	5	1070	6	856	7	713	8
		1.25 x D	.4 x D	185	5654	11	2827	6	1885	7	1413	10	1131	11	942	12
		1.5 X D	.1 x D	230	7039	23	3519	11	2346	15	1760	21	1408	23	1173	25
	Ductile Cast GGG-40	.5 x D	1 x D	115	3514	5	1757	3	1171	4	879	5	703	5	586	6
		1.25 x D	.4 x D	180	5501	10	2750	5	1834	7	1375	9	1100	10	917	11
		1.5 X D	.1 x D	250	7640	24	3820	12	2547	16	1910	21	1528	24	1273	26
N	Cast Aluminum Casting	.5 x D	.5 x D	350	10696	28	5348	28	3565	33	2674	35	2139	33	1783	33
		1.25 x D	.3 x D	420	12835	41	6418	42	4278	48	3209	50	2567	48	2139	48
		1.5 X D	.1 x D	500	15280	92	7640	94	5093	96	3820	101	3056	97	2547	97
	Aluminum Alloy 6061, 7075	.5 x D	.5 x D	300	9168	23	4584	23	3056	28	2292	29	1834	28	1528	28
		1.25 x D	.3 x D	360	11002	33	5501	34	3667	40	2750	42	2200	40	1834	40
		1.5 X D	.1 x D	500	15280	73	7640	75	5093	83	3820	87	3056	83	2547	83