



## Chamfer Mills

Material Guide		HRc	SFM	FEED PER TOOTH					
				UP TO 1/8"	1/8" - 3/16"	3/16" - 1/4"	1/4" - 5/16"	5/16" - 3/8"	3/8" - 1/2"
COBALT BASE ALLOYS	Stellite, HS-21, Haynes 25/188, X-40, L-605	< 32	30 - 50	.0004	.0005	.0010	.0010	.0010	.0010
NICKEL BASE ALLOYS	Inconel-625/718, Waspalloy, Rene, Hastelloy	< 32	30 - 50	.0004	.0005	.0010	.0010	.0010	.0010
IRON BASE ALLOYS	Incoloy 800-802, Multimet N-155, Timkin 16-25-6, Carpeneter 22-b3	< 32	40 - 65	.0005	.0005	.0010	.0010	.0015	.0020
TITANIUM ALLOYS	Commercially Pure, 6AL-4V, Astm 1/2/3, 6Al-25N-4Zr-2Mo-Si		25 - 125	.0005	.0005	.0005	.0005	.0010	.0010
STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17-4, AM-350/355	< 32	40 - 125	.0005	.0005	.0010	.0010	.0010	.0020
STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 316, 304L, 316L	< 32	50 - 175	.0001	.0002	.0005	.0005	.0010	.0015
STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440	< 32	50 - 125	.0001	.0002	.0005	.0005	.0005	.0010
HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, 01	< 32	25 - 150	.0005	.0005	.0010	.0010	.0010	.0010
MEDIUM ALLOY STEELS	200, 250, 300	< 32	75 - 175	.0005	.0005	.0010	.0010	.0020	.0025
CARBON STEELS	A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310	< 32	50 - 200	.0005	.0010	.0015	.0015	.0020	.0030
DUCTILE	Ductile Cast Irons		50 - 200	.0005	.0010	.0015	.0015	.0020	.0020
CAST IRONS	Gray Cast Irons		50 - 200	.0005	.0010	.0020	.0020	.0030	.0040
ALUMINUM	2014, 2024, 6061-(T1-T6), 7075, Die Cast, Extruded		500 - 1000	.0010	.0020	.0020	.0020	.0030	.0040
MAGNESIUM			450 - 650	.0010	.0020	.0020	.0020	.0030	.0040
COPPER, COPPER ALLOYS	Yellow Brass, High Lead Brass, Red Brass		400 - 750	.0010	.0010	.0020	.0020	.0025	.0030
BRASS, BRONZE	Brass, Alum/Bronze, Low Silicon Bronze		400 - 500	.0010	.0010	.0020	.0020	.0025	.0030
PLASTICS	Acrylics, Phenolics		100 - 300	.0010	.0020	.0030	.0030	.0040	.0060
CARBON, GRAPHITES			100 - 200	.0040	.0040	.0060	.0060	.0080	.0100

THESE VALUES ARE A STARTING POINT BASED ON AN UNCOATED TOOL.  
FOR AITIN COATED TOOLS INCREASE VALUES BY UP TO +40%