HEVC-4

SPEEDS & FEEDS

4 Flute - Corner Radius - Coolant Through - Variable Pitch

HEVC-4

Material Guide		Hardness	SFM	Inches per Tooth (IPT)																			
				1/8			3/16			1/4			3/8			1/2			3/4			1		
				Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin	Slot	Rgh	Fin
Carbon Steel	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB	455	.0007	.0013	.0017	.0011	.0019	.0019	.0014	.0025	.0022	.0021	.0037	.0025	.0028	.0049	.0029	.0040	.0070	.0034	.0050	.0089	.0042
		75 - 98 HRB	445	.0005	.0009	.0014	.0008	.0014	.0016	.0010	.0018	.0018	.0016	.0027	.0021	.0020	.0036	.0025	.0029	.0051	.0029	.0037	.0065	.0036
		21 - 36 HRC	400	.0003	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0010	.0018	.0017	.0013	.0023	.0020	.0019	.0033	.0024	.0024	.0042	.0029
Low Alloy Steel	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB	390	.0005	.0008	.0014	.0007	.0012	.0015	.0009	.0016	.0017	.0013	.0024	.0020	.0017	.0031	.0023	.0025	.0044	.0027	.0032	.0056	.0033
		21 - 36 HRC	340	.0003	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0010	.0018	.0017	.0013	.0023	.0020	.0019	.0033	.0024	.0024	.0042	.0029
		36 - 50 HRC	260	.0003	.0005	.0011	.0005	.0008	.0012	.0006	.0010	.0014	.0009	.0015	.0016	.0011	.0020	.0019	.0016	.0029	.0022	.0021	.0036	.0027
		> 50 HRC	155	.0002	.0004	.0010	.0004	.0006	.0011	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0016	.0017	.0013	.0023	.0020	.0016	.0029	.0024
Tool Steel	A2, H13, L6, P20, S7	75 - 98 HRB	340	.0005	.0008	.0014	.0007	.0012	.0015	.0009	.0016	.0017	.0013	.0024	.0020	.0017	.0031	.0023	.0025	.0044	.0027	.0032	.0056	.0033
		21 - 36 HRC	250	.0004	.0006	.0012	.0005	.0009	.0013	.0007	.0013	.0015	.0011	.0019	.0017	.0014	.0025	.0020	.0020	.0035	.0024	.0025	.0045	.0029
		36 - 50 HRC	145	.0003	.0005	.0011	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0015	.0015	.0011	.0019	.0018	.0016	.0028	.0022	.0020	.0035	.0026
		> 50 HRC	85	.0002	.0004	.0010	.0003	.0006	.0011	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0016	.0016	.0013	.0022	.0019	.0016	.0029	.0023
Specialty Steel	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 75 HRB	290	.0006	.0011	.0015	.0009	.0015	.0017	.0012	.0021	.0020	.0018	.0031	.0023	.0023	.0040	.0026	.0033	.0058	.0032	.0042	.0074	.0038
		75 - 98 HRB	255	.0004	.0007	.0013	.0006	.0011	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0016	.0028	.0022	.0023	.0040	.0026	.0029	.0051	.0031
		21 - 36 HRC	175	.0004	.0007	.0012	.0006	.0010	.0013	.0007	.0013	.0015	.0011	.0019	.0018	.0014	.0025	.0021	.0020	.0036	.0025	.0026	.0046	.0030
		36 - 50 HRC	150	.0003	.0006	.0011	.0005	.0009	.0013	.0007	.0012	.0015	.0010	.0017	.0017	.0013	.0022	.0019	.0018	.0032	.0023	.0023	.0041	.0028
		> 50 HRC	55	.0002	.0004	.0009	.0003	.0005	.0010	.0004	.0007	.0011	.0006	.0010	.0013	.0008	.0014	.0015	.0011	.0020	.0018	.0014	.0025	.0022
Austenitic Stainless Steel	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	75 - 98 HRB	265	.0004	.0008	.0013	.0007	.0012	.0015	.0009	.0016	.0017	.0013	.0023	.0019	.0017	.0030	.0023	.0024	.0043	.0027	.0031	.0055	.0033
		21 - 36 HRC	225	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0018	.0015	.0027	.0021	.0022	.0039	.0026	.0028	.0049	.0031
		36 - 50 HRC	180	.0003	.0006	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0040	.0028
Martensitic & Ferritic Stainless Steel	403, 410, 416, 420, 440, 430, 446	75 - 98 HRB	300	.0005	.0008	.0013	.0007	.0012	.0015	.0009	.0016	.0017	.0013	.0024	.0020	.0018	.0031	.0023	.0025	.0044	.0027	.0032	.0057	.0033
		21 - 36 HRC	280	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0018	.0015	.0027	.0021	.0022	.0039	.0025	.0028	.0049	.0031
PH Stainless Steel	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC	200	.0003	.0006	.0011	.0005	.0009	.0013	.0007	.0012	.0015	.0010	.0017	.0017	.0013	.0023	.0020	.0018	.0033	.0023	.0024	.0041	.0028
		36 - 50 HRC	145	.0003	.0005	.0011	.0004	.0008	.0012	.0006	.0010	.0014	.0009	.0015	.0016	.0011	.0020	.0018	.0016	.0028	.0022	.0020	.0036	.0027
Gray Cast Iron	SAE J431, ASTM A48	75 - 98 HRB	410	.0007	.0013	.0017	.0011	.0019	.0019	.0015	.0026	.0022	.0022	.0038	.0025	.0028	.0050	.0029	.0041	.0072	.0035	.0052	.0091	.0043
		21 - 36 HRC	370	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0018	.0015	.0027	.0022	.0022	.0039	.0026	.0028	.0050	.0031
Malleable Cast Iron	ASTM A47, ASTM A220, ASTM A602	75 - 98 HRB	345	.0005	.0008	.0014	.0007	.0012	.0015	.0009	.0016	.0017	.0014	.0024	.0020	.0018	.0032	.0023	.0026	.0045	.0028	.0033	.0058	.0034
		21 - 36 HRC	335	.0004	.0007	.0013	.0006	.0010	.0014	.0008	.0014	.0016	.0012	.0021	.0019	.0016	.0027	.0022	.0022	.0039	.0026	.0028	.0050	.0031
Nodular (Ductile) Cast Iron	ASTM A536, ASTM 897	75 - 98 HRB	310	.0005	.0009	.0014	.0007	.0013	.0015	.0010	.0017	.0018	.0014	.0025	.0020	.0019	.0033	.0024	.0027	.0047	.0028	.0034	.0060	.0034
		21 - 36 HRC	260	.0003	.0006	.0011	.0005	.0008	.0013	.0006	.0011	.0014	.0010	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0023	.0040	.0028
		36 - 50 HRC	135	.0002	.0004	.0009	.0003	.0005	.0010	.0004	.0007	.0011	.0006	.0011	.0013	.0008	.0014	.0015	.0011	.0020	.0018	.0014	.0025	.0022
Pure Nickel	Nickel 200, Nickel 201	< 75 HRB	285	.0006	.0011	.0016	.0009	.0016	.0018	.0012	.0022	.0020	.0018	.0032	.0023	.0024	.0042	.0027	.0035	.0061	.0032	.0044	.0077	.0039
		75 - 98 HRB	250	.0005	.0009	.0014	.0008	.0014	.0016	.0010	.0018	.0018	.0015	.0027	.0021	.0020	.0036	.0025	.0029	.0051	.0029	.0037	.0065	.0036
Nickel Alloy	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB	80	.0003	.0006	.0011	.0005	.0008	.0013	.0006	.0011	.0014	.0009	.0017	.0017	.0012	.0022	.0019	.0018	.0031	.0023	.0022	.0039	.0028
		21 - 36 HRC	75	.0003	.0005	.0011	.0005	.0008	.0012	.0006	.0011	.0014	.0009	.0016	.0016	.0012	.0021	.0019	.0017	.0030	.0023	.0021	.0038	.0027
		36 - 50 HRC	70	.0003	.0005	.0010	.0004	.0007	.0011	.0005	.0009	.0013	.0008	.0014	.0015	.0010	.0018	.0017	.0014	.0025	.0021	.0018	.0032	.0025
Pure Titanium	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0009	.0015	.0019	.0013	.0022	.0021	.0017	.0030	.0024	.0025	.0045	.0027	.0033	.0059	.0032	.0048	.0084	.0038	.0061	.0107	.0046
		75 - 98 HRB	275	.0007	.0013	.0017	.0011	.0019	.0019	.0014	.0025	.0022	.0021	.0038	.0025	.0028	.0049	.0029	.0040	.0070	.0035	.0051	.0090	.0042
		21 - 36 HRC	250	.0006	.0010	.0015	.0008	.0014	.0017	.0011	.0019	.0019	.0016	.0028	.0022	.0021	.0037	.0025	.0030	.0053	.0030	.0038	.0067	.0036
Titanium Alloy	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	180	.0004	.0008	.0013	.0006	.0011	.0015	.0009	.0015	.0017	.0013	.0022	.0019	.0016	.0029	.0022	.0024	.0042	.0027	.0030	.0053	.0032
		36 - 50 HRC	160	.0004	.0007	.0012	.0006	.0010	.0014	.0008	.0014	.0016	.0011	.0020	.0018	.0015	.0026	.0021	.0022	.0038	.0025	.0027	.0048	.0031
Cobalt Alloy	ASTM F562, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB	210	.0004	.0006	.0012	.0006	.0009	.0014	.0007	.0013	.0015	.0011	.0019	.0018	.0014	.0025	.0021	.0020	.0035	.0024	.0025	.0045	.0030
		21 - 36 HRC	170	.0004	.0006	.0012	.0005	.0009	.0013	.0007	.0012	.0015	.0010	.0018	.0017	.0013	.0024	.0020	.0019	.0034	.0024	.0025	.0043	.0029
		36 - 50 HRC	65	.0002	.0004	.0010	.0004	.0006	.0011	.0005	.0008	.0012	.0007	.0012	.0014	.0009	.0016	.0017	.0013	.0023	.0020	.0017	.0029	.0024

Milling Process	Hardness	ADOC	RDOC
Slot (Full Slotting)	< 35 HRC	75%-125% Diameter	100% Diameter
	≥ 35 HRC	60%-100% Diameter	100% Diameter
Rgh (Traditional Roughing)	< 35 HRC	Up to Max LOC	30%-40% Diameter
	≥ 35 HRC	Up to Max LOC	25%-35% Diameter
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.