



## SPEEDS & FEEDS

### 6 Flute - For High Efficiency Milling

HVTI-6																	
Material Guide		Hardness	SFM	Inches Per Tooth (IPT)													
				1/8		3/16		1/4		3/8		1/2		3/4		1	
				HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0019	.0014	.0029	.0017	.0038	.0020	.0058	.0023	.0079	.0027	.0118	.0032	.0159	.0039
		75 - 98 HRB	250	.0016	.0012	.0024	.0015	.0032	.0018	.0049	.0021	.0066	.0025	.0099	.0029	.0134	.0036
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB	80	.0010	.0010	.0014	.0012	.0019	.0014	.0029	.0016	.0041	.0019	.0060	.0023	.0081	.0028
		21 - 36 HRC	75	.0010	.0010	.0014	.0012	.0019	.0014	.0028	.0016	.0039	.0019	.0058	.0022	.0077	.0027
		36 - 50 HRC	70	.0008	.0009	.0012	.0011	.0016	.0013	.0024	.0015	.0034	.0017	.0049	.0021	.0066	.0025
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0026	.0015	.0039	.0019	.0052	.0023	.0079	.0027	.0110	.0032	.0164	.0038	.0220	.0046
		75 - 98 HRB	275	.0022	.0013	.0033	.0017	.0044	.0021	.0066	.0025	.0091	.0029	.0137	.0034	.0183	.0042
		21 - 36 HRC	250	.0017	.0015	.0025	.0017	.0033	.0019	.0050	.0021	.0069	.0025	.0102	.0030	.0137	.0036
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	180	.0014	.0010	.0020	.0013	.0027	.0016	.0041	.0019	.0054	.0022	.0081	.0026	.0108	.0032
		36 - 50 HRC	160	.0012	.0012	.0018	.0014	.0024	.0016	.0036	.0018	.0049	.0021	.0074	.0025	.0099	.0030
COBALT ALLOY	ASTM F562, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB	210	.0011	.0011	.0017	.0013	.0022	.0015	.0034	.0017	.0046	.0020	.0069	.0024	.0092	.0029
		21 - 36 HRC	170	.0011	.0011	.0016	.0013	.0021	.0015	.0032	.0017	.0044	.0020	.0067	.0024	.0088	.0029
		36 - 50 HRC	65	.0007	.0008	.0011	.0010	.0014	.0012	.0023	.0014	.0030	.0016	.0046	.0019	.0060	.0024

Milling Process	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Fin (Finishing)	Up to Max LOC	4%-6% Diameter