

## **SPEEDS & FEEDS**



HSF-7

## 7 Flute - Finisher

HSF-7																	
Inches Per Tooth (IPT)																	
Material Guide		Hardness	SFM	1/8		3/16		1/4		3/8		1/2		3/4		1	
				Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin	Rgh	Fin
CARBON STEEL	10XX, 11XX, 12XX, 12LXX, ASTM A27, ASTM A36	< 75 HRB 75 - 98 HRB 21 - 36 HRC	455 445 400	.0017 .0013 .0008	.0019 .0016 .0013	.0026 .0019 .0013	.0022 .0018 .0015	.0034 .0025 .0016	.0024 .0021 .0017	.0052 .0038 .0024	.0028 .0024 .0019	.0067 .0049 .0031	.0033 .0028 .0022	.0097 .0071 .0046	.0039 .0033 .0027	.0123 .0090 .0058	.0047 .0040 .0033
LOW ALLOY STEEL	13XX, 41XX, 43XX, 51XX, 86XX, 93XX	75 - 98 HRB 21 - 36 HRC 36 - 50 HRC	390 340 260	.0011 .0008 .0007	.0015 .0013 .0012	.0017 .0012 .0011	.0017 .0014 .0014	.0022 .0016 .0014	.0019 .0017 .0016	.0033 .0024 .0021	.0022 .0019 .0018	.0042 .0031 .0027	.0026 .0023 .0021	.0061 .0046 .0040	.0031 .0027 .0025	.0078 .0058 .0051	.0038 .0033 .0030
TOOL STEEL	A2, H13, L6, P20, S7	> 50 HRC 75 - 98 HRB 21 - 36 HRC 36 - 50 HRC > 50 HRC	155 340 250 145 85	.0006 .0011 .0009 .0007 .0006	.0011 .0015 .0014 .0012 .0011	.0009 .0017 .0013 .0010	.0012 .0017 .0015 .0013	.0011 .0022 .0017 .0014	.0014 .0019 .0017 .0015	.0017 .0033 .0026 .0020	.0016 .0022 .0020 .0017	.0022 .0042 .0033 .0026	.0019 .0026 .0023 .0020	.0032 .0061 .0049 .0038	.0022 .0031 .0028 .0024	.0040 .0078 .0062 .0049	.0027 .0038 .0034 .0029 .0027
SPECIALTY STEEL	300M, Invar 36, Kovar, Maraging 200, Maraging 250, Maraging 300, Maraging 350	< 75 HRB 75 - 98 HRB 21 - 36 HRC 36 - 50 HRC > 50 HRC	290 255 175 150 55	.0014 .0010 .0009 .0008	.0017 .0014 .0014 .0013	.0022 .0015 .0013 .0012	.0012 .0020 .0016 .0015 .0014	.0028 .0019 .0018 .0016	.0022 .0018 .0018 .0017	.0043 .0029 .0026 .0024	.0026 .0021 .0020 .0019	.0022 .0055 .0038 .0034 .0031 .0019	.0030 .0025 .0023 .0022 .0017	.0080 .0055 .0049 .0044 .0027	.0022 .0035 .0029 .0028 .0026	.0102 .0070 .0063 .0056 .0035	.0043 .0036 .0034 .0032
AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	75 - 98 HRB 21 - 36 HRC 36 - 50 HRC	265 225 180	.0003 .0011 .0010 .0008	.0010 .0015 .0014 .0013	.0016 .0015 .0012	.0017 .0016 .0014	.0010 .0021 .0019 .0015	.0019 .0018 .0016	.0032 .0029 .0023	.0013 .0022 .0021 .0019	.0019 .0041 .0037 .0030	.0026 .0024 .0022	.0060 .0054 .0043	.0021 .0031 .0029 .0026	.0035 .0076 .0069 .0055	.0025 .0037 .0035 .0032
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 98 HRB 21 - 36 HRC	300 280	.0011 .0010	.0015 .0014	.0017 .0015	.0017 .0016	.0022 .0019	.0019 .0018	.0033 .0029	.0022 .0021	.0042 .0037	.0026 .0024	.0061 .0053	.0031 .0029	.0078 .0068	.0038 .0035
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC 36 - 50 HRC	200 145	.0008	.0013 .0012	.0012 .0011	.0014 .0014	.0016 .0014	.0017 .0016	.0024 .0021	.0019 .0018	.0031 .0027	.0022 .0021	.0045 .0039	.0026 .0025	.0057 .0050	.0032 .0030
GRAY CAST IRON	SAE J431, ASTM A48	75 - 98 HRB 21 - 36 HRC	410 370	.0018 .0010	.0019 .0014	.0027 .0015	.0022 .0016	.0035 .0019	.0024 .0018	.0053 .0029	.0028 .0021	.0068 .0037	.0033 .0025	.0099 .0054	.0039 .0029	.0127 .0069	.0048 .0035
MALLEABLE CAST IRON	ASTM A47, ASTM A220, ASTM A602	75 - 98 HRB 21 - 36 HRC	345 335	.0011	.0015 .0014	.0017 .0015	.0017 .0016	.0022	.0020 .0018	.0034	.0023 .0021	.0043	.0026 .0025	.0063 .0054	.0031	.0080	.0038
NODULAR (DUCTILE) CAST IRON	ASTM A536, ASTM 897	75 - 98 HRB 21 - 36 HRC 36 - 50 HRC	310 260 135	.0012 .0008 .0005	.0016 .0013 .0010	.0018 .0012 .0008	.0017 .0014 .0011	.0023 .0015 .0010	.0020 .0016 .0013	.0035 .0023 .0015	.0023 .0019 .0015	.0045 .0030 .0019	.0027 .0022 .0017	.0065 .0043 .0028	.0032 .0026 .0021	.0083 .0055 .0035	.0039 .0032 .0025
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB 75 - 98 HRB	285 250	.0015 .0013	.0018 .0016	.0023 .0019	.0020 .0018	.0030 .0025	.0023 .0021	.0045 .0038	.0026 .0024	.0058 .0048	.0030 .0028	.0084 .0071	.0036 .0033	.0107 .0090	.0044 .0040
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB 21 - 36 HRC 36 - 50 HRC	80 75 70	.0008 .0007 .0006	.0013 .0012 .0011	.0012 .0011 .0009	.0014 .0014 .0013	.0015 .0015 .0013	.0016 .0016 .0015	.0023 .0022 .0019	.0019 .0018 .0017	.0029 .0028 .0024	.0022 .0021 .0020	.0043 .0041 .0035	.0026 .0025 .0023	.0055 .0052 .0045	.0031 .0031 .0028
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB 75 - 98 HRB 21 - 36 HRC	300 275 250	.0021 .0018 .0013	.0021 .0019 .0017	.0032 .0027 .0020	.0024 .0022 .0019	.0041 .0035 .0026	.0027 .0024 .0021	.0062 .0052 .0039	.0031 .0028 .0024	.0080 .0067 .0050	.0036 .0033 .0028	.0116 .0097 .0073	.0043 .0039 .0034	.0148 .0124 .0093	.0052 .0048 .0041
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC 36 - 50 HRC	180 160	.0010 .0010	.0015 .0014	.0016 .0014	.0017 .0016	.0020 .0019	.0019 .0018	.0031 .0028	.0022 .0021	.0040 .0036	.0025 .0024	.0058 .0053	.0030 .0029	.0073 .0067	.0037 .0035
COBALT ALLOY	ASTM F562, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB 21 - 36 HRC 36 - 50 HRC	210 170 65	.0009 .0009 .0006	.0013 .0013 .0011	.0013 .0013 .0009	.0015 .0015 .0012	.0017 .0017 .0011	.0017 .0017 .0014	.0026 .0025 .0017	.0020 .0019 .0016	.0033 .0033 .0022	.0023 .0023 .0019	.0049 .0047 .0032	.0028 .0027 .0023	.0062 .0060 .0041	.0034 .0033 .0027

Milling Process	Hardness	ADOC	RDOC			
Rgh (Traditional Roughing)	< 35 HRC	Up to Max LOC	10%-15% Diameter			
Rgii (Traditional Roughing)	≥ 35 HRC	Up to Max LOC	10%-15% Diameter			
Fin (Finishing)	N/A	Up to Max LOC	4%-6% Diameter			

NOTES:

Hardness Scales: HRB = Rockwell B HRC = Rockwell C

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.