

NXG-4 Series End Mills - Speeds & Feeds

Square, Corner Radius, Ball, Corner Break Series

CONVENTIONAL MILLING																
MATERIAL	SIDE MILLING		SLOTTING	SFM		IPT										
	ADOC	RDOC	ADOC	MIN	MAX	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	1-1/4	
P	Carbon Steel	1.5 x D	0.5 x D	1.25 x D	441	561	0.0010	0.0015	0.0020	0.0026	0.0030	0.0037	0.0043	0.0048	0.0054	0.0054
	Alloyed Steel	1.5 x D	0.5 x D	1.25 x D	351	442	0.0008	0.0012	0.0017	0.0021	0.0025	0.0032	0.0038	0.0042	0.0050	0.0053
	Tool Steel	1.5 x D	0.5 x D	1.25 x D	270	417	0.0007	0.0011	0.0015	0.0019	0.0022	0.0028	0.0033	0.0037	0.0042	0.0044
M	Austenitic	1.5 x D	0.5 x D	1.25 x D	270	323	0.0008	0.0012	0.0017	0.0021	0.0025	0.0032	0.0038	0.0042	0.0050	0.0053
	Martensitic, Ferritic	1.5 x D	0.5 x D	1.25 x D	180	221	0.0007	0.0010	0.0014	0.0017	0.0020	0.0025	0.0030	0.0034	0.0040	0.0043
	PH Stainless	1.5 x D	0.5 x D	1.00 x D	180	196	0.0006	0.0008	0.0011	0.0014	0.0017	0.0021	0.0025	0.0027	0.0031	0.0032
K	Gray Cast	1.5 x D	0.5 x D	1.00 x D	351	417	0.0010	0.0015	0.0020	0.0026	0.0030	0.0037	0.0043	0.0048	0.0054	0.0054
	Nodular	1.5 x D	0.5 x D	1.00 x D	324	391	0.0008	0.0012	0.0017	0.0021	0.0025	0.0032	0.0038	0.0042	0.0050	0.0053
	Ductile	1.5 x D	0.5 x D	1.00 x D	324	366	0.0007	0.0010	0.0014	0.0017	0.0020	0.0025	0.0030	0.0034	0.0040	0.0043
S	Co, Fe Alloys	1.5 x D	0.3 x D	0.75 x D	144	221	0.0007	0.0010	0.0014	0.0017	0.0020	0.0025	0.0030	0.0034	0.0040	0.0043
	Ni-Based Alloys	1.5 x D	0.5 x D	0.50 x D	72	111	0.0004	0.0007	0.0009	0.0011	0.0013	0.0017	0.0020	0.0023	0.0027	0.0029
	Titanium Alloys	1.5 x D	0.5 x D	1.25 x D	144	170	0.0005	0.0008	0.0012	0.0016	0.0019	0.0023	0.0028	0.0031	0.0036	0.0039
H	45 - 50 HRC	1.5 x D	0.5 x D	0.3 x D	234	391	0.0007	0.0011	0.0015	0.0019	0.0022	0.0028	0.0033	0.0037	0.0042	0.0044
	> 50 HRC	1.5 x D	0.2 x D	0.05 x D	207	332	0.0006	0.0008	0.0011	0.0014	0.0017	0.0021	0.0025	0.0027	0.0031	0.0032

- All posted speed and feed parameters are suggested starting values that may be increased or decreased
- For slotting (B), reduce IPT by 20%
- For tools >3D reach, reduce feed rate by 20-30%
- For corner break end mills, increase IPT by 15%