

Speed and Feed Chart • Negative Inserts • Inch

DIN ISO 513	VDI 3323	A Finishing (doc x feed = .0394 x .0039)			B Medium (doc x feed = .0787 x .0079)			C Roughing (d.o.c. x feed = .1575 x .0098)			D Heavy roughing (d.o.c. x feed = .2362 x .0236)					
Material Group		min	Start	max	min	Start	max	min	Start	max	min	Start	max			
P	Geometry	FF • ML			ML • UR • MR			ML • UR • MR			UR • MR • RH					
	DOC [in]	.0079-.0787			.0315-.1969			.0315-.1969			.0394-.3150					
	f [in]	.0020-.0079			.0663-.0157			.0663-.0157			.0079-.0236					
		WP15CT			WP15CT			WP25CT			WP15CT					
	1	1115	1605	1935	915	1310	1570	820	1180	1410	655	950	1145	590	850	1015
	2	1115	1570	1900	850	1210	1440	785	1115	1345	620	885	1045	425	620	750
	3	950	1375	1640	590	850	1015	555	785	950	520	750	915	425	590	720
	4	850	1210	1440	620	885	1045	590	820	980	425	620	750	360	490	590
	5	655	915	1115	455	655	785	425	620	750	295	425	520	245	360	425
	6	885	1275	1540	655	950	1145	620	885	1045	455	655	785	360	520	620
	7	850	1210	1440	620	885	1045	590	820	980	425	620	750	360	490	590
	8	720	1045	1245	520	750	915	490	685	820	360	490	590	275	390	455
	9	655	915	1115	455	655	785	425	620	750	295	425	520	245	360	425
	10	885	1275	1540	655	950	1145	620	885	1045	455	655	785	360	520	620
11	655	915	1115	425	620	750	390	555	655	295	425	520	245	360	425	
12	490	720	850	455	655	785	425	590	720	390	555	655	360	520	620	
13.1	425	620	750	390	555	655	360	490	590	325	455	555	295	425	520	
13.2	210	310	375	195	275	325	180	245	295	160	225	275	145	210	260	
M	Geometry	FF • UF • FW • UM			FF • UM • MW • .NMP			FF • UM • MW • .NMP			UM • .NMP • UR • RH					
	DOC [in]	.0079-.0787			.0236-.1969			.0236-.1969			.0197-.2362					
	f [in]	.0020-.0079			.0047-.0157			.0047-.0157			.0039-.0236					
		WM15CT			WM15CT			WM25CT			WM25CT					
	14.1	590	820	980	490	720	850	455	620	750	455	655	785	360	490	590
14.2	455	655	785	425	590	720	360	520	620	360	520	620	275	390	455	
14.3	360	490	590	325	455	555	275	390	455	275	390	455	210	295	360	
14.4	295	425	520	245	360	425	225	310	360	225	325	390	180	260	310	
K	Geometry	FF • FW			MW • .NMA • ML			MW • .NMA • ML			UR • .NMA • RH					
	DOC [in]	.0079-.0787			.0394-.3150			.0394-.3150			.0394-.3150					
	f [in]	.0020-.0079			.0079-.0236			.0079-.0236			.0047-.0236					
		WK05CT / WK20CT / WS10PT			WK05CT / WK20CT / WS10PT			WK05CT / WK20CT			WK05CT / WK20CT					
	15	950	1345	1605	750	1080	1310	-	-	-	590	850	1015	-	-	-
	16	750	1080	1310	590	820	980	-	-	-	455	655	785	-	-	-
	17	820	1180	1410	685	980	1180	-	-	-	590	820	980	-	-	-
18	785	1115	1345	620	885	1045	-	-	-	490	685	820	-	-	-	
19	1115	1605	1935	950	1345	1605	-	-	-	785	1115	1345	-	-	-	
20	950	1345	1605	750	1080	1310	-	-	-	590	850	1015	-	-	-	
S	Geometry	.NMP			.NMP • UM			.NMP • UM			.NMP • UR					
	DOC [in]	.0197-.0394			.0197-.0394			.0197-.0394			.0197-.2362					
	f [in]	.0039-.1969			.0039-.1969			.0039-.1969			.0039-.0236					
		WS10PT / WS25PT			WS10PT / WS25PT / WM25CT			WM25CT			WM25CT					
	21	180	260	310	150	210	260	-	-	-	135	195	225	-	-	-
	22	150	210	260	110	160	195	-	-	-	110	160	195	-	-	-
	23	110	155	195	90	130	155	-	-	-	80	115	140	-	-	-
	24	65	95	115	50	75	90	-	-	-	50	75	85	-	-	-
	25	70	100	120	55	80	95	-	-	-	55	75	95	-	-	-
	26	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
27	135	195	225	110	160	195	-	-	-	100	145	180	-	-	-	

INDEXABLE MILLING
SOLID END MILLING
HOLEMAKING
TAPPING
TURNING

Speed and Feed Chart • Positive Inserts • Inch

DIN ISO 513	VDI 3323	A Finishing (doc x feed = .0394 x .0039)			B Medium (doc x feed = .0787 x .0079)			C Roughing (doc x feed = .1575 x .0098)								
Material Group	Geometry DOC [in] f [in]	min	Start	max	min	Start	max	min	Start	max	min	Start	max	min	Start	max
				FP			FP • MP			FP • MP			MP			MP
		.0079-.0787			.0118-.1775			.0118-.1775			.0276-.1969			.0276-.1969		
		.0020-.0079			.0315-.1378			.0315-.1378			.0047-.0157			.0047-.0157		
P		WP15CT			WP15CT			WP15CT / WP25CT			WP25CT			WP35CT		
	1	1115	1605	1935	915	1310	1570	820	1180	1410	655	950	1145	590	850	1015
	2	1115	1570	1900	850	1210	1440	785	1115	1345	620	885	1045	425	620	750
	3	950	1375	1640	590	850	1015	555	785	950	520	750	915	425	590	720
	4	850	1210	1440	620	885	1045	590	820	980	425	620	750	360	490	590
	5	655	915	1115	455	655	785	425	620	750	295	425	520	245	360	425
	6	885	1275	1540	655	950	1145	620	885	1045	455	655	785	360	520	620
	7	850	1210	1440	620	885	1045	590	820	980	425	620	750	360	490	590
	8	720	1045	1245	520	750	915	490	685	820	360	490	590	275	390	455
	9	655	915	1115	455	655	785	425	620	750	295	425	520	245	360	425
	10	885	1275	1540	655	950	1145	620	885	1045	455	655	785	360	520	620
	11	655	915	1115	425	620	750	390	555	655	295	425	520	245	360	425
	12	490	720	850	455	655	785	425	590	720	390	555	655	360	520	620
13.1	425	620	750	390	555	655	360	490	590	325	455	555	295	425	520	
13.2	210	310	375	195	275	325	180	245	295	160	225	275	145	210	260	
M		FP			FP • MP			FP • MP			MP			MP		
		.0079-.0787			.0118-.1772			.0118-.1772			.0118-.1772			.0118-.1772		
		.0020-.0079			.0032-.1378			.0032-.1378			.0032-.1378			.0032-.1378		
		WM15CT			WM15CT			WM25CT			WM25CT			WM35CT		
	14.1	590	820	980	490	720	850	455	620	750	455	655	785	360	490	590
14.2	455	655	785	425	590	720	360	520	620	360	520	620	275	390	455	
14.3	360	490	590	325	455	555	275	390	455	275	390	455	210	295	360	
14.4	295	425	520	245	360	425	225	310	360	225	325	390	180	260	310	
K		FP			FP • MP • CMW			FP • MP • CMW			MP • CMW			MP • CMW		
		.0079-.0787			.0118-.1772			.0118-.1772			.0394-.3150			.0394-.3150		
		.0020-.0079			.0032-.1378			.0032-.1378			.0039-.0197			.0039-.0197		
		WK05CT / WK20CT			WK05CT / WK20CT			WK20CT			WK20CT			WK20CT		
	15	950	1345	1605	750	1080	1310	-	-	-	590	850	1015	-	-	-
	16	750	1080	1310	590	820	980	-	-	-	455	655	785	-	-	-
	17	820	1180	1410	685	980	1180	-	-	-	590	820	980	-	-	-
18	785	1115	1345	620	885	1045	-	-	-	490	685	820	-	-	-	
19	1115	1605	1935	950	1345	1605	-	-	-	785	1115	1345	-	-	-	
20	950	1345	1605	750	1080	1310	-	-	-	590	850	1015	-	-	-	

INDEXABLE MILLING

SOLID END MILLING

HOLEMAKING

TAPPING

TURNING