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Speed and feed data for carbide end mill

Feed data for tungsten carbide coated end mill

Work piece	Cast iron,nodular cast iron		Carbon steel,alloy steel ~750N/mm ²		Carbon steel,alloy steel ~30HRC		Pre-hardened steel,quenched and tempered steel ~40HRC		Stainless steel		Pre-hardened steel,quenched and tempered steel ~50HRC		Aluminum alloy	
Flute	2	4	2	4	2	4	2	4	2	4	2	4	2	3
Diameter (mm)	Feed speed (mm/min)		Feed speed (mm/min)		Feed speed (mm/min)		Feed speed (mm/min)		Feed speed (mm/min)		Feed speed (mm/min)		Feed speed (mm/min)	
1	165	250	165	250	135	200	135	200	50	90	100	150	650	800
2	265	400	265	400	240	360	235	350	70	100	150	225	950	1200
3	455	680	455	680	420	630	350	525	100	120	275	410	1500	1800
4	465	700	465	700	430	640	355	535	110	125	280	420	1600	2000
5	485	730	485	730	450	670	370	560	115	125	295	440	1500	1750
6	500	750	500	750	460	690	385	575	115	135	300	450	1250	1500
8	495	740	495	740	455	680	380	565	115	135	305	460	1400	1650
10	485	730	485	730	450	670	370	560	115	135	290	435	1600	1900
12	485	730	485	730	450	670	370	560	115	135	290	435	1650	1950
14	455	680	455	680	420	630	350	525	110	125	275	410	1700	2000
16	455	680	455	680	420	630	350	525	100	120	275	410	1700	2000
18	445	670	445	670	410	620	345	515	100	105	270	405	1700	2000
20	445	670	445	670	410	620	345	515	100	105	270	405	1700	2000

Cutting speed for tungsten carbide end mill

Work piece	Cast iron,nodular cast iron	Carbon steel,alloy steel ~750N/mm ²	Carbon steel,alloy steel ~30HRC	Pre-hardened steel,quenched and tempered steel ~40HRC	Stainless steel	Pre-hardened steel,quenched and tempered steel ~50HRC	Aluminum alloy
Cutting speed (m/min)	130	130	120	100	70	80	250