

Series SM3F & SR3F

Cutting Parameters

Suggested Starting Speeds & Feed Rates

Material Group	ISO Code	Material Examples	Finishing Cuts		Medium Cuts		Heavy Cuts		Slotting		Facing		Ramping	
			.1D Radial x 2D Axial		.25D Radial x 1.5D Axial		.5D Radial x 1.5D Axial		.5D Axial		.75D Radial x .25D Axial		Max. Ramp Angle - 10°	
			SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM
Stainless Steel	M	303,304, 316	450	40.00	450	35.00	450	30.00	450	25.00	400	35.00	400	30.00
		410, 420, 440, 13-8, 15-5, 17-4 Ph	350	35.00	350	30.00	350	25.00	350	20.00	300	30.00	300	25.00
Non-Ferrous	N	Aluminum	1000	100.00	800	80.00	700	70.00	600	60.00	600	60.00	600	50.00
		Copper, Brass, Bronze, Plastics, Fibreglass	500	45.00	450	40.00	400	35.00	400	25.00	400	35.00	450	30.00

Recommended Chip Loads

Material Group	ISO Code	Material Examples	Cutting Diameter						
			3/16	1/4	3/8	1/2	5/8	3/4	1
Stainless Steel	M	303,304, 316	0.0012	0.0016	0.0023	0.0032	0.0042	0.0053	0.0065
		410, 420, 440, 13-8, 15-5, 17-4 Ph	0.0012	0.0016	0.0023	0.0032	0.0042	0.0053	0.0065
Non-Ferrous	N	Aluminum, Copper, Brass, Bronze	0.0016	0.0021	0.0032	0.0043	0.0055	0.0065	0.0085
		Plastics, Fibreglass	0.0015	0.0019	0.0029	0.0038	0.0048	0.0058	0.0078